Chemcraft International, Inc.

Product Information

Plasticolor® 900 White–117-10XX

PRODUCT DESCRIPTION

117-1020	Low Gloss
117-1035	Satin Gloss
117-1050	Semi Gloss
117-1090	Full Gloss

Plasticolor® 900 White is an acid curing, light stable, fast drying Reactive Amino Coating (RAC) with good building properties. This is a fast building product due to its high solid content (54% volume). Plasticolor® 900 White is a low producing VOC product with 3.32 lb/gal.

FEATURES

Plasticolor® 900 White gives a smooth, knock-proof and hardwearing surface resisting influence from alcohol, water, etc. It is used as the final coat over wood, plywood, chipboard, etc., meant for interior use. This product is recommended for kitchen cabinets, high build office or residential furniture as well as many other interior wood applications where high build and durability are required. Plasticolor® 900 White has very good light stability based on the type of resin used.

Special Recognition: When applied as specified will meet required performance for the ANSI/KCMA A161.1 1990 9.0 Finish tests. Recommended: American Woodworking Institute (AWI) O.P.4.

Note: Plasticolor® 900 White must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. Plasticolor® 900 White must not be used and dried at temperatures below 64°F or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

SPECIFICATION VALUES

Gloss:	As required
Flash Point:	12°C (53°F)
Specific Gravity:	1.17
Weight per Gallon:	9.70
Solids by Weight:	65%
Solids by Volume:	54%
Fire Hazard Class:	3
Health Hazard Class:	2
Viscosity at 25°C (77°F):	20" z#4
VOC:	400 g/l (3.32 lb/gal)
Lbs. VOC/Gallon:	3.32 lb/gal
Lbs. VOC/Lbs. Solids:	0.55
Lbs. VHAPs/Lbs. Solids:	0.27

Values at Application if Catalyzed:

Lbs. VOC/Lbs. Solids:	0.66
Lbs. VHAPs/Lbs. Solids:	0.27

If additional reducers or additives are used, compliance values must be recalculated.

SPECIFICATION INFORMATION

Shelf Life: Twelve months recommended if unopened and stored between 15°C - 25°C (59°F - 77°F). Always rotate stock.

Pot Life: Mix only enough for one days use for optimum product performance. Use of material that has been catalyzed for more than 12 hours may cause failure in film integrity.

Coverage: Coverage is 866 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Mixing Ratio: 10 parts volume by Plasticolor® 900 White 117-10XX: 1 part by volume of Catalyst 873-0870.

Reduction: Use Reducer 803-1325. Up to 25% by volume of reducer may be used to obtain desired viscosity. Use Chemcraft® Retarder 800-5328 to slow the cure and keep the film open longer.

Plasticolor® 900 White 117-10XX

DIRECTIONS FOR USE

Surface Preparation: Primer should be sanded using 240 and 320 grit stearated paper. Suitable primers are Reslack Primer 740-200 or Plastiprimer 900 MDF 522-1410. Primers should be topcoated within eight hours of sanding. Care should be taken during sanding to avoid sanding through the primer.

Directions for Use: Catalyze and reduce the material as recommended. Plasticolor® 900 White is applied in one or two coats and can be used both as a primer and enamel on all kinds of wood meant for interior use. A premium system is however, obtained through priming with Plastiprimer 900 MDF 522-1410.

A thorough sanding between the coats is essential to the adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded. Plasticolor® 900 White cannot be used on metal, old oil or cellulose lacquers.

Total recommended film build of Plastiprimer 900 MDF 522-1410 and Plasticolor 900 White 117-10XX is not to exceed 6 mils dry. Over the primer, the topcoat should not exceed 4 mils dry.

To ensure proper sheen, the catalyzed material should be agitated at all times. Plasticolor® 900 White must be thoroughly stirred, while adding catalyst and thinner in the recommended mixing ratio. Contact with metal surfaces should be avoided once the Plasticolor® 900 White has been catalyzed.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this technical data sheet will likely result in unsatisfactory film appearance or film failure. The completed coating system should be checked for required properties prior to start-up of production.

APPLICATION

Method of Application:		**Viscosity**	**Wet Film**	**Dry Film**
Spray -	Conventional	Z #2/22-25"	5 mils	1.6-2.0 mils
-	Airless	Z #2/18-26"	5 mils	1.6-2.0 mils
-	HVLP	Z #2/17-20"	5 mils	1.6-2.0 mils
-	Air Assist Airless	Z #2/18-22”	5 mils	1.6-2.0 mils

All measurements recommended are based on results at temperatures of 68°F. Viscosity will vary depending on the temperature of the liquid.

Drying Times:

At 68ºF	(Minimum Required)	At 122ºF	(Minimum Required)
Tack Free:	15-20 minutes	Tack Free:	Flash off before entering oven
Dry to Sand:	3 hours	Dry to Sand:	1 hour
Dry to Stack:	Overnight	Dry to Stack:	3 hours

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

Clean-Up: Use 803-1298.

Chemcraft International Inc. views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Revised: October 18, 2002