Chemcraft
A Great Finish is Only the Beginning

AkzoNobel

117-19XX Plasticolor 275 White Post-Cat Pigmented TC

Product codes:	117-1920 Low Gloss 117-1940 Satin	**Viscosity**	Zahn #2 signature cup 15 sec at 77°F
		Flash Point:	-4°F (-20°C)
		Density (lb/gal):	9.1
		Solid (% by weight):	54%
		Solid (% by volume):	39%
		Shelf Life (months):	12

Product Description:
Plasticolor 275 White is a two-component high solids post-catalyzed Reactive Amino Coating (RAC) topcoat. This product has been formulated to meet 275 g/l VOC regulations. Plasticolor 275 White gives a smooth, tough and hardwearing surface resisting influence from alcohol, water, etc. Plasticolor 275 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 2000 9.0 Finish tests. Recommended: Architectural Woodwork Institute, (8th Ed) - Conversion Varnish Opaque

Uses:
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.

Environmental Data (as supplied):	**VOC less exempt lb/gal:**	<2.10
	VOC lb/gal:	<0.85
	VOC less exempt g/l:	
	VOC g/l:	
	VOC lb/lb Solid:	<0.20
	VHAPs lb/lb Solid:	<0.01

Note:
See individual compliance sheets for specific data

Application Data	**Suggested Uses:**	Wood Finish
	Mixing Ratio:	100 parts 117-19XX to 5 parts 873-1900
	Suggested Uses:	8 hours
	Application Viscosity:	Zahn #2 signature cup 14 – 15 seconds
	Reducer:	800-5500
	Retarder:	800-5328
	Clean-up Solvent:	800-5500
	Recommended Wet Film:	3 – 5 mils
	Coverage:	N/A

Note:
N/A

Directions for use:

Surface Preparation:
Primer should be sanded using 240 and 320 grit stearated paper. A suitable primer is **catalyzed** Versaprime® 275 545-5120. Primers should be topcoated within eight hours of sanding. Care should be taken during sanding to avoid sanding through the primer. Substrate should be sanded using 120, 150 or 180 grit stearated paper prior to coating. Plasticolor 275 White cannot be used on metal, old oil or cellulose lacquers.

General Information:
Agitate material before use. Catalyze and reduce the material as recommended. Always mix Plasticolor 275 White while adding hardener and reducers in the recommended mixing ratios. Plasticolor 275 White must be agitated thoroughly at all times to ensure product consistency and gloss.
Apply at 3-5 mils wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit stearated paper. 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.
Maximum film build of Plasticolor 275 White should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 6 mils dry. Contact with metal surfaces should be avoided.
Plasticolor 275 White must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats.
Plasticolor 275 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.
Please note that, as with any other acid catalyzed product, this material contains, and has the potential to emit, formaldehyde (CAS# 50-00-0). As per the US Department of Labor Standard 29 CFR 1910.1048 covering formaldehyde, section (d)(1)(i) states that “Each employer who has a workplace covered by this standard shall monitor employees to determine their exposure to formaldehyde.” Please refer to the OSHA web site at www.osha.gov for further information.
THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION

Drying Times:

	Room Temperature (20°C / 68°F)	Forced Drying Schedule (50°C / 122°F)
Tack Free Time:	15 – 20 minutes	Flash off before entering oven
Dry to Sand:	3 hours	Overnight
Dry to Stack:	30 minutes	60 - 90 minutes

Note:
N/A

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.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

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Updated: 2024-05-19 01:00:26