

#### 421-6301 Chemlife® 24 HS Sealer

<b>Product codes:</b>	421-6301	<b>Viscosity</b>	Zahn #2 signature cup 28 - 32 seconds at 77° F
		<b>Flash Point:</b>	-4° F (-20° C)
		<b>Density (lb/gal):</b>	7.92
		<b>Solid (% by weight):</b>	40.21
		<b>Solid (% by volume):</b>	31.79
		<b>Shelf Life (months):</b>	12

#### Product Description:

High solids Post-Catalyzed sealer with exceptional vertical hang and sanding properties, specifically designed for the Chemlife 24 product line.

#### Uses:

Chemlife 24 HS Sealer can be used in the following interior applications:

Cabinetry  
Furniture  
Millwork  
Recreational  
Building Products

#### Environmental Data (as supplied):

<b>VOC less exempt lb/gal:</b>	<4.8
<b>VOC lb/gal:</b>	5.0
<b>VOC less exempt g/l:</b>	
<b>VOC g/l:</b>	
<b>VOC lb/lb Solid:</b>	<1.5
<b>VHAPs lb/lb Solid:</b>	<0.36

#### Note:

Please refer to Material Safety Data Sheet

#### Application Data

<b>Suggested Uses:</b>	Wood - Various Species
<b>Mixing Ratio:</b>	100 parts 421-6301 to 10 parts 873-1251
<b>Suggested Uses:</b>	24 hours (catalyzed)
<b>Application Viscosity:</b>	Zahn #2 signature cup 28 - 32 seconds
<b>Reducer:</b>	803-1325 5 - 10% as needed
<b>Retarder:</b>	800-5328 (2 - 3% maximum)
<b>Clean-up Solvent:</b>	Acetone
<b>Recommended Wet Film:</b>	3.5 - 4.5 mils
<b>Coverage:</b>	Theoretical coverage - 509.93 (sq. ft/dry mil @ 100% transfer efficiency)

#### Note:

Thinner reduction ratio: 5-10% as needed depending on equipment

Directions for use:

Surface Preparation:

Substrate must be sanded using 120 or 150 grit stearted paper prior to staining or coating. Sealers should be sanded with 240, 280 and 320 grit stearted paper prior to being coated. The substrate as well as the sealers should be topcoated within eight hours of being sanded. Chemlife 24 cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. AkzoNobel recommends using 825-90XX, 825-91XX Promatch® C-Mix Stains or 890-85XX Promatch® Dye Stains.

General Information:

Catalyze and reduce the material as recommended. Chemlife 24 is applied in one to three coats on all kinds of wood meant for indoor use. Thorough sanding between the coats is a must for good adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Contact with metal surfaces should be avoided once the Chemlife 24 has been catalyzed.

This product can be used as a sealer under Chemlife 24 Topcoat 421-63XX. Consult with your coatings supplier for specific recommendations.

Chemlife 24 demonstrates excellent resistance to marring, dry heat, moisture, household and office liquids, etc.

Total recommended film build of the Chemlife 24 system should not exceed 4 mils dry.

Chemlife 24 must not be polluted with oil and must not be sanded with steel wool between coats.

Chemlife 24 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.

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 minutes	Flash off before entering oven
Dry to Sand:	1 hour	Overnight
Dry to Stack:	30 minutes	3 hours

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.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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