

**436-48XX ora Verde® Chiaro PU Clear TC**

<b>Product codes:</b>	436-4810 Matte	<b>Viscosity</b>	Zahn #2 signature cup 30 sec at 77°F
	436-4820 Low Gloss	<b>Flash Point:</b>	25° F
	436-4830 Low Gloss	<b>Density (lb/gal):</b>	7.74
	436-4870 Gloss	<b>Solid (% by weight):</b>	24.2%
		<b>Solid (% by volume):</b>	18.2%
		<b>Shelf Life (months):</b>	12

**Product Description:**

Chiaro Clear TC is a universal topcoat formulated as ultra clear polyurethane. Chiaro is a highly versatile polyurethane coating with excellent physical properties and chemical resistance. Extremely durable with a great finish feel. Chiaro has a superior tolerance to impact resistance.

**Uses:**

Great choice for surfaces that require extra chemical resistance. Uses include interior marine, cabinetry, store fixture, and musical instruments.

**Environmental Data (as supplied):**

<b>VOC less exempt lb/gal:</b>	<5.9
<b>VOC lb/gal:</b>	<5.9
<b>VOC less exempt g/l:</b>	
<b>VOC g/l:</b>	
<b>VOC lb/lb Solid:</b>	<3.2
<b>VHAPs lb/lb Solid:</b>	<0.77

**Note:**  
N/A

**Application Data**

<b>Suggested Uses:</b>	Wood Finish
<b>Mixing Ratio:</b>	100 Parts 436-48XX with 50 Parts 876-9068 (by volume)
<b>Suggested Uses:</b>	3-4 Hours depending on temperature and humidity.
<b>Application Viscosity:</b>	Zahn #2 signature cup 22 seconds
<b>Reducer:</b>	Fast 803-1410, Medium 803-1409, or slow 803-1408 if needed
<b>Retarder:</b>	800-5328 3-5% by volume
<b>Clean-up Solvent:</b>	800-5500 Acetone
<b>Recommended Wet Film:</b>	3 to 5 wet mils
<b>Coverage:</b>	N/A

**Note:**

**MAXIMUM DRY FILM THICKNESS OF THE SYSTEM MUST NOT EXCEED 6.0 DRY MILS**

**Directions for use:**

**Surface Preparation:**

Substrate must be sanded using 120, 150 or 180 grit paper prior to staining or coating. Sealer should be sanded with 280/320 grit paper prior to being coated. The sealer should be coated within eight hours of being sanded. Appropriate sealer is the ora Verde Chiaro 436-2305, 436-2310 or 436-2320. When recoating, the previous coat of Chiaro must be sanded and the next coat applied within eight hours. Stain systems used under Chiaro are formulated to develop excellent grain definition. AkzoNobel recommends using Promatch® W/B Monocolor Spray Stains 824-50XX, Promatch Aqua Stains 824-51XX, Promatch Dye Stains 890-85XX or Promatch C-Mix Wipe Stains 825-90XX, 825-91XX.

**General Information:**

The mixed product contains 876-9068, an isocyanate based co-reactant. Please follow all precautions associated with handling and use of those materials. Refer to MSDS for detail information.

Oil stains must be avoided because they will interfere with the adhesion. When coating exotic woods (Teak, Rosewood, etc.) a barrier coat (tie-coat) should be applied before the sealer or base coat. See Product data sheet for 401-033 Isolante.

Product must be thoroughly stirred before adding the hardener in the recommended ratio. The viscosity of the product should be monitored after mixing with the hardener.

The relative humidity in the application and drying room should not exceed 75% for maximum coating performance.

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:**

	<b>Room Temperature (20°C / 68°F)</b>	<b>Forced Drying Schedule (50°C / 122°F)</b>
<b>Tack Free Time:</b>	15 minutes	15 minutes
<b>Dry to Sand:</b>	3 hours	24 hours
<b>Dry to Stack:</b>	15 minutes	15 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.

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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