

Product Code:

Gloss	White	Black
10	330-110	330-316
20	330-318	330-320
50	330-245	330-234
Full	330-175	330-239

VISCOSITY:	Zahn #2 35" at 25°C
FLASH POINT:	-4°C (29°F)
DENSITY (Kg/L):	0.95-1.05
SOLID (% by weight):	30-35%
SOLID (% by volume):	20-25%
SHELF LIFE (months):	12

Product Description:

These are ready-to-use, nitrocellulose lacquer enamels. They are single pack, fast drying by solvent evaporation, conventional lacquer topcoats. Consideration should be given to a non-yellowing, clear topcoat when using this product.

Uses:

Chemlack may be used for antique lacquer finishes, edge lacquers or solid painted finishes.

Environmental Data (as supplied):

VOC less exempt lb/gal:	5.4-5.7
VOC lb/gal:	5.4-5.7
VOC less exempt g/l:	600-700
VOC g/l:	600-700
VOC lb/lb Solid:	2.3
VHAPs lb/lb Solid:	1.1

See individual compliance sheets for specific data

Application Data:

SUGGESTED USES:	Pigmented Lacquer Topcoat
MIXING RATIO:	NA
POT LIFE:	NA
APPLICATION VISCOSITY:	Z #2 20-25"
REDUCER:	Lacquer Thinner
RETARDER:	121-014
CLEAN-UP SOLVENT:	Lacquer Thinner
APPLIED FILM THICKNESS:	3-5 wet mils



AkzoNobel

Directions for Use

Chemlack
330-0XX

Surface Preparation:

Substrate to be coated should be sanded with 120,150 or 180 grit sandpaper prior to coating. It is recommended to sand primers prior to finishing to ensure good adhesion and appearance. The recommended primer for this product is 545-5510 Chemprime.

General information:

Mix carefully before use. The build should be kept below 4 mils dry. This product is designed for conventional cold spray and should be reduced with 121-001 if the product is not at spray viscosity. It is also used for airless spraying.

Chemlack colours are to be applied in one (cross) coat. At very high air humidity, the lacquer surface can appear whitish due to quick evaporation. This phenomenon can be redressed by adding 3-5% retarder.

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:

	At 20°C (Minimum Required)	At 50°C (Minimum Required)
Tack Free Time:	20 mins.	Flash off before entering oven
Dry to Sand:	2 hours	20-30 mins.
Dry to Stack:	3 hours	1 hour

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.

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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