

## 431-57XX Opticlear 275 Pre-Cat Clear TC

<b>Product codes:</b>	431-5710 Flat	<b>Viscosity</b>	Zahn #2 signature cup 20 sec at 77°F
	431-5720 Low Gloss	<b>Flash Point:</b>	-4° F (-20°C)
	431-5740 Satin	<b>Density (lb/gal):</b>	4.65
		<b>Solid (% by weight):</b>	23.5%
		<b>Solid (% by volume):</b>	22.3%
		<b>Shelf Life (months):</b>	3

### Product Description:

Opticlear 275 is a one-component pre-catalyzed lacquer. This product has been formulated to meet 275 g/l VOC regulations. Opticlear 275 demonstrates very good moisture, household chemical and mar resistance. Opticlear 275 is supplied at a ready to spray viscosity. This coating will dry quickly and sand easily. Opticlear 275 may be catalyzed to further enhance its durability.

Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.

Recommended: Architectural Woodwork Institute Pre-Catalyzed Lacquer System (8th Ed).

### Uses:

Opticlear 275 is recommended for office and household furniture, kitchen cabinets, as well as many other interior wood applications.

<b>Environmental Data (as supplied):</b>	<b>VOC less exempt lb/gal:</b>	<2.29
	<b>VOC lb/gal:</b>	<0.60
	<b>VOC less exempt g/l:</b>	
	<b>VOC g/l:</b>	
	<b>VOC lb/lb Solid:</b>	<0.30
	<b>VHAPs lb/lb Solid:</b>	<0.10

### Note:

N/A

<b>Application Data</b>	<b>Suggested Uses:</b>	Wood Finish
	<b>Mixing Ratio:</b>	100 parts 431-57XX to 1 part 873-1900 (when catalyzed)
	<b>Suggested Uses:</b>	8 hours (when catalyzed)
	<b>Application Viscosity:</b>	Zahn #2 signature cup 18 – 20 seconds
	<b>Reducer:</b>	803-1348
	<b>Retarder:</b>	800-5915
	<b>Clean-up Solvent:</b>	800-5500
	<b>Recommended Wet Film:</b>	3 – 5 mils
	<b>Coverage:</b>	Coverage is 276 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

<b>Note:</b> N/A
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**Directions for use:****Surface Preparation:**

Substrate must be sanded using 120, 150 or 180 grit steared paper prior to staining or coating. Sealers, if used, should be sanded prior to being coated with 280/320 grit steared paper. The sealer should be topcoated within eight hours of being sanded. Appropriate sealers are Chemcraft pre-catalyzed sealers, or self-seal. When recoating, the previous coat of Opticlear 275 must be sanded and the next coat applied within eight hours. Opticlear 275 cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. AkzoNobel recommends using Chemcraft Intermix 825-39XX series stains or 824-29XX series waterborne stains.

**General Information:**

Agitate material before use. Opticlear 275 must be agitated thoroughly at all times to ensure product consistency and consistent gloss. Always mix Opticlear 275 while adding hardener and reducers in the recommended mixing ratios.

Apply at 3-5 mils wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit steared paper. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Maximum film build of Opticlear 275 should not exceed 3 mils dry. Maximum film build of total coating system must not exceed 3mils dry. Contact with metal surfaces should be avoided.

Please note that, as with any other pre-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](http://www.osha.gov) for further information.

Opticlear 275 must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. Opticlear 275 must not be used and dried at temperatures below 64°F or relative humidity above 65%. During hardening 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:**

	<b>Room Temperature (20°C / 68°F)</b>	<b>Forced Drying Schedule (50°C / 122°F)</b>
<b>Tack Free Time:</b>	20 minutes	Flash off before entering oven
<b>Dry to Sand:</b>	1 - 1.5 hours	2 - 3 hours
<b>Dry to Stack:</b>	30 - 45 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.

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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