

Product Information

Lustrate Clear 436-1399

PRODUCT DESCRIPTION

Lustrate is a two-component polyurethane enamel with a tough cross-linked film. The coating is very resistant to scratching and household chemicals when cured, and can provide exceptional gloss and clarity.

SPECIFICATION VALUES

Gloss:	High
Flash Point:	24°C (75°F)
Specific Gravity:	1.0
Weight per Gallon:	8.6 lbs
Solids by Weight:	56%
Solids by Volume:	50%
Fire Hazard Class:	3
Health Hazard Class:	2
Viscosity at 25°C(77°F):	45" Z#2
VOC:	450g/l
Lbs. VOC/Gallon:	3.75 lb/gal
Lbs. VOC/Lb. Solid:	0.77
Lbs. VHAPs/Lb. Solid:	0.44
Values at Application: (100% Hardener)	
Lbs. VOC/Lb. Solid:	1.38
Lbs. VHAPs/Lb. Solid:	0.54
If additional reducers or additives are used, compliance values must be recalculated.	

FEATURES

SPECIFICATION INFORMATION

Shelf Life: Twelve months recommended if unopened and stored between 15°C - 25°C (59°F-77°F). Always rotate stock.

Pot Life: Four to six hours depending upon conditions. Pot life is decreased when product is hot or under pressure. It is recommended NOT to mix more than enough for one hour of use. Viscosity should be monitored after mixing with hardener.

Coverage: Coverage is 14 sq m/L (560 sq.ft./G) at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Mixing Ratio: 1 part 436-1399; 1 part 876-9081 by volume.

Reduction: If desired, 100-120, 100-122 or 100-137 may be used. When applied during warm temperatures and high humidity (>65%), 5-10% 100-137 should be used to avoid film imperfections.

DIRECTIONS FOR USE

Surface Preparation: Primer should be well sanded using 240, 320 and 360 grit steared paper. Suitable primers are polyurethane (283-XXX) or polyester (458-XXXX) types. Care should be taken during sanding to avoid sanding through the primer.

Directions for Use: Mix the desired amount of material and apply 4-5 mils wet. The "out-of-gun" surface is very glossy and must be applied under dust-free conditions. The coating when cured is very suitable to be buffed and polished where dust-free conditions are not available.

The relative humidity in the application and drying rooms should never exceed 75%. Viscosity on the mixed material should be monitored regularly to maintain a consistent appearance.

The mixed product contains 876-9081, an isocyanate based co-reactant. Please follow all precautions associated with handling and use of these materials.

Total recommended film thickness of Lustrate is not to exceed 6 mils dry.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this technical data sheet will likely result in unsatisfactory film appearance or film failure.

The completed coating system should be checked for required properties prior to start-up of production.

APPLICATION

Method of Application:	Viscosity	Wet Film	Dry Film
Spray - Conventional	Z #2/18-21"	4-5 mils	1.5-2.0 mils
- Airless	Z #2/18-21"	4-5 mils	1.5-2.0 mils
- HVLP	Z #2/18-21"	4-5 mils	1.5-2.0 mils

All measurements recommended are based on results at temperatures of 20°C (68°F). Viscosity will vary depending on the temperature of the liquid.

Drying Times:

At 20°C (68°F)	(Minimum Required)	At 50°C (122°F)	(Minimum Required)
Tack Free:	15-30 minutes	Tack Free:	Flash off before entering oven
Dry to Sand:	Overnight	Dry to Sand:	3 hours
Dry to Stack:	Overnight	Dry to Stack:	4 hours

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 18°C/64°F must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

Clean-Up: Use 121-001 thinner. Do not mix with product. Where the thinner and product may blend, use 100-120.

Chemcraft International Inc. 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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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.