

# Product Information

**PRODUCT NAME:** DANCRYL

**PRODUCT CODE:** 635-XXX

**DESCRIPTION:** Dancryl is a two-component, acrylic lacquer designed for all types of wood for interior use. It provides a smooth, hard-wearing surface that is resistant to alcohol, water, grease and usual household chemicals. Dancryl is especially suited for topcoating light-coloured basecoats due to its good light stability and water white appearance.

**SPECIFICATIONS:**

Gloss:	As required.
Flash Point:	<21 C
Specific Gravity:	0.97
Solids Content:	Approx. 40% by weight
Fire Hazard Class:	3
Health Hazard Class:	2
Viscosity:	40 sec., Zahn #2

**HARDENER MIXING RATIO:** 100 parts by volume 635-XXX Dancryl  
8 parts by volume 999-017 Hardener.

**REDUCTION:** Use 121-802 Slow Reducer or 121-830 Reducer.  
Other reducers may be recommended for specific applications.

**SHELF LIFE:** 12 months recommended if unopened and stored in a cool, dry area.  
Always rotate stock.

**POT LIFE:** Mix only enough material for one day's use.

**COVERAGE:** Coverage is 8-10 sq. m/L at 100% transfer efficiency. Coverage will vary depending on method of application and coating thickness.

**SURFACE PREPARATION:** Wood substrate should be sanded with 120, 150 or 180 grit paper prior to staining or coating. Sealers should be sanded with 280/320 grit steared paper prior to topcoating. Appropriate sealers are self-seal or catalyzed 401-line vinyl sealer. When recoating, the sealer or previous coat must be sanded and the next coat applied within eight hours. Stain systems under acid containing coatings should be acid stable. Dancryl can not be used on metal, old oil or cellulose lacquers.

**Dancryl - 635-XXX**

# Product Information

Page 2

## DIRECTIONS FOR USE:

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

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.

Contact with metal surfaces should be avoided.

Maximum film build of Dancryl should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 4 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.

## DRYING TIME:

Note: Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures.

### At 20 C:

Tack Free:  
Dry to Sand:  
Dry to Stack:

### (Minimum Required)

15 minutes  
2-3 hours  
Overnight

### At 50 C:

Tack Free:  
Dry to Sand:  
Dry to Stack:

Flash off before entering oven  
15-25 minutes  
2-3 hours

# Product Information

Page 3

## APPLICATION:

<u>Method</u>	<u>Viscosity</u>	<u>Wet Film</u>	<u>Recommended Dry Film</u>
Spray - Conventional	20-24", Z #2 }		
- Airless	22-27", Z #2 }-	3-4 mils	1.0-1.7 mils
- HVLP	20-24", Z #2 }		
Curtain Coater:	35-50", Z #2	3-4 mils	1.0-1.7 mils
Roller Coater:	40-50", Z #2	1-3 mils	0.3-1.0 mils

Note: All measurements recommended are based on results at temperatures of 20 C.

## NOTE:

Dancryl must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats.

Dancryl must not be used and dried at temperatures below 18 C or relative air humidity above 65% as the hardening may otherwise become incomplete. During hardening, the lacquer must not be exposed to ammonia vapours.

Ammonia cleaners should not be used for cleaning the finished surface.

## CLEAN-UP:

Use 121-802, 121-830 or 121-001.

Please refer to the Material Safety Data Sheet for additional information.

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 our products alone or in combination with other products. Users are advised to make their own tests to determine 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 in combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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