
TYPE	Two component acid curing topcoat.
USE	Industrial surface treatment of furniture and other wooden substrates. Only for interior use.
SPECIAL PROPERTIES	Good filling properties and scratch resistant surface. Very good resistance to chemicals. Contains no aromatic solvents.

TECHNICAL DATA

Density	0.99-1.24 kg/l depending on colour
Solids	Approx. 64-72 weight % depending on colour Approx. 57-60 volume % depending on colour
Volatile organic compound (VOC)	See Safety Data Sheet.
Storage	Storage: See label. Store in a tightly closed container.
Colours	Available in different colours. Bases in gloss 20, 35 and 50 which can be tinted in TEKNOTINT tinting system.
Mixing ratio	10 weight % TEKNOCOAT HARDENER 1399-12 15 volume % Variant 1633-09: 10 weight % TEKNOCOAT HARDENER 1399-12 13 volume %
Potlife	One day when thinned to 20 s DIN 4, 20 °C. Overdosing of hardener may result in discolouration of light colours.
System treatment	Priming is done with acid curing primer; TEKNOCOAT PRIMER 1603 or UV-primer. Maximum recommended amount to be applied is 3 x 120 g/m ² .

DIRECTIONS FOR USE

Application data	Spraying												
Hardener	TEKNOCOAT HARDENER 1399-12												
Thinning	1633-02, -03: TEKNOSOLV 1135-95 To a viscosity of 18-20 s DIN cup 4, 20 °C 1633-09: TEKNOSOLV 1135-91 To a viscosity of 18-20 s DIN cup 4, 20 °C												
Drying	<table><thead><tr><th><u>At RH 55 %</u></th><th><u>20 °C</u></th><th><u>50 °C</u></th><th><u>70 °C</u></th></tr></thead><tbody><tr><td>Dry for sanding:</td><td>8-10 hours</td><td>50 min.</td><td>25 min.</td></tr><tr><td>Dry for stacking:</td><td>12-16 hours</td><td>1.5 hours</td><td>40 min.</td></tr></tbody></table>	<u>At RH 55 %</u>	<u>20 °C</u>	<u>50 °C</u>	<u>70 °C</u>	Dry for sanding:	8-10 hours	50 min.	25 min.	Dry for stacking:	12-16 hours	1.5 hours	40 min.
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Dry for stacking:	12-16 hours	1.5 hours	40 min.										

The drying times are based on an amount applied of 100 g wet topcoat per m².
After forced drying cooling to 30 °C is required prior to stacking.

HEALTH AND SAFETY	See Safety Data Sheet.
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ADDITIONAL INFORMATION

Full gloss system:

1 x TEKNOCOAT PRIMER 1603-11
Sanding grain 320
1 x TEKNOCOAT 1633
Sanding grain 400
1 x TEKNOCOAT 1633
Sanding grain 600
Sanding grain 800
The surface must be completely smooth.
1 x TEKNOCOAT 1633-09

Re-coatable after min. 24 hours between each application.

The product should be stirred well prior to and after addition of hardener.
Should not be applied or left to dry at temperatures below 18 °C.
Should not be applied or left to dry at a relative humidity above 70 %.

The above information is normative and based on laboratory tests and practical experiences. The information is noncommittal, and we cannot accept liability for the results obtained under working conditions beyond our control, and consequently the buyer or the user is not released from the obligation to test the suitability of our products for specific means and application methods under the actual application conditions. Our liability covers only damage caused directly by defects in the products supplied by Teknos. The latest versions of Teknos' Technical Data Sheets and Safety Data Sheets are available from our homepage www.teknos.com.
