

WC29

## SOLVENT-BORNE HIGH-GLOSS ACID-CATALYZED PAINT SYSTEM FOR WOODEN FURNITURE

DICCOPLAST PRIMER 694 0201 DICCO CRYSTAL 90 59V-s

Solvent -borne acid-catalyzed system WC29 is high gloss paint system for kitchen cabinets, doors, chairs, furniture etc.

Diccoplast Primer is two-component acid catalysed primer. It is very fast drying and easy to sand. The primer has high solid content, good filling properties and good hiding power.

Dicco Crystal 90 is two-component high-gloss acid-catalyzed top paint. The paint has minimal tendency for yellowing and excellent color retention. It has good chemical and scratch resistance.

## Typical paint system

Treatment	Product	Application method	Wet film thickness
Priming	1-2 x Diccoplast Primer	Spraying	100-150 g/m <sup>2</sup>
Top coat	1x Dicco Crystal 90	Spraying	100-130 g/m <sup>2</sup>

## **PRODUCT PROPERTIES**

Solid Content	53 volume-%, 71 weight-% 51 volume-%, 64 weight-%	(694 0201) (59V-s)	
Specific gravity	1,4 kg/l 1,2 kg/l	(694 0201) (59V-s)	
Paint hardener mixing ratio	694 0201 : 006 2098 59V -s : 006 2098	100:10 100:10	

# **Drying times**

	100-120 /m²	+23°C	+50°C
	Dry to sand	1-2 h	30-40 min
Diccoplast Primer	Dry to stack	1-2 h	30-40 min
	Dry to sand	2-3 h	25-35 min
Dicco Crystal 90	Dry to stack	4-5 h	35-45 min

Stacking temperature below +35°C.

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Gloss High-gloss (59V-s)

**Color** Temaspeed Premium- tinting system.

Application methods Spraying

Thinner Thinner 1025 (slow), 1027 (medium slow)

Cleaning of equipment Thinner 1025, 1027

#### **SURFACE PREPARATION**

Dirt, dust and other unfamiliar material must be removed from the surface. Wooden material should be sanded before application with paper grain size 150 - 240. All sanding dust must be removed before application.

## **APPLICATION CONDITIONS**

During application and drying the temperature of the air, paint and surface should be at least +18 °C. The relative humidity should not exceed 70 %. Good ventilation is needed during drying process.

## **APPLICATION**

Stir the Diccoplast Primer well and add 10 % by volume of hardener 006 2098 and mix well again. Thin the paint to the proper application viscosity with thinner 1033. Proper spraying viscosity is 18-25 sec (Din4).

Spray an even coat (wet film thickness about 100-150 g/m²) and let it dry about 1-2 h (in 20-30 °C temperature) before sanding. Sand the surface carefully with paper grain size 320-1200 and remove sanding dust before second application. Small grain size sanding paper is recommended before top paint.

If needed apply a second even coat and let it dry about 1-2 hours (in 20-30 °C temperature) and sand the surface with paper grain size 600 – 1200 and remove sanding dust.

Stir the Dicco Crystal 90 well and add 10 % by volume of hardener 006 2098 and mix well again. Thin the paint to the proper application viscosity with thinner 1025. Proper spraying viscosity is 18-25 sec (Din4). Spray an even coat (wet film thickness about 100-130 g/m²) and let it dry about 4-5 h (in 20-30 °C temperature) before further processing.

The drying time depends of film thickness, temperature, relative humidity and the air ventilation.

The recommended nozzle size is 0,011-0,015" and angle 20 or 40.

## **MAINTENANCE PAINTING**

Wash down the surface with Maalipesu and rinse carefully with water. Remove old loose paint with scraper. Sand down surface and remove the sanding dust. Stir Miranol, Empire or Maalarin Valkolakka well before use. Apply evenly 1-2 coats of paint. Sand down lightly between each coat.

The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. The quality of the product is ensured by our operational system, based on the requirements of ISO 9001 and ISO 14001. As manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

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