

# Mohawk Finishing Products

Division of RPM Wood Finishes Group, Inc.

## Product Data Sheet

### DuraCoat™ II Post-Catalyzed Clear Lacquer

M612-3480 (Gloss), M612-3460 (Semi-gloss), M612-3440 (Satin), M612-3420 (Matte), M612-3410 (Flat)

Available in 1 gallon (125 fluid ounce) and 5 gallon (625 fluid ounce) containers.

**Product Description:** DuraCoat™ II Post-Catalyzed Lacquer is 275 VOC compliant, high quality finish that must be catalyzed with DuraCoat™ II Catalyst (M612-301) before use, which helps to build resistance properties into the film.

#### Advantages:

1. Extended shelf life
2. 275 VOC compliant
3. HAP's and Rule 66 compliant
4. Excellent toughness, resistance and stability
5. Ready to spray, no reduction required

#### Characteristics:

Weight per gallon: 7.84\* lbs/gal

Solids % (wt): 24.38\*

Solids % (vol): 18.63\*

Package viscosity: 12-14 seconds, # 4 Ford cup

Dry time: Air dry @ 72 F, 35% relative humidity

To touch: 7 minutes

To handle: 15 minutes

To sand and recoat: 30-45 minutes

To rubout or package: 24 hours

VOC's (coating): 2.29 lbs/gal (274.48 g/l)\*

VOC's (material): .63 lbs/gal (76.11 g/l)\*

HMIS: Health – 2, Flammability – 3, Reactivity – 0, Personal Protection - X

VHAP's: 0.052 lbs VHAP's/lb solids\*

Shelf Life Catalyzed: 1 year un-catalyzed; 6 months after addition of catalyst.

Store product in cool, dry environment

Sheen: Gloss:  $\geq 80$ , Semi-gloss: 60, Satin: 40, Matte: 20, Flat: 10

Spread Rate: 299 sq ft @ 1 dry mil

(Contains nitrocellulose resins, which tend to amber in color over time but does not affect coating performance)

\*Varies between sheens.

All values theoretical; not intended to be exact QC specifications.

**Directions:** Add 1 bottle of the pre-measured (packaged in 3.2 oz./single gallon and 16 oz./5-gal pails bottles) DuraCoat™ II Catalyst (M612-301) to catalyze the entire container of DuraCoat™ II Post-Catalyzed Lacquer. Stir material while adding catalyst and continue to stir until thoroughly mixed. Material is now ready for spraying. Seal with E-Z Vinyl® Sealer (M612-800) or DuraCoat™ II Pre-Catalyzed Sealer (M612-3400) or use as a self-sealing system and allow 30-45 minutes to dry before sanding with 320 grit sandpaper. Do not use a steared, nitrocellulose sanding sealer as a sealer with this product. Steared, nitrocellulose sanding sealers may cause acid blooming.

DuraCoat™ II Post-Catalyzed Lacquer is manufactured at spray viscosity and should be applied in light, even coats of no more than 3-4 wet mils. Scuff sand with 320 grit steared sandpaper and remove sanding dust prior to applying the next coat. All Mohawk 275 VOC formulations are high solids products, which build very quickly. Total film build of the entire system, including topcoats, should not exceed 4 dry mils. Excessive build may lead to poor adhesion, cracking or cold check

problems. Mohawk Retarder for Low VOC Coatings (M612-1056) is recommended if a flow enhancer is needed.

**Refer to the last page of this document for additional 275 VOC product tips.**

**Notes:** The entire container of DuraCoat™ II Post-Catalyzed Clear Lacquer must be catalyzed at once. Do not catalyze partial amounts. Attempting to catalyze partial amounts may result in poor performance of the product. DuraCoat™ II Post-Catalyzed Lacquer is manufactured at spray viscosity. If further reduction is required, Mohawk Acetone (M650-001) is recommended. Recoating DuraCoat™ II Post-Catalyzed Clear Lacquer (M612-3400 series) should take place after 30-45 minutes of dry time or after a fresh sanding. Stainless spray equipment is strongly recommended. Total dry film of the entire system, including topcoats, should not exceed 4 mils. All products should be stirred properly before being used and also continuously agitated while in use to insure product consistency from start to finish. Filtering at every opportunity is suggested. The system should be pre-tested on the wood to be finished under application conditions. Mixing with other products or finish systems is not recommended. Mohawk Finishing Products will not be held liable for finish failure resulting from mixing products or systems. This product is formulated for interior applications and is not recommended or tested for exterior use.

**Safety and Other Precautions:** Read MSDS for precautions before using product.

**MSDS:** If Material Safety Data Sheet is required, contact:

Mohawk Finishing Products

Division of RPM Wood Finishes Group, Inc.

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Hickory, NC 28603

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# Mohawk 275 VOC Coatings

## Tip Sheet

**Viscosity** is typically much lower or thinner in 275 VOC coatings because they have to be in order to achieve proper flow out of the coating.

**Agitation** is needed to thoroughly mix flattening agents and pigments in opaque colors into all coatings. Periodic agitation is always recommended for most clear and opaque coatings. However it is particularly important with 275 VOC coatings because 275 VOC products tend to settle faster due to the lower viscosity, which can allow flattening agents and pigments to fall out of suspension much faster than in higher VOC formulations.

For best results, always agitate or stir 275 VOC products more frequently in order to maintain a consistent sheen or color. A good habit to get into is to stir the 275 VOC products at least every 10 minutes.

**Application** of 275 VOC coatings does have a few new things to remember.

1. Stir/Agitate 275 VOC coatings frequently.
2. Lighter coats work better than heavy wet coats. Do not try to level a coat by applying it too heavy. Excessive build could occur.
3. Lowering your air or fluid pressure will reduce the risk of the product going on dry.

4. Hold the gun a little closer to the substrate when applying to reduce the risk of applying too dry.

**Build** can be deceiving with a 275 VOC coating. In fact, it is very easy to exceed the maximum build of 4 dry mils.

To reduce this risk, try to keep the four coat rule. **DO NOT APPLY MORE THAN 4 TOTAL COATS INCLUDING SEALERS OR PRIMERS.**

275 VOC coatings may be lower in viscosity but they remain high solids coatings. Exceeding the 4 coat rule can increase the chances of excessive build, which can result in cracking or other finish failures.

**Mohawk 275 VOC Products include:**

M612-2500 series Finisher's Choice™ Clear Lacquer

M612-800 E-Z Vinyl® Sealer

M612-3400 series Duracoat™ II Post-Catalyzed Lacquer

M612-3600 series Duracoat™ II Post-Catalyzed White Lacquer

M612-2800 series Ultra™ Clear Conversion Varnish (Post Catalyzed)

M612-2700 series Ultra™ White Conversion Varnish (Post Catalyzed)

M612-106 & M612-306 E-Z Vinyl® Colored Sealer