

# Product Information

## Optiset® 900 White – 131-80XX

### PRODUCT DESCRIPTION

131-8020	Low Gloss
131-8035	Satin Gloss
131-8050	Semi-Gloss
131-8090	Full Gloss

Optiset® is a one component, pigmented pre-catalyzed Reactive Amino Coating (RAC) with good resistance properties. This product meets the German “E-1” classification for the emission of formaldehyde as tested by an accredited laboratory using North American test methods. This is a fast building pigmented pre-catalyzed RAC due to its high solid content (34% volume). Optiset is recommended for kitchen cabinets, office and household furniture, as well as other interior wood applications.

### FEATURES

Optiset® demonstrates very good moisture, household wear, household chemical and mar resistance. The coating has light stable properties due to the type of resin used. This coating may be catalyzed to further enhance its durability. Contact your coating supplier for a recommendation.

Optiset® has very low odor during the curing process while maintaining its rapid dry and cure properties.

Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.  
Recommended: American Woodworking Institute (AWI). O.P.2.

**Note:** Optiset® White must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. 131-80XX must not be used and dried at temperatures below 64°F or relative humidity above 65%. During hardening the enamel must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

### SPECIFICATION VALUES

Gloss:	As required
Flash Point:	10°C (50°F)
Specific Gravity:	1.10
Weight per Gallon:	9.15
Solids by Weight:	49%
Solids by Volume:	34%
Fire Hazard Class:	3
Health Hazard Class:	2
Viscosity at 25°C (77°F):	60" 2#Z
VOC:	570 g/l (4.70 lb/gal)
Lbs. VOC/Gallon:	4.70 lb/gal
Lbs. VOC/Lbs. Solids:	0.99
Lbs. VHAPs/Lbs. Solids:	<0.05 lbs.

#### Values at Application after Reduced if Catalyzed:

Lbs. VOC/Lbs. Solids:	1.44
Lbs. VHAPs/Lbs. Solids:	0.07

If additional reducers or additives are used, compliance values must be recalculated.

### SPECIFICATION INFORMATION

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

**Pot Life:** When catalyzing, only mix enough material for a maximum of eight hours use.

**Coverage:** Coverage is 545 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

**Mixing Ratio:** When used as a two-component product use 100 parts by volume of 131-80XX Optiset® White, 3 parts by volume of 873-0870 Hardener.

**Reduction:** Use Reducer 803-1325 at a ration of 15-20 % by volume. Use Chemcraft® Retarder 800-5328 to slow the cure and keep the film open longer.

## DIRECTIONS FOR USE

**Surface Preparation:** Wood substrate should be sanded with 120, 150 or 180 grit paper prior to coating. Primers should be sanded with 280/320 grit stearated paper prior to topcoating. An appropriate primer is Optiprime White (545-8001) or self-seal. When recoating, the previous coat of Optiset® or primer must be sanded and the next coat applied within eight hours. Optiset® White cannot be used on metal, old oil or cellulose lacquers.

**Directions for Use:** Agitate material before use. Always mix Optiset® while adding hardener and reducers in the recommended mixing ratios. Optiset® must be agitated thoroughly at all times to ensure product consistency and consistent gloss.

Apply at 3-5 mils wet on sanded or primed substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit stearated paper. Maximum film build of Optiset® White should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Contact with metal surfaces should be avoided.

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 #2/20-25"	3-5 mils	0.8-1.2 mils
- Airless	Z #2/18-22"	3-5 mils	0.8-1.2 mils
- HVLP	Z #2/17-20"	3-5 mils	0.8-1.2 mils

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

### Drying Times:

At 68°F	(Minimum Required)	At 122°F	(Minimum Required)
Tack Free:	10-15 minutes	Tack Free:	Flash off before entering oven
Dry to Sand:	2 hours	Dry to Sand:	30-45 minutes
Dry to Stack:	3 hours	Dry to Stack:	60-90 minutes

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

**Clean-Up:** Use 803-1298.

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.

Revised:

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.