

<b>Product Code:</b>		<b>VISCOSITY:</b>	Z#2/22" at 77° F
431-4620	Low Gloss	<b>FLASH POINT:</b>	-4° F (-20°C)
431-4635	Satin Gloss	<b>DENSITY (lb/gal):</b>	7.8
431-4650	Semi-Gloss	<b>SOLID (% by weight):</b>	30%
431-4690	Full Gloss	<b>SOLID (% by volume):</b>	22%
		<b>SHELF LIFE (months):</b>	6

**Product Description:** Varicure is a one-component high solids pre-catalyzed Reactive Amino Coating (RAC). This is a fast building pre-catalyzed RAC due to its high volume solids (22%). Varicure demonstrates very good moisture, household wear, household chemical, solvent and mar resistance. Varicure has very fast hardness development resulting in early print resistance and packaging. Varicure is supplied at a ready to spray viscosity. This coating will dry quickly and sand easily.

Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.  
Recommended: Architectural Woodwork Institute (AWI). T.R.2.

**Uses:** Varicure is recommended for office and household furniture, kitchen cabinets, as well as many other interior wood applications.

**Environmental Data (as supplied):**

<b>VOC less exempt lb/gal:</b>	<5.45
<b>VOC lb/gal:</b>	<5.05
<b>VOC less exempt g/l:</b>	<655
<b>VOC g/l:</b>	<605
<b>VOC lb/lb Solid:</b>	<2.25
<b>VHAPs lb/lb Solid:</b>	<0.25

<b>Application Data:</b>	<b>SUGGESTED USES:</b>	Wood Finish
	<b>MIXING RATIO:</b>	97 parts 431-46XX, 3 parts 873-0870 (Pot Life 8 hours) 99 parts 431-46XX, 1 parts 873-1205 (Pot Life 8 hours) 99 parts 431-46XX, 1 parts 873-1244 (Pot Life 10 days)
	<b>POT LIFE:</b>	See mixing ratio
	<b>APPLICATION VISCOSITY:</b>	Z # 2 20 – 25"
	<b>REDUCER:</b>	803-1325
	<b>RETARDER:</b>	800-5328
	<b>CLEAN-UP SOLVENT:</b>	803-1298
	<b>RECOMMENDED WET FILM:</b>	3 – 5 mils
	<b>COVERAGE:</b>	372 sq ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.



## Directions for Use

Varicure  
431-46XX

**Surface Preparation:** Substrate must be sanded using 120, 150 or 180 grit stearated paper prior to staining or coating. Sealers, if used, should be sanded with 280/320 grit stearated paper prior to being coated. The sealer should be topcoated within eight hours of being sanded. Appropriate sealers are Chemcraft pre-catalyzed sealers, or self-seal. When recoating, the previous coat of Varicure must be sanded and the next coat applied within eight hours. Varicure cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. AkzoNobel recommends using 825-80XX C-mix stains or 890-85XX N.G.R. stains.

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

Apply at 3 – 5 mill wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit stearated paper. The second and subsequent coats must be applied the same day as the previous coat is sanded. The maximum film build of Varicure should not exceed 4 mils dry.

Varicure may be catalyzed to further enhance its durability. Contact your coating supplier for a recommendation. This product is intended as a self-seal product; however, if a sealer is desired Optiseal 900 H/S (431-1909) is recommended.

Maximum film build of total coating system must not exceed 4 mils dry. Contact with metal surfaces should be avoided. Varicure must not be polluted with oil, varnish or the like and must not be sanded with steel wood between coats. Varicure 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.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION.

### Drying Times:

	At 68°F	At 122°F
<b>Tack Free Time:</b>	10 – 15 minutes	Flash off before entering oven
<b>Dry to Sand:</b>	20 – 30 minutes	15 – 20 minutes
<b>Dry to Stack:</b>	2 Hours	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.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

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.

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