

# Product Information

## Optiprime 900 White – 545-8001

### PRODUCT DESCRIPTION

Optiprime 900 White is a one-component, high solids, pre-catalyzed Reactive Amino Coating (RAC) used as a primer. This product meets the German "E-1" classification for the emission of formaldehyde as tested by an accredited laboratory using North American test methods.

Optiset is fast drying and well suited for spraying as well as coating by roller and curtain coating. This pre-catalyzed lacquer has very low odor during the curing process while maintaining its rapid dry and cure properties.

### FEATURES

Optiprime 900 White is recommended for use as a primer for Optiset® 131-80XX. It has good filling properties and hiding characteristics.

This coating may be catalyzed to further enhance its durability. Contact your coating supplier for a recommendation.

**Note:** Optiprime 900 White must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats.

Optiprime 900 White 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:	N/A
Flash Point:	50°F
Weight per Gallon:	9.36
Solids by Weight:	50%
Solids by Volume:	34.5%
Fire Hazard Class:	3
Health Hazard Class:	2
Viscosity:	Z#2/58" at 77°F.
VOC:	4.71 lb./gal.
Lbs. VHAPs/Lbs. Solids:	0.06
Lbs. VOC/Lbs. Solids:	1.01

#### Values at Application if catalyzed:

Lbs. VHAPs/Lbs. Solids:	0.06
Lbs. VOC/Lbs. Solids:	1.49 (with 30% reduction)

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

### SPECIFICATION INFORMATION

**Shelf Life:** Six months recommended if unopened and stored in a cool dry area. Always rotate stock.

**Pot Life:** Mix only enough for 8 hours use for optimum product performance. Use of material which has been catalyzed for more than 8 hours may cause failure in film integrity.

**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 545-8001 Optiprime White, 3 parts by volume of 873-0870 Hardener.

**Reduction:** Use slow reducer 803-1325 for hot climates and extra flow. Use Fast Reducer 803-1329 for temperate climates. Use up to 30% by volume of reducer as required to obtain recommended viscosity.

## DIRECTIONS FOR USE

**Surface Preparation:** Substrate should be sanded using 120, 150 or 180 grit steared paper prior to coating. Primers, if used, should be sanded prior to being coated with 280/320 grit steared paper. When recoating, the previous coat of Optiprime 900 White must be sanded and the next coat applied within eight hours. Optiprime 900 White cannot be used on metal, old oil or cellulose lacquers.

**Directions for Use:** Agitate material before use. Always mix Optiprime 900 White while adding hardener and reducers in the recommended mixing ratios. Optiprime 900 White must be agitated thoroughly at all times to ensure product consistency.

Apply at 3-5 mils wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit steared paper. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Maximum film build of Optiprime 900 White should not exceed 2-3 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. 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
- Curtain Coater	Z #2/25-35"	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:	1-2 hours	Dry to Sand:	30 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.