



DuoCryl Profi

Technical Information

- Characteristics:** Fast drying two-component lacquer based on acrylic resin, providing a good colour fastness. A perfect result can only be achieved by carrying out the following instructions.
- Area of application:** Suitable for a resisting finish of woods used for furniture construction and interior work.
- Substrates:** Dry, clean, resin-free wood and, in case of previous staining, completely dry and clean surfaces. The substrate must be stable.
- Hardener:** **DuoCryl Härter**
- Mixing ratio:** **10** units lacquer : **1** unit hardener by weight or by volume
- Pot life:** Max. 24 hours at 20°C/65% relative air humidity.
Exceeding the pot life may cause surface defects.
Attention: The pot life is reduced by higher temperatures of object and ambience.
- Processing:** **DuoCryl Profi** is applied by spraying (gravity spray gun, Airless, Airmix).

Application:	Airless	Airmix	gravity spray gun
Spray pressure:	60 - 80 bar	50 - 60 bar	----
Air pressure:	----	1.5 – 2.0 bar	2.5 – 3.5 bar
Nozzle size:	0.22 – 0.33 mm	0.22 – 0.33 mm	1.5 – 1.8 mm
Spray viscosity:	approx. 25 s/4 mm	approx. 25 s/4 mm	approx. 25 s/4 mm

Depending on the spray gun in use deviations concerning spray pressure, air pressure and nozzle size can occur. The temperature during application should not fall below +18°C. This applies also to the substrate.
Unsuitable for rolling and brushing. The product needs to be adapted to application by curtain coater.

- Dilution:** **DuoCryl Profi** mixed with hardener **DuoCryl Härter** is a sprayable compound. Depending on the processing method and need it can be thinned with **DD-Verdünnung Nr. 20**, **DD-Verdünnung Nr. 25 lang (Verzögerer)** (max. 5%) can be used to retard the drying time. **DD-Verdünnung Nr. 15 kurz** (max. 10%) can be used to accelerate the drying time.
- Spreading rate:** Applied quantity: Approx. 120-140 ml/m² and layer.
Approx. 7-8 m²/l per layer, depending on the absorptivity of the wood and the application method.
- Drying time:** Depending on the application method and the applied quantity at room temperature (20°C/65% relative air humidity):
- set to touch after 30 minutes.
- sandable and recoatable after approx. 2 hours.

Please turn over!



DuoCryl Profi

Technical Information

Primer and topcoat: **DuoCryl Profi** is used as primer as well as topcoat. In order to obtain higher stress resistance a third coat of **DuoCryl Profi** can be applied after an intermediate sanding.
Attention: When using the gloss level 5 (dull), the primer should have a higher gloss level (1-45). The gloss level 5 (dull) should only be used for top coats.

Cleaning of tools: **Waschlöser Nr. 52** and **PUG Pinsel- u. Gerätereiniger**.

Storage: **DuoCryl Profi** can be stored at least 3 years in closed original containers and the hardener at least 2 years.

Special remarks: Even if the surfaces treated with **DuoCryl Profi** are dry and stackable after a short time, the required chemical and mechanical resistance is only achieved after a drying time of 5-7 days (at 20°C/65% relative air humidity).

DIN 68861-1 (behaviour at chemical influence): Stress group: 1B

DIN 68861-2 (behaviour at abrasion): Stress group: 2C

DIN 51131 / EN 13893: Determination of antislip property

DIN 53160-1/-2: Saliva and perspiration resistance.

DIN EN 71-3: Safety of toys (heavy metal migration).

DIN 4102-1 (test to determine the fire behaviour to prove the classification B1): Difficult to ignite on chipboards – even with veneer – with fire behaviour **DIN 4102-B1** (in combination with **DuoCryl Härter**).

Please consider: The product and the recommendations in this technical data sheet correspond to today's state of the art. Our oral and written application recommendations, that are based on years of experience and provided to the best of knowledge, are non-committal and do not establish a contractual relationship and secondary obligation of the sales contract. They do not release the user from his obligation to verify on his own responsibility the existing substrate and the suitability of our products for the intended purpose. In case of doubt, suitability and spreading rate are to be tested by creating a sample. If our products are combined or inter-mixed with third-party products we cannot guarantee a perfect surface finish. Our general terms and conditions apply.

This technical data sheet replaces all previous versions.

Edited 12/25