

DuoCryl Top

Technical Information

Characteristics: Fast drying two-component lacquer based on acrylic resin, with very good colour fastness and good filling power.
A perfect result can only be achieved by carrying out the following instructions.

Area of application: For a resisting finish of woods used for furniture construction and interior work.

Substrates: Dry, clean and resin-free wood and, in case of previous staining, completely dry and clean surfaces. The substrate must be load-bearing. Also suitable for bleached wood.

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 occur surface defects.
Attention: The pot life is reduced by higher temperatures of the object and ambiance.

Processing: **DuoCryl Top** 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	1,8 - 2,0 mm
Spray viscosity:	approx. 25 s/4 mm	approx. 25 s/4 mm	approx. 25 s/4 mm

Depending on the used spray gun, deviations concerning spray pressure, air pressure and nozzle size can occur. The temperature for application should not fall below 18°C. This also applies to the substrate.

Not suitable for rolling and brushing. The product has to be adjust when applying by curtain coater.

Dilution: **DuoCryl Top** mixed with hardener **DuoCryl Härter** is a sprayable compound. Depending on the processing method and the need it can be thinned **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. 100-110 ml/m² and layer.
Approx. 9-10 m²/l per layer, depending on the absorptive capacity 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!

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Primer and topcoat:

DuoCryl Top is used as primer as well as top coat. For intended higher stress, a third coat of **DuoCryl Top** can be applied after having sanded intermediately.
Caution: 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 the top coat.

Cleaning of tools:

Waschlöser Nr. 52 and **PUG Pinsel- u. Gerätereiniger**.

Storage:

DuoCryl Top can be stored at least 3 years in tightly closed original containers and the hardener at least 2 years.

Special remarks:

Even if the surfaces treated with **DuoCryl Top** 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 (20°C/65% relative air humidity).



DuoCryl Top
Baustoffklasse
DIN 4102-B1
schwerentflammbar auf
Holzspanplatte mit dem
Brandverhalten
DIN 4102-B1

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 the anti-slip property
DIN 53160-1/-2: Saliva and perspiration resistance.
DIN EN 71-3: Safety of toys (heavy metal migration).

Please consider:

The product and the recommendations in this technical data sheet correspond to today's state of the art. Our application technology recommendations oral and in writing, which we give due to our experience to the best of our knowledge, are non-committal and do not constitute a contractual legal relation and additional obligation of the sales contract. They do not release the user from his obligation to check the existing underground and the suitability of our products for the intended purpose on his own responsibility. In case of doubt, suitability and consumption rate are to be tested by creating a sample. When merging other products with our own products or processing with foreign manufactured products we cannot guarantee a perfect final result of the surface. Our general terms of payment and supply are in force.

With this technical information all previous lose their validity.

Edited 03/26