

<b>TYPE</b>	Two component acid curing topcoat.
<b>USE</b>	Industrial surface treatment of furniture and other wooden substrates. Only for interior use.
<b>SPECIAL PROPERTIES</b>	Good filling properties and scratch resistant surface. Very good resistance to chemicals. Contains no aromatic solvents.

**TECHNICAL DATA**

<b>Density</b>	0.99-1.24 kg/l depending on colour
<b>Solids</b>	Approx. 64-72 weight % depending on colour Approx. 57-60 volume % depending on colour
<b>Volatile organic compound (VOC)</b>	See Safety Data Sheet.
<b>Storage</b>	Storage: See label. Store in a tightly closed container.
<b>Colours</b>	Available in different colours. Bases in gloss 20, 35 and 50 which can be tinted in TEKNOTINT tinting system.
<b>Mixing ratio</b>	10 weight %      TEKNOCOAT HARDENER 1399-12 15 volume %
<b>Potlife</b>	One day when thinned to 20 s DIN 4, 20 °C. Overdosing of hardener may result in discolouration of light colours.
<b>System treatment</b>	Priming is done with acid curing primer; TEKNOCOAT PRIMER 1603 or UV-primer. Maximum recommended amount to be applied is 3 x 120 g/m <sup>2</sup> .

**DIRECTIONS FOR USE**

<b>Application data</b>	Spraying			
<b>Hardener</b>	TEKNOCOAT HARDENER 1399-12			
<b>Thinning</b>	1633-02, -03: TEKNOSOLV 1135-93 or TEKNOSOLV 1135-95 gloss 30-35 To a viscosity of 18-20 s DIN cup 4, 20 °C			
	1633-02, -03: TEKNOSOLV 1181-11 or TEKNOSOLV 1182-11 gloss 20-25 To a viscosity of 18-20 s DIN cup 4, 20 °C			
	1633-09: TEKNOSOLV 1135-91 To a viscosity of 18-20 s DIN cup 4, 20 °C			
	1633-20: TEKNOSOLV 1135-95 or TEKNOSOLV 1181-11/TEKNOSOLV 1182-11 To a viscosity of 18-20 s DIN cup 4, 20 °C			
<b>Drying</b>	<u>At RH 55 %</u>	<u>20 °C</u>	<u>50 °C</u>	<u>70 °C</u>
	Dry for sanding:	8-10 hours	50 min.	25 min.
	Dry for stacking:	12-16 hours	1.5 hours	40 min.

The drying times are based on an amount applied of 100 g wet topcoat per m<sup>2</sup>. After forced drying cooling to 30 °C is required prior to stacking.

<b>HEALTH AND SAFETY</b>	See Safety Data Sheet.
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**ADDITIONAL INFORMATION**

Full gloss system:

1 x TEKNOCOAT PRIMER 1603-11  
Sanding grain 320  
1 x TEKNOCOAT 1633  
Sanding grain 400  
1 x TEKNOCOAT 1633  
Sanding grain 600  
Sanding grain 800  
The surface must be completely smooth.  
1 x TEKNOCOAT 1633-09

Re-coatable after min. 24 hours between each application.

The product should be stirred well prior to and after addition of hardener.  
Should not be applied or left to dry at temperatures below 18 °C.  
Should not be applied or left to dry at a relative humidity above 70 %.

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The above information is normative and based on laboratory tests and practical experiences. The information is noncommittal, and we cannot accept liability for the results obtained under working conditions beyond our control, and consequently the buyer or the user is not released from the obligation to test the suitability of our products for specific means and application methods under the actual application conditions. Our liability covers only damage caused directly by defects in the products supplied by Teknos. The latest versions of Teknos' Technical Data Sheets and Safety Data Sheets are available from our homepage [www.teknos.com](http://www.teknos.com).

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