

Technical Data Sheet

DM308-0018

Care Clear 18

Product description

Acid catalyst clear lacquer. This is a general purpose lacquer for most wooden substrates. Fast drying lacquer suitable for fast production lines.

Product data

Gloss:	16-20	Gardner 60°	
Solid content:	35 ±1	[weight %] theoretical	
Specific gravity:	970 ±30	[kg/m ³]	
Viscosity:	110-120	[s] DIN 4	test performed at 23 °C
Frost sensitive:	No		
Storing:	12 months	At 0-30 °C	Storing at higher temperature reduces shelf life, do not expose to direct sunlight
Process Temperature:	18-30 °C		To achieve the best result and consistency follow the application and surface temperatures given in Schedule of Application for each specific technology and production line.

Mixing/Application

Recommended application method	Hardener	Amount hardener [Parts by vol]	Dilutant	Application viscosity [s] DIN 4	Application amount [g/m ²]	Notes
Air mix spraying	DV309	5	DT890	17-25	80-120	Hardener added to 100 vol parts of paint
Stir well before use!						
Cleaning:	NT019 DT890					

Drying

Method	Drying condition	Drying time	Notes
Air Drying	20 °C	10-16 h	Depends on amounts applied
Forced drying	50 °C	20-30 min	Depends on amounts applied

All kind of drying requires good ventilation and circulation
Do not stack before surface temperature below 30 °C

Curing

UV-dose	Min UV dose [mJ/cm ²]	Rec min Peak. [mW/cm ²]	Min UV dose [mJ/cm ²]	Rec min Peak. [mW/cm ²]
	Hg lamps (280-320 nm)	Hg	Ga lamps (390-450 nm)	Ga
Full cure	N/A		N/A	
Semi cure	N/A		N/A	

Note - Required Peak/Energy is depending on several factors, such as substrate, amount of application, number of layers and type of UV oven / reflectors. Recommended application amounts and Peak/Energy values will be stated in the finishing instruction/process control submitted by technician.

General information

According to Swedish legislation we provide information regarding dangerous materials. The Safety Data Sheet contains facts about the components, primarily solvents and acids which present the dangerous characteristics. The Safety Data Sheet will be sent on request. All values and recommendations above are to be considered as guidance only. Many factors beyond our control may have an influence on the coating result. Should a problem arise, please contact us and we will advise accordingly. We reserve the right to alter the above specifications.

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