

**Product Codes:**

436-3810	Matte
436-3820	Low Gloss
436-3835	Satin
436-3850	Semi-Gloss
436-3865	Semi-Gloss
436-3890	High Gloss

<b>VISCOSITY:</b>	Zahn #2 signature cup 33 sec at 77°F
<b>FLASH POINT:</b>	40 °F
<b>DENSITY (lb/gal):</b>	7.89
<b>SOLID (% by weight):</b>	25.9%
<b>SOLID (% by volume):</b>	20.8%
<b>SHELF LIFE (months):</b>	12

**Product Description:** Acrilico is formulated with crystal clarity and virtually no discoloration. Acrilico takes acrylic polyurethane coating to a new level. While providing a great look for open pore finishes, Acrilico is also the logical choice for the high end kitchen cabinet industry. The Acrilico line provides superior surface resistance.

**Uses:** Acrilico is designed for use on high end woodwork such as: business jet interior, luxury ship interior, kitchen cabinets, furniture, and expensive veneers.

**Environmental Data (as supplied):**

<b>VOC less exempt lb/gal:</b>	<5.9
<b>VOC lb/gal:</b>	<5.9
<b>VOC less exempt g/l:</b>	<708
<b>VOC g/l:</b>	<708
<b>VOC lb/lb Solid:</b>	<2.9
<b>VHAPs lb/lb Solid:</b>	<0.5

**Application Data:**

<b>SUGGESTED USES:</b>	Wood Finish
<b>MIXING RATIO:</b>	100 Parts 436-38XX with 20 Parts 876-9101 (by volume)
<b>POT LIFE:</b>	6 hours
<b>APPLICATION VISCOSITY:</b>	Zahn #2 signature cup 18 – 20 seconds
<b>REDUCER:</b>	Fast 803-1410, Medium 803-1409, or slow 803-1408 if needed
<b>RETARDER:</b>	800-5328 3-5% by volume
<b>CLEAN-UP SOLVENT:</b>	800-5500 Acetone
<b>RECOMMENDED WET FILM:</b>	3 to 5 wet mils

**MAXIMUM DRY FILM THICKNESS OF THE SYSTEM MUST NOT EXCEED 6.0 DRY MILS**

## Directions for Use

ora Verde® Acrilico PU Clear TC  
436-38XX

**Surface Preparation:** Substrate must be sanded using 120, 150 or 180 grit paper prior to staining or coating. Sealer should be sanded with 280/320 grit paper prior to being coated. The sealer should be coated within eight hours of being sanded. Appropriate sealer is the ora Verde Acrilico Sealer 436-2400. When recoating, the previous coat of Acrilico must be sanded and the next coat applied within eight hours. Stain systems used under Acrilico are formulated to develop excellent grain definition. AkzoNobel recommends using Promatch® W/B Monocolor Spray Stains 824-50XX, Promatch Aqua Stains 824-51XX, Promatch Dye Stains 890-85XX or Promatch C-Mix Wipe Stains 825-90XX, 825-91XX.

**General Information:** The mixed product contains 876-9101, an isocyanate based co-reactant. Please follow all precautions associated with handling and use of those materials. Refer to MSDS for detail information.

Oil stains must be avoided because they will interfere with the adhesion. When coating exotic woods (Teak, Rosewood, etc.) a barrier coat (tie-coat) should be applied before the sealer or base coat. See Product data sheet for 401-033 Isolante.

Product must be thoroughly stirred before adding the hardener in the recommended ratio. The viscosity of the product should be monitored after mixing with the hardener.

The relative humidity in the application and drying room should not exceed 75% for maximum coating performance.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR THE START-UP OF PRODUCTION.

### Drying Times:

	<b>Room Temperature (68°F)</b>	<b>Forced Drying Schedule (122°F)</b>
<b>Tack Free Time:</b>	15 minutes	15 minutes
<b>Dry to Sand:</b>	4 hours	15 minutes
<b>Dry to Stack:</b>	24 hours	15 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.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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