

**Product Code:**

620-111	Matte
620-114	Gloss

**VISCOSITY:** Zahn #2 signature cup 21 sec at 77°F  
**FLASH POINT:** 25° F (-4°C)  
**DENSITY (lb/gal):** 8.16  
**SOLID (% by weight):** 37.3%  
**SOLID (% by volume):** 31.3%  
**SHELF LIFE (months):** 12

**Product Description:** D-Dur is a two-component polyurethane with very good wetting properties.

**Uses:** D-Dur is recommended for wooden surfaces where good outdoor durability is desired (i.e. window frames, doors etc.)

**Environmental Data (as supplied):**

<b>VOC less exempt lb/gal:</b>	<5.2
<b>VOC lb/gal:</b>	<5.2
<b>VOC less exempt g/l:</b>	<612
<b>VOC g/l:</b>	<612
<b>VOC lb/lb Solid:</b>	<1.7
<b>VHAPs lb/lb Solid:</b>	<0.25

See individual compliance sheets for specific data

**Application Data:**

<b>SUGGESTED USES:</b>	Wood Finish.
<b>MIXING RATION:</b>	4 parts 620-1XX to 1 part 999-062
<b>POT LIFE:</b>	Approximately 4 hours depending on conditions. Pot life is decreased when product is hot or under pressure. Viscosity should be monitored after mixing with hardener.
<b>APPLICATION VISCOSITY:</b>	Zahn #2 signature 18 – 22 seconds
<b>REDUCER:</b>	800-5301 (Fast)
<b>RETARDER:</b>	800-5328
<b>CLEAN-UP SOLVENT:</b>	800-5500
<b>RECOMMENDED WET FILM:</b>	4 – 5 mils

## Directions for Use

D-Dur PU Clear TC  
620-1XX

**Surface Preparation:** Wood substrate should be sanded with 120,150 or 180 grit paper prior to staining or coating. Sealer should be well sanded using 240 or 320 grit stearted paper. A first coat of Isolante is recommended, please refer to SOP for application.

**General information:** Mix the desired amount of material and apply 4-5 mils wet. The relative humidity in the application and drying rooms should never exceed 75%. Viscosity on the catalyzed material should be monitored regularly to maintain a consistent appearance. Mixed product will contain 999-062, an isocyanate base co-reactant. Please follow all precautions associated with handling and use of these materials. The total recommended film thickness of D-Dur system is not to exceed 6 mils dry.

The completed coating system should be checked for required properties prior to the start-up of production.

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 TO THE START-UP OF PRODUCTION.

### Drying Times:

	<b>Room Temperature (68°F)</b>
<b>Tack Free Time:</b>	20 – 30 minutes
<b>Dry to Handle:</b>	Approximately 4 hours
<b>Dry to Stack:</b>	Overnight (Complete curing is obtained after 7 days air dry.)

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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