

Product Code:
432-1220

VISCOSITY: Z #2/24" at 77°F
FLASH POINT: 24°F (-4°C)
DENSITY (lb/gal): 7.8
SOLID (% by weight): 31%
SOLID (% by volume): 23%
SHELF LIFE (months): 12

Product Description: Danseal is a high solids modified Reactive Amino Coating (RAC) Danseal provides good clarity, fast dry and excellent sanding characteristics.

Uses: Danseal is specifically made for use under Danspeed (432-62XX), Danspeed Elite (424-44XX), Plastofix Light (421-48XX) and Plasticlear (421-40XX).

Environmental Data (as supplied):

VOC less exempt lb/gal:	<5.20
VOC lb/gal:	<4.47
VOC less exempt g/l:	<625
VOC g/l:	<540
VOC lb/lb Solid:	<1.85
VHAPs lb/lb Solid:	<0.7

Application Data:

SUGGESTED USES:	Sealer
MIXING RATIO:	100 parts 432-1220 to 7 parts 873-0870
POT LIFE:	12 hours
APPLICATION VISCOSITY:	Z # 2/20 – 25"
REDUCER:	803-1325
RETARDER:	800-5328
CLEAN-UP SOLVENT:	803-1298
RECOMMENDED WET FILM:	3 – 5 mils
COVERAGE:	385 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.



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Directions for Use

Surface Preparation: Substrate must be sanded using 120, 150 or 180 grit steared paper prior to staining or coating. Sealers should be sanded with 240, 280 and 320 grit steared paper prior to being coated. Stain systems used under acid catalyzed systems should be acid stable. Akzo recommends 825-80XX C-mix stains, or 890-85XX N.G.R. stains. Danseal cannot be used on metal, old oil or cellulose lacquers.

General information: Agitate material thoroughly before use. Always mix Danseal while adding catalyst in the recommended mixing ratios. Apply and allow to dry for one hour. Scuff sand with 220 to 280 grit steared paper before topcoating to ensure good adhesion and a smooth finish. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Danseal must not be used and dried at temperatures below 64°F or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

Maximum film build of Danseal should not exceed 2 mils dry. Maximum film build of total coating system must not exceed 4 mils dry.

Contact with metal surfaces should be avoided.

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:

	At 68°F	At 122°F
Tack Free Time:	15 – 20 mins.	Flash off before entering oven
Dry to Sand:	1 hour	20 – 30 mins.
Dry to Stack:	8 hours	40 – 45 mins.

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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