



**117-25XX CHEMLIFE® 24 PLUS White CV Pigmented TC**

<b>Product Codes:</b> 117-2505 Flat 117-2510 Matte 117-2520 Low Gloss 117-2535 Satin 117-2550 Semi-Gloss 117-2590 High Gloss	<b>Viscosity:</b> Zahn #3 signature cup 23-25 sec at 77°F <b>Flash Point:</b> 53.6°F (12°C) <b>Density (lb/gal):</b> 9.33 <b>Solid (% by weight):</b> 59.91% <b>Solid (% by volume):</b> 44.8% <b>Shelf Life (months):</b> 12
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**Product Description:**  
 CHEMLIFE 24 PLUS White Topcoat is an acid curing, light stable, fast drying Reactive Amino Coating (RAC) with good building properties. It gives a smooth, knock-proof and hardwearing surface resisting influence from alcohol, water, etc. Due to its 24 hour pot-life, CHEMLIFE 24 PLUS White Topcoat provides the customer with minimum waste resulting in lower production costs. It also provides very good light stability based on the type of resin used and superior vertical hang.  
 Special Recognition: When applied as specified, will meet required performance for the ANSI/KCMA A161.1 1990 9.0 Finish Test. Recommended: Architectural Woodwork Institute (AWI) System 5.

**Uses:**  
 This product is used as the final coat over wood, plywood, chipboard, etc., meant for interior use. This product is recommended for kitchen cabinets, high build office or residential furniture as well as many other interior wood applications where high build and durability are required.

<b>Environmental Data (as supplied):</b>	<b>VOC less exempt lb/gal:</b> <3.74 <b>VOC lb/gal:</b> <3.74 <b>VOC less exempt g/l:</b> <449 <b>VOC g/l:</b> <449 <b>VOC lb/lb Solid:</b> <0.67 <b>VHAPs lb/lb Solid:</b> <0.12
<b>Note:</b> See individual compliance sheets for specific data	

<b>Application Data:</b>	<b>Suggested Uses:</b> Wood Finish <b>Mixing Ratio:</b> 100 parts 117-25XX to 10 part 873-1251 <b>Pot Life:</b> 24 hours <b>Application Viscosity:</b> Zahn #3 signature cup 23 – 25 seconds <b>Reducer:</b> 803-1325 <b>Retarder:</b> 800-5328 <b>Clean-up Solvent:</b> 803-1298 <b>Recommended Wet Film:</b> 5 mils <b>Coverage:</b> 719 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.
<b>Note:</b> N/A	

# 117-25XX CHEMLIFE® 24 PLUS White CV Pigmented TC

## Directions for use:

### Surface Preparation:

Primer should be sanded using 240 and 320 grit steared paper. Suitable primer is CHEMLIFE 24 PLUS White Primer 522-2500. The primer should be topcoated within eight hours of sanding. Care should be taken during sanding to avoid sanding through the primer.

### General Information:

Catalyze and reduce the material as recommended. CHEMLIFE 24 PLUS White Topcoat is applied in one or two coats and can be used on all kinds of wood meant for interior use.

A thorough sanding between the coats is essential to the adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded. CHEMLIFE 24 PLUS White Topcoat cannot be used on metal, old oil or cellulose lacquers.

Total recommended film build of CHEMLIFE 24 PLUS White Primer 522-2500 and CHEMLIFE 24 PLUS White Topcoat 117-25XX is not to exceed 6 mils dry. Over the primer, the topcoat should not exceed 4 mils dry.

To ensure proper sheen, the catalyzed material should be agitated at all times. Chemlife 24 Plus White must be thoroughly stirred while adding catalyst and thinner in the recommended mixing ratio. Contact with metal surfaces should be avoided once the Chemlife 24 Plus White has been catalyzed.

CHEMLIFE 24 PLUS White Topcoat must not be polluted with oil, varnish or the like and must not be sanded with steel wool between coats. CHEMLIFE 24 PLUS White Topcoat must not be used and dried at temperatures below 65°F (18°C) 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.

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:

	Room Temperature (68°F)	Forced Drying Schedule (122°F)
<b>Tack Free Time:</b>	15 – 20 minutes	Flash off before entering oven
<b>Dry to Sand:</b>	3 hours	1 hour
<b>Dry to Stack:</b>	Overnight	3 hours

### Note:

N/A

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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