MAB S.p.A. Industrie Chimiche

TECHNICAL DATA SHEET - TDS

PRODUCT CODE

OPP 80 series

October 2008

GENERAL INFORMATION

OPP 80 series includes high cover white PU top- coats for panelling, furniture, interior doors.
OPP 80 has particularly high hiding power, excellent surface hardness and good thixotropy.

For futher queries:

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CHEMICAL - PHYSICAL CHARACTERISTICS

Viscosity

Part A

method: *DIN 8* — *31" ±* 3"

Parts A + B

method: *DIN 4* — *18" ±* 3"

Solids

PART A	*70* **%** ± *1* %
PARTS A + B	*55* **%** ± *1* %

Density

1,330 g/cm^3 ± 0,03 g/cm^3

Packaging

metal

Shelf life

12 months

Hardener shelf life

6 months

Drying: room T (20°C - 68°F)

DRYING	TIME
dust free	*20'*
touch dry	*70'*
completely dry	*10 h*

Pot life

Parts A +B — *> 5 h*

Surface hardness

Excellent

Chemical resistance

Good

Resistance to weather

Unsuitable

Yellowing

with CATALYST	RESULTS
CAT 66	*Typycal of PU*
CAT 225	*Good*

MIX

-	PART A (%)	CATALYST (%)	ACCELERANT (%)	THINNER (%)	ADDITIVES (%)	NOTES
1	*OPP 80 (100)*	*CAT 66 (50)*	*-*	*DLT 10 (10 to 30)*	*-*	*Yellowing system*
2	*OPP 80 (100)*	*CAT 225 (50)*	*-*	*DLT 10 (10 to 30)*	*-*	*Anti-yellowing system*
3	*OPP 80 (100)*	*CAT 225 (50)*	*-*	*DLT 10 (20 to 40)*	*ADT 34 (2 to 3%)*	*Electrostatic application*

- For slower drying, and in order to avoid the connected problems, use DLT 14 in the same amount.
- Catalyst ratios are calculated by weight and not by volume, as the specific weight of OPP 80 is higher than 1.

APPLICATION

☑ SPRAY ☑ AIRLESS ☐ ELECTROSTATIC ☑ CURTAIN COATER

☐ ROLLER ☐ IMMERSION ☐ BRUSH ☐ FLOW COATING

APPLICATION	*spray*	*airless*	*curtain coater*
1st coat (g/m^2)	*120/150*	*120/150*	*120/150*
2nd coat (g/m^2)	*-*	*-*	*-*
Tot. max applicable (g/m^2)	*150*	*150*	*150*
Thinner	*30 to 40%*	*30 to 40%*	*0 to 5%*

RECOMMENDED CYCLES

Surface: SOLID WOOD, MDF (PU SYSTEM)

STEP	PRODUCT	COATS
BASE COAT	*FPP 15, FPP 40*	*2 - 3*
SANDING	*grain 240 - 320*	*-*
TOP COAT	*OPP 80*	*1*

Surface: MDF, SOLID WOOD (PE SYSTEM)

STEP	PRODUCT	COATS
BASE COAT	*PKP 24, PKP 26*	*2 - 3*
	grain 240 - 320	*-*
TOP COAT	*OPP 80*	*1*

ADDITIONAL INFORMATION

- Do not apply directaly on the wood.
- It cannot be used in cycles requiring rapid stacking.

CODE	MATTING GRADE (±2)
OPP 80	*matt (20 gloss)*
OPP 81	*medium matt (30 gloss)*
OPP 82	*satiny (40 gloss)*
OPP 83	*medium stiny (50 gloss)*
OPP 84	*medium gloss (60 gloss)*

CODE	MATTING GRADE (±2)
OPP 85	*medium gloss (70 gloss)*
OPP 86	*medium gloss (80 gloss)*
OPP 87	*deep matt (15 gloss)*
OPP 88	*depp matt (10 gloss)*
OPP 89	*deep extra matt (5 gloss)*

All data are average test results at lab conditions (room condition 20°C and 70% relative humidity). The information provided concerning methods of use and the results obtained are based on our lab test experimentation of practical applications, while we accept no liability and provide no warranty for any single application. Users are therefore always strongly advised to carry out preliminary tests to confirm that the product is suitable for the specific situation. Our Technical Service is always happy to assist the clientele for all requirements