



DuoCryl Compact

Technical Information

- Characteristics:** Very good light fastness, good filling properties and sandability are the main characteristics of this fast drying 2-component clearcoat based on polyacrylate resin. A perfect result can only be achieved by carrying out the following instructions.
- Area of application:** Perfect for a resistant refinishing of woods used for furniture and interior fitting.
- Substrates:** Dried, cleaned, resin-free wood; and in case of stained substrates, perfectly dried and clean surfaces. The substrate must be solid. Also suitable for bleached woods.
- Hardener:** **DuoCryl Härter**
- Mixing ratio:** 10 units lacquer : 1 unit hardener by weight or by volume
- Pot life:** Max. 24 hours at 20°C and 65% relative air humidity.
Exceeding the pot life may cause surface defects.
Attention: Higher material and ambience temperatures reduce the pot life.
- Processing:** **DuoCryl Compact** is applied by spraying (gravity spray gun, Airless, Airmix).
- | Application: | Airless | Airmix | gravity spray gun |
|------------------|-------------------|-------------------|-------------------|
| Spray pressure: | 60 - 80 bar | 50 - 60 bar | ---- |
| Air pressure: | ---- | 1.5 – 2.0 bar | 1.5 – 2.5 bar |
| Nozzle size: | 0.22 – 0.33 mm | 0.22 – 0.33 mm | 1.8 – 2.0 mm |
| Spray viscosity: | approx. 25 s/4 mm | approx. 25 s/4 mm | approx. 25 s/4 mm |
- Depending on the spray gun in use, deviations concerning spray pressure, air pressure and nozzle size must be considered. The application temperature should not fall below +18°C. This also applies to the substrate.
- Dilution:** **DuoCryl Compact** mixed with **DuoCryl Härter** is a sprayable compound. Depending on the application mode and if necessary, it can be thinned with **DD-Verdünnung Nr. 20**. Use **DD-Verdünnung Nr. 25** (max. 5%) to retard the drying.
- Spreading rate:** Applied quantity: approx. 100-120 g/m² and layer.
Approx. 8-10 m²/l per layer depending on the absorptivity of the wood and application.
- Drying time:** Depending on the application mode and the applied quantity at room temperature (20°C/65% relative air humidity):
- set to touch after 30 minutes
- sandable and recoatable after approx. 2 hours
- Gloss level:** 34 = satin matt, 45 = matt
- Primer and topcoat:** **DuoCryl Compact** is used as primer as well as topcoat. In case of expected higher stress conditions, we recommend applying a third layer of **DuoCryl Compact** after an intermediate sanding.

Please turn over!

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- Cleaning of tools:** Waschlöser Nr. 52 and PUG Pinsel- u. Gerätereiniger.
- Storage:** DuoCryl Compact can be stored 3 years in unopened original container, the hardener for 2 years.
- Special remarks:** Even if the surfaces treated with DuoCryl Compact are dry and stackable after a short time, the required chemical and mechanical resistance is only achieved after a drying time of 5-7 days (at 20°C/65 % relative humidity).
- Tested according to:
DIN 53160-1/-2: salvia- and sweat-resistant.
DIN 68861-1 (Behaviour at chemical influence): stress group 1B.
- Please consider:** The product and the recommendations in this technical data sheet correspond to today's state of the art. Our oral and written application recommendations, that are based on years of experience and provided to the best of knowledge, are non-committal and do not establish a contractual relationship and secondary obligation of the sales contract. They do not release the user from his obligation to verify on his own responsibility the existing substrate and the suitability of our products for the intended purpose. In case of doubt, suitability and spreading rate are to be tested by creating a sample. If our products are combined or intermixed with third-party products, we cannot guarantee a perfect surface finish. Our general terms and conditions apply.

This technical data sheet replaces all previous versions.

Edited 1/20