



# DuoCryl HF

## Technical data sheet

- Characteristics:** Fast drying two-component lacquer based on polyacrylate resin with excellent light fastness and outstanding filling properties.  
A perfect result can only be achieved by carrying out the following instructions.
- Area of application:** For a resistant refinement of woods used for upscale furniture construction and interior fitting as well as for the contract sector.
- Substrates:** Dry, clean, resin-free woods, and if stained, perfectly dry and clean surfaces. Also suitable for bleached woods.
- Hardener:** **DuoCryl Härter**
- Mixing ratio:** 10 units lacquer : 1 unit hardener by weight or by volume
- Pot life:** Max. 8 hours at 20°C/65% relative air humidity.  
Exceeding the pot life may cause surface defects.  
Attention: Higher material and ambient temperatures reduce the pot life.
- Processing:** **DuoCryl HF** is applied by spraying ( gravity spray gun, Airless, Airmix).
- | Application:           | Airless           | Airmix            | Gravity spray gun |
|------------------------|-------------------|-------------------|-------------------|
| Spray pressure:        |                   |                   |                   |
| Air pressure:          | 60 - 80 bar       | 50 - 60 bar       | ----              |
| Nozzle size:           | ----              | 1.5 - 2 bar       | 2.5 – 3.5 bar     |
| Application viscosity: | 0.22 – 0.33 mm    | 0.22 – 0.33 mm    | 1.8 – 2.0 mm      |
|                        | approx. 28 s/4 mm | approx. 28 s/4 mm | approx. 28 s/4 mm |
- Depending on the spray gun in use, deviations concerning spray pressure, air pressure and nozzle size can occur. The temperature for application should not fall below +18°C. This applies also to the substrate. Unsuitable for rolling and brushing. The viscosity of the product needs to be adapted for application by curtain coater.
- Dilution:** **DuoCryl HF** mixed with **DuoCryl Härter** is a sprayable compound. Depending on the type of application and need it can be thinned with **DD-Verdünnung Nr. 20**. Use **DD-Verdünnung Nr. 25** (max. 5%) to retard drying.
- Spreading rate:** Applied quantity : Approx. 100-110 ml/m<sup>2</sup> and layer.  
Approx. 9-10 m<sup>2</sup>/l per layer depending on the absorptivity of the wood and the application method.
- Drying time:** Depending on the mode of application and the applied quantity at room temperature (20°C/65% relative humidity):  
- set to touch after 30 minutes  
- sandable and recoatable after approx. 2 hours
- Gloss level:** 4 = semi-matt, 45 = matt

Please turn over!

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- Primer and topcoat:** DuoCryl HF can be used as primer as well as topcoat. In order to obtain higher stress resistance a third coat of DuoCryl HF can be applied after an intermediate sanding.
- Cleaning of tools:** Waschlöser Nr. 52 and PUG Pinsel- u. Gerätereiniger.
- Storage:** DuoCryl HF can be stored for at least 3 years in closed original container and the hardener at least 2 years.
- Special remarks:** Even if the surfaces treated with DuoCryl HF are dry and stackable after a short time, the required chemical and mechanical resistance is only achieved after a curing time of 5-7 days (at 20° C/65 % relative humidity).



DuoCryl HF

Baustoffklasse  
DIN 4102-B1  
schwerentflammbar auf  
Holzspanplatte mit dem  
Brandverhalten  
DIN 4102-B1

Tested according to:

**DIN 68861-1** (Behaviour at chemical influence):  
Stress group 1B.

**DIN 68861-2** (behaviour at abrasion stress): Stress  
group 2C.

**DIN 53160-1/-2:** saliva- and sweat-resistant.

- 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.

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