



RUDD COMPANY, INC
Manufacturers of Quality Coatings Since 1912

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PRE-CATALYZED LACQUER

Pro 680 VOC WATER CLEAR PRE-CATALYZED LACQUER

Product Code: **651962**

Pro 680 VOC Clear Lacquer is an economical water clear pre-catalyzed lacquer ideal for interior wood surfaces.

Ideal for

- Doors & Millwork
- Casegoods
- Interior Wood Work

- Federal AIM compliant at 680 g/l VOC
- NESHAP compliant—JJ (furniture)

Benefits

- Water Clear
- Good abrasion resistance
- Low odor
- Excellent flow and leveling
- Excellent sanding properties

APPLICATION DATA

SURFACE PREPARATION: “White sand” wood with maximum 150 grit aluminum oxide sandpaper. Remove all sanding dust. Keep free of dirt, grease, silicone oils, lubricants and other contaminants.

APPLICATION EQUIPMENT: This product is designed for spray application through all types of application equipment.

THINNING: No thinning required. This product is designed to spray at package viscosity with all application equipment. If thinning is desired, use Acetone.

Caution: Thinning with solvents will reduce film build and increase VOCs (unless using Acetone). Note: Thinning requirements may vary with changes in temperature and spray room conditions.

AGITATION: This product must be kept under slow, constant agitation, to ensure proper mixing and to prevent sheen variations.

CLEAN UP: Use acetone or VOC compliant lacquer thinner.

FINISHING SYSTEM

STAIN: When staining wood, use Rudd ColorTools™ Dye Stains, ColorTools™ Spray Only Stain, or ColorTools™ Wiping Stain.

SEAL: Apply one coat (3 -4 mils wet) of Pro 680 VOC Clear Lacquer as it's own sealer. Allow to dry 15 minutes*, sand with 220/320 grit silicon carbide sandpaper before finishing.

FINISH: Apply two coats (4—6 mils wet) of Pro 680 VOC Clear Lacquer. Allow 15 minutes* dry time and sand with 220/320 grit silicon carbide sandpaper between coats.

If desired, additional coats may be applied up to a total dry film of 5.0 dry mils.

*Dry times will vary with film thickness, temperature, humidity and air movement.

SAFETY PRECAUTIONS

Avoid breathing vapors, use a NIOSH approved cartridge respirator. Use pre-filters to avoid breathing spray particles or sanding dust.

Flammable Liquid: Keep away from heat, sparks and flame. Ensure adequate ventilation during use.

Read Material Safety Data Sheet and label before using.

AVAILABLE SHEENS*

Gloss	High Semi-Gloss	Semi-Gloss	Satin	
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KCMA FINISH TEST

Vinegar	No Visual Effect
Lemon Juice	No Visual Effect
Orange Juice	No Visual Effect
Grape Juice	No Visual Effect
Catsup	No Visual Effect
Olive Oil	No Visual Effect
100 Proof Alcohol	No Visual Effect
Coffee	No Visual Effect
Water Ring	Slight marking at 190° F after 30 minutes
Edge Soak	Passed 24 hr KCMA test with no softening, discoloration or film defects

SPECIFICATIONS

Coverage	230 square feet per gallon @ 1 mil dry film thickness
Viscosity	28–33 seconds (#2 Zahn Cup @ 77°F)
Sag Resistance	5 mils vertical @ 65–70°F
Solids*	19.7–20.1% by weight 1.46–1.49 lbs per gallon
VOCs* (Volatile Organic Compounds)	Calculated: 5.65–5.66 lb/gal 677–679 g/l
HAPs* (Hazardous Air Pollutants)	Pounds HAP per Pounds Solid: 0.24–0.25
Dry to Sand	15 minutes @ 65–70°F
Block Free	6 hours @ 65–70°F
*Variations depend on gloss CAUTION: Thinning will reduce film build and increase VOCs.	

*Call for current Stock Sheens and Package Sizes.

APPLICATION PRECAUTIONS

- Pro 680 VOC Clear Lacquer has a limited shelf life of approximately 6 months from date of manufacture.
- Usability and performance may not be determined from viscosity. Shelf life will vary with storage conditions.
- Do not use Pro 680 VOC Clear Lacquer as a topcoat over stearated sanding sealers. Formulated for use as a self-seal system.
- Do not use Pro 680 VOC Clear Lacquer in heated spray equipment.
- This product is not recommended for exterior use.
- Clear finishes will not prevent natural (unstained) wood from changing color over time.
- Finish, substrate and curing temperatures should remain above 60° F, extremes of temperature and humidity may affect product performance.
- Total film build of system must not exceed 5.0 dry mils.
- This product has been tested on a limited number of substrates and over a limited number of coatings. The user is responsible for testing suitability and performance for their specific application.
- Designed for professional use by spray application only

Shipping & Storage Information

Flash Point: -4° F Pensky-Martin

OSHA Flammability Class: Flammable Liquid—Class IB

DOT Class: Paint, 3, UN 1263, PG II



Rudd Company, Inc. · 1141 NW 50th St. · Seattle, WA 98107
ruddcompany.com · 206-789-1000

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