

ChromaCat™ 680 Clear Tint Base

OPAQUE PRE-CATALYZED LACQUER

Product Code: **652065**

ChromaCat™ 680 Clear Tint Base is a ready to use, pre-catalyzed lacquer utilized for tinting dark opaque custom colors and is ideal for all interior wood surfaces.

Ideal for

- Doors & Millwork
- Cabinets and Caseworks
- Fixtures & Displays
- Interior Wood Surfaces
- Meets KCMA performance tests
- Federal AIM compliant 680 g/l VOC
- NESHAP compliant—JJ (furniture)
- NESHAP compliant—QQQQ (doors & windows)

Benefits

- Excellent color stability
- Exceptional abrasion resistance
- Excellent water and chemical resistance
- Low odor
- Superior flow, leveling and sandability
- User friendly in broad range of environmental conditions
- Super-Low HAPs

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 equipment. Recommended settings are with trigger pulled:

Airless	No thinning required. Spray at 1000 to 1200 psi 411 or 513 tip
Air Assist	No thinning required. Spray at 700 to 900 psi fluid pressure 10 to 12 psi air cap 411 or 513 tip
HVLP	Thin 10-20% with recommended thinner. Spray at 28 psi through a 1.4 fluid nozzle.

THINNING: This product is designed to spray at package viscosity with most application equipment. Thinning requirements may vary with changes in temperature and spray room conditions. If thinning is desired, use 650870 Premium Lacquer Thinner, 652081 VOC Exempt Lacquer Thinner, 652210 No-HAP Lacquer Thinner or Acetone.

Note: Thinning will reduce film build and may increase VOCs or HAPs, unless using VOC Exempt or HAP-Free solvents.

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

CLEAN UP: Use lacquer thinner compliant with local air quality rules and regulations.

FINISHING SYSTEM

SEAL: Apply one coat (4-6 mils wet) of ChromaCat Opaque White Sanding Sealer, or use ChromaCat 680 Clear Base, tinted to the desired color, as it's own sealer. Allow to dry 20-25 minutes*, sand with 220/320 grit silicon carbide sandpaper before finishing.

FINISH: Apply two coats (4-5 mils wet) of ChromaCat 680 PreCat Clear Base tinted to desired color. Allow 25 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 may 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. Clean up spills with non-sparking tools and inert absorbent material. Store solvent and lacquer soaked rags and filters water-filled container prior to disposal. Dispose of in a safe, approved manner.

Read Material Safety Data Sheet and label before using.

FINISH PERFORMANCE TESTING

KCMA

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	Leaves detectable mark
Hot Coffee	No Visual Effect
Edge Soak	Passed 24 hr KCMA test with no softening, discoloration or film defects
Cold Check	Passed 20 cycles @ 5 mils dry film

OTHER

Pencil Hardness	Pass 2B
Mar Resistance	Very Good
Adhesion	Excellent

Note: Exceeding recommended colorant loads may affect KCMA test results.

SPECIFICATIONS

Coverage	285 square feet per gallon @ 1 mil dry film thickness
Viscosity	28-32 seconds (#2 Zahn Cup @ 77° F)
Sag Resistance	5 mils vertical @ 65-70° F
Solids*	26.3-27.4% by weight 2.04-2.14 lbs per gallon
VOC* (Volatile Organic Compounds)	Calculated: 662-667 g/l (5.52-5.56 lb/gal)
HAP* (Hazardous Air Pollutants)	Pounds HAP per Gallon: 0.058 Pounds HAP per Pounds Solid: < 0.8 (actual 0.027-0.028) Pounds HAP per Volume Solids: < 0.48 (actual 0.294-0.302)
Dry to Sand	25 minutes @ 65-70° F
Block Free	24 hours @ 65-70° F
*Variations depend on gloss and amount of colorant/dye. CAUTION: Thinning will reduce film build and may increase VOCs and HAPs unless using VOC Exempt and/or HAP-free thinner.	

APPLICATION PRECAUTIONS

- ChromaCat 680 Tint Base has a limited shelf life of approximately 12 months unopened, from date of manufacture.
- Usability and performance may not be determined by viscosity. Shelf life will vary with storage conditions.
- Do not use ChromaCat 680 Tint Base as a topcoat over steared primer. Use ChromaCat 680 Opaque Sanding Sealer, or use ChromaCat 680, Tint Base, tinted to the desired color, as it's own sealer.
- Total film build of finishing system must not exceed 5.0 dry mils.
- Do not use ChromaCat 680 Clear Tint Base in heated spray equipment.
- ChromaCat 680 Clear Tint Base may be tinted to a maximum of 8 fl. oz. per gallon with Colortools™ Colorants, or high quality industrial colorant dispersions, such as 844.
- Dry time, block-free time, mar resistance and KCMA tests results may be altered if tints exceed maximum colorant recommendation. Always test for suitability of intended use.
- This product is not recommended for exterior use.
- Finish, substrate and curing temperatures should remain above 60°F, extremes of temperature and humidity may affect product performance.
- 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 Pinsky-Martin

OSHA Flammability Class: Flammable Liquid—Class IB

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



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