TECHNICAL DATA SHEET

supersedes previous issue dated 28/11/01

TL 335/ABC

PIGMENTED HIGH GLOSS POLYURETHANE TOPCOAT

Colours available:	**hiding pigments** A1 - white A2 - ochre A5 - black A8 - brick red	**semi-transparent pigments** B2 - red B3 - amaranth B5 - violet B6 - dark blue B8 - green B9 - violet C4 - lemon yellow C7 - golden yellow C9 - orange	**pigments containing lead** A9 - orange B4 - lemon yellow B7 - golden yellow
Areas of use:	Flat panels and profiles		
Method of use:	Airmix and airless spray, curtain coater		
Mixing Procedure:		by weight	by volume
Part A:	TL 335/ABC	100	
Part B (hardener):	TH 735	70	see Table 1
Thinner:	DT 424	5-30	

Technical Information

Solid content % (w/w):	Part A: see Table 1 Part B: 46 ± 1
Specific gravity:	Part A: see Table 1 Part B: 0.998 ± 0.030
Viscosity (DIN 4 at 20°C):	See Table 1
Pot-life (at 20°C):	5 hours
Recommended application weight (g/m²):	100 min. - 200 max.
Drying time (100 g/m² at 20°C)	Dust-Free : 25' Touch-Dry : 6 hours Stackable : 72 hours
Shelf-life:	If the product is properly stored, shelf-life is unlimited. After long periods of storage, always check homogeneity and stir well before use to eliminate any possible sediment.

Preparation of the substrate

Pigmented polyester or polyurethane basecoats.

General characteristics

TL 335/ABC is a high gloss topcoat showing very good flow, satisfactory vertical application, good solvent release.
It is suitable for finishing kitchen doors, frames, flat panels, etc.
It can be applied in one single coat or in two coats wet on wet with 1-4 hours interval.
It can be polished after 3 days.
In summertime or in tropical areas add thinners such as DT 41, DT 441, XT 403 in the amount of 5-10%.

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Alternative hardeners

- TH 733 at 70% to increase drying time and build in dark colours
- TH 724 at 100% for fast drying and stackability after 18-24 hours. The build is lower, for this reason it is advisable to spray two coats. Good yellowing resistance.

Special Instructions

In wintertime make sure that the paint and the application temperature are kept above 18°C and increase hardening ratio even up to 100%.
TL 335/ABC contains organic or inorganic pigments, according to the colour (see Table 2).
The colours based on organic pigments are slower drying, have lower hardness and lower hiding power, if compared to the ones based on inorganic pigments.
It's important to notice that some colours, when blended with white for achieving pale shades have reduced light fastness (the paler the shade the poorer the light fastness). On the contrary, when used alone or blended in dark shades, light fastness is good.
For colours requiring the black, use TL 335/A5 only, since it has been expressely formulated for mixtures (TL 335/57 is not suitable).
All TL 335/ABC colours are perfectly intermixable in the WOOD-COLOR system.
It is not sufficient to shake the can before using. The contents must be stirred thoroughly.
TL 335/ABC pigmented topcoats are not suitable for outdoor use.

Problem of colour alteration with light

White and lighter shades are liable to undergo colour change over time. Equipment exists for determining to a good degree of accuracy how long it will take for the colour of coatings to change and the extent of the change. End users should have the light fastness of these pigmented topcoats evaluated to determine whether or not they are suitable for their requirements. Arch laboratories can carry out this assessment with the utmost objectivity, although it would be even better for the user to contact an independent testing laboratory.

TABLE 1

Colour	Solid Content (% ± 2)	Specific Gravity (kg/lt ± 0.030)	Viscosity (DIN 4 at 20° C)	% of hardener	
				by weight	by volume
A1 WHITE	71	1.349	250" ±5"	70	100
A2 OCHRE	62	1.159	135" ± 5"	70	85
A5 BLACK	54	1.206	145" ± 5"	70	85
A8 RED OXIDE	62	1.196	135" ± 5"	70	85
A9 ORANGE	63	1.191	130" ± 5"	70	85
B2 RED	54	1.029	150" ± 5"	70	70
B3 AMARANTH	54	1.026	85" ± 5"	70	70
B4 LEMON YELLOW	66	1.292	135" ± 5"	70	90
B6 BLUE	53	1.026	120" ± 5"	70	70
B7 GOLDEN YELLOW	66	1.263	135" ± 5"	70	85
B8 GREEN	54	1.037	75" ± 5"	70	70
B9 VIOLET	54	1.018	85" ± 5"	70	70
C4 YELLOW	62	1.290	135" ± 5"	70	90
C7 GOLDEN YELLOW	55	1.200	135" ± 5"	70	84
C9 ORANGE	55	1.190	130" ± 5"	70	83

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TABLE 2

Chemical nature	Hiding power	Light fastness	
		Alone	Blended with White
A1 Inorganic	Excellent	Excellent	--
A2 Inorganic	Excellent	Excellent	Excellent
A5 Organic	Excellent	Excellent	Excellent
A8 Inorganic	Excellent	Excellent	Excellent
A9 Inorganic	Excellent	Good	Good
B2 Organic	Poor (1)	Good	Poor (2)
B3 Organic	Poor (1)	Good	Poor (2)
B4 Inorganic	Poor (1)	Good	Good
B6 Organic	Poor (1)	Excellent	Excellent
B7 Inorganic	Fair(1)	Good	Good
B8 Organic	Poor (1)	Excellent	Excellent
B9 Organic	Fair (1)	Excellent	Excellent
C4 Organic	Fair (1)	Good	Good
C7 Organic	Poor (1)	Good	Good
C9 Organic	Poor (1)	Good	Good

(1) When these colours are used alone, apply more than one coat, preferably on a basecoat of a similar shade.

(2) In order to prepare pastel colours, A8 OXIDE RED should be used.

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