

TECHNICAL DATA SHEET

supersedes previous issue dated 09/09/97

TL 335
CLEAR HIGH GLOSS POLYURETHANE TOPCOAT

Area of use:	Flat parts, fitted furniture, turned parts, picture frames.		
Method of use:	Airmix and airless spray guns; curtain coater.		
Mixing procedure:		by weight (kg)	by volume (l)
	Part A	TL 335	100
	Part B (hardener)	TH 760	100
	Thinner	DT 424	10-20

Technical characteristics:

Solids content (%):	Part A:	48 ± 1
	Part B:	42 ± 1
Specific gravity (kg/l):	Part A:	0.983 ± 0.030
	Part B:	1.012 ± 0.030
Viscosity (DIN 4 at 20°C):	Part A:	28" ± 3"
	A + B:	16" ± 3"
Pot-life at 20°C:	6 hours	
Recommended application weight (g/m ²):	Max. 200	
Drying time (100 g/m ² at 20°C):	Dust free	20'
	Touch dry	6 hours
	Stackable	48 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.	

Substrate preparation

Preferably with a polyester basecoat.

General characteristics

TL 335 is a clear gloss topcoat with excellent wettability and flow combined with good thixotropy and solvent release. It is suitable for coating fitted furniture, coffins, picture frames, etc. Coating systems can consist of a single coat, two coats wet-on-wet 1-4 hours apart, or two coats 24 hours apart without problems of stratification.

Alternative hardeners

- TH 721 at 100% for systems requiring a very high build (e.g.: coffins). The hardener is not recommended for buffing and has poor non-yellowing properties. Thin with 10-30% DT 424.
Solids contents: 44 ± 1
Specific gravity: 1.000 ± 0.030
- TH 724 at 100% when extremely fast drying is required. Stackable after 16 hours, buffable after 24 hours, at the expense of build. The mixture with 100% hardener is ready for curtain coater application. Add 5-20% thinner for spray application. TH 724 has good non-yellowing properties.
Solids contents: 31 ± 1
Specific gravity: 0.950 ± 0.030
- TH 733 at 70-100% for maximum film hardness and curtain coater application.
Solids contents: 49 ± 1
Specific gravity: 1.015 ± 0.030
- TH 735 at 70-100% for good wettability, build and yellowing resistance; drying is slower than with TH 733.
Solids contents: 44 ± 1

N.B.: Data provided on this Technical Data Sheet correspond to our best knowledge and experience. We assure consistency on the chemical-physical characteristics of our products, within the tolerance limits specified on our Technical Data Sheets. Responsibility of final result of product application is fully up to the users, who shall make sure that the product corresponds to their own needs with regard to application system, to substrates used as well as to working conditions.

WARNING: Actual viscosity of some pigmented and/or thixotropic products may differ from the viscosity shown on the Technical Data Sheet. Differences are to be regarded as acceptable if within 30% maximum.

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- Specific gravity: 0.998 ± 0.030
- TH 738 at 100% of when fast drying is required for stacking after 24 hours and buffing after 48 hours. Limited light fastness
- Solids contents: 39 ± 1
- Specific gravity: 1.003 ± 0.030

With very light coats, reduce the percentage of hardener and add more thinner to compensate viscosity.

During the summer, or in tropical areas, add 5-10% of slow-drying thinner XT 403 or DT 441.

Special instructions

In winter make sure that the temperature of the coating and the environment are not lower than 18°C.

If light tinting is required, use XC 1900/XX stains. If faster drying is required, 2% of additive XT 4031 can be added at the expense of pot-life (reduced to about 3 hours).