

**WC24**
**SOLVEN-BORNE ACID CATALYSED PAINT SYSTEM FOR WOODEN FURNITURE**
**DICCOPLAST PRIMER  
DICCO CRYSTAL 30**

Solvent -borne acid catalysed system WC24 is all around paint system for interior wooden doors, chairs, furniture etc.

Diccoplast Primer is two-component acid catalysed primer. It is very fast drying and easy to sand. The primer has high solid content, good filling properties and good hiding power.

Dicco Crystal 30 is two-component acid catalysed top coat. The color of the paint is pure white and paint has minimal tendency for yellowing. It has good chemical and scratch resistance and it is especially suitable for fast production lines.

**Typical paint system**

Treatment	Product	Application method	Wet film thickness
Priming	1-2 x Diccoplast primer	Spraying	100-150 g/m <sup>2</sup>
Top coat	1x Dicco Crystal 30	Spraying	100-120 g/m <sup>2</sup>

**PRODUCT PROPERTIES**

<b>Solid Content</b>	53 volume-%, 71 weight-%	(694 0201)
	60 volume-%, 74 weight-%	(960 6535)
<b>Specific gravity</b>	1,4 kg/l	(694 0201)
	1,3 kg/l	(950 6535)
<b>Paint hardener mixing ratio</b>	694 0201 : 006 2098	100:10
	950 6535 : 006 2098	100:10

**Drying times**

	100–120 /m <sup>2</sup>	+23°C	+50°C
Diccoplast Primer	Dry to sand	1-2 h	30-40 min
	Dry to stack	1-2 h	30–40 min
Dicco Crystal30	Dry to sand	2-3 h	25-35 min
	Dry to stack	3-4 h	35-45 min

Stacking temperature below +35°C.

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

<b>Gloss</b>	Semi-matt
<b>Color</b>	TAL, White 0201
<b>Application methods</b>	Spraying
<b>Thinner</b>	Thinner 1035 (fast), 1058 (normal)
<b>Cleaning of equipment</b>	Thinner 1035, 1058

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<b>SURFACE PREPARATION</b>	Dirt, dust and other unfamiliar material must be removed from the surface. Wooden material should be sanded before application with paper grain size 150 – 240. All sanding dust must be removed before application.
<b>APPLICATION CONDITIONS</b>	During application and drying the temperature of the air, paint and surface should be at least +18 °C. The relative humidity should not exceed 70 %. Good ventilation is needed during drying process.
<b>APPLICATION</b>	<p>Stir the Diccoplast Primer well and add 10 % by volume of hardener 006 2098 and mix well again. Thin the paint to the proper application viscosity with thinner 1033. Proper spraying viscosity is 18-25 sec (Din4).</p> <p>Spray an even coat (wet film thickness about 100-120 g/m<sup>2</sup>) and let it dry about 1-2 h (in 20-30 °C temperature) before sanding. Sand the surface carefully with paper grain size 320 or 400 and remove sanding dust before second application.</p> <p>If needed apply a second even coat and let it dry about 1-2 hours (in 20-30 °C temperature) and sand the surface again and remove sanding dust.</p> <p>Stir the Dicco Crystal 30 well and add 10 % by volume of hardener 006 2098 and mix well again. Thin the paint to the proper application viscosity with thinner 1035. Proper spraying viscosity is 18-25 sec (Din4). Spray an even coat (wet film thickness about 100-120 g/m<sup>2</sup>) and let it dry about 4-6 h (in 20-30 °C temperature) before further processing.</p> <p>The drying time depends of film thickness, temperature, relative humidity and the air ventilation.</p> <p>The right nozzle size is 0,011-0,013" and angle 20 or 40 and the spraying distance from object about 20-25 cm.</p>
<b>MAINTENANCE PAINTING</b>	Wash down the surface with Maalipesu and rinse carefully with water. Remove old loose paint with scraper. Sand down surface and remove the sanding dust. Stir Empire or Maalarin Valkolakka well before use. Apply evenly 1-2 coats of paint. Sand down lightly between each coat.

The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. The quality of the product is ensured by our operational system, based on the requirements of ISO 9001 and ISO 14001. As manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

The product is intended for professional use only and shall only be used by professionals who have sufficient knowledge and expertise on the proper use of the product. The information above is advisory only. To the extent permitted by applicable law, we shall not approve of any liability for the conditions under which the product is being used or for the use or application of the product.

In case you intend to use the product for any other purpose than that recommended in this document without first getting our written confirmation on the suitability for the intended use, such use takes place at your own risk.

