

WC21
SOLVEN-BORNE FAST DRYING ACID CATALYSED PAINT SYSTEM FOR WOOD SURFACES

DICCO SURF	007 5898
DICCO SURF COLOR	692 7623
DICCO ASTRAL 35	629-s

Solvent -borne acid catalysed system WC21 is fast drying paint system for interior wooden panels, frames, doors, chairs, furniture etc. This system is recommended especially for fast painting lines.

Dicco Surf primer is two-component fast drying acid catalysed primer. It has good hiding power and it's easy to sand. Dicco Surf Color is tintable acid catalysed primer. It can be tinted to TCL-base colors.

Dicco Astral 35 is two-component fast drying acid catalysed top coat. It is aromatic solvent free and tintable in Temaspeed –tinting system.

Typical paint system

Treatment	Product	Application method	Wet film thickness
Priming	1-2 x Dicco Surf	Spraying	100-150 g/m ²
Top coat	1x Dicco Astral 35	Spraying	100-120 g/m ²

PRODUCT PROPERTIES

Solid Content	43 volume-%	(007 5898)
	50 volume %	(692 7623)
	56 volume-%	(629-s)
Specific gravity	1,3 kg/l	(007 5898)
	1,1-1,4 kg/l (depends of color shade)	(629-s)
Paint hardener mixing ratio	007 5898 : 006 2098	100:10
	629-s : 006 2098	100:14

Drying times

	100–120 /m ²	+23°C	+50°C
Dicco Surf	Dry to sand	40-60 min	20-40 min
	Dry to stack	40-60 min	20-40 min
Dicco Astral 35	Dry to sand	1-2 h	30-40 min
	Dry to stack	1-3 h	30-40 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.

Gloss	Semi-matt	(629-s)
Application methods	Spraying, curtain coating	
Thinner	Thinner 006 1035 (fast), 006 1058 (slow)	
Cleaning of equipment	Thinner 1035, 1058	

TIKKURILA OYJ

 P.O. Box 53, Kuninkaalantie 1, FI-01301 Vantaa, Finland, Tel. +358 (0)20 191 2000, Fax +358 (0)20 191 2000
 VAT FI01970674, Business Identity Code 0197067-4, Registered Office Vantaa

www.tikkurila.com

SURFACE PREPARATION	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.
APPLICATION CONDITIONS	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.
APPLICATION	<p>Stir the Dicco Surf 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 1035. Proper spraying viscosity is 18-25 sec (Din4).</p> <p>Spray an even coat (wet film thickness about 100-120 g/m²) and let it dry about 40-60 min (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 need pply a second even coat and let it dry about 40-60 min (in 20-30 °C temperature) and sand the surface again and remove sanding dust.</p> <p>Stir the Dicco Astral 35 well and add 14 % 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/m²) and let it dry about 1-3 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>
MAINTENANCE PAINTING	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.

