

# DuraFlex™ II 550

## WATER CLEAR HCV CONVERSION COATING

Product Code: **310603**

DuraFlex™ II 550 HCV is a water clear post-catalyzed conversion coating ideal for residential and commercial interior wood surfaces.

### Ideal For

Furniture  
Fixtures and Displays  
Cabinetry & Casegoods  
Interior wood work

Meets KCMA performance tests  
Federal AIM compliant at 550 g/l VOC  
NESHAP Compliant—JJ (furniture)  
NESHAP Complaint—QQQQ (doors & windows)

### Benefits

Water Clear  
Non-yellowing  
Excellent flow and leveling  
Easy sand  
Low odor  
Extended pot life—up to 30 days  
Minimize waste

## 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	No thinning required. Spray at 28 psi through a 1.4 fluid nozzle.

**THINNING:** This product is designed to spray at package viscosity with most application equipment. 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

**MIXING DIRECTIONS:** Add 2 fluid ounces of Rudd 03-419 Catalyst per gallon. Stir well during and after adding catalyst.

**POT LIFE:** 30 days @ 65-70° F.

**STAIN:** When staining wood, use Rudd LOW VOC versions of ColorTools™ Dye Stains, ColorTools™ Spray Only Stain, or ColorTools™ Wiping Stain.

**SEAL:** Apply one coat (3—4 mils wet) of 310604 DuraFlex II 550 Sealer or use 310603 DuraFlex II 550 finish as its own sealer. Allow to dry 20 minutes\*, sand with 220/320 grit silicon carbide sandpaper before finishing.

**FINISH:** Apply one or two coats (4—6 mils wet) of 310603 DuraFlex II HCV coating. Allow 20 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 vary with film thickness, temperature, humidity and air flow.

## SAFETY PRECAUTIONS

Avoid breathing vapors, use a NIOSH approved cartridge respirator. Use pre-filters to avoid breathing spray particles or sanding dust.

**Flammable Liquid and Vapor:** 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 in water-filled, closed container prior to disposal. Dispose in safe, approved manner.

Read 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	No Visual Effect
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
<b>OTHER</b>	
Pencil Hardness	Pass 2B
Mar Resistance	Excellent
Adhesion	Excellent

\*\*\* Contact your Sales Representative for available stock sheens and package sizes.\*\*\*

**SPECIFICATIONS**

Coverage	300 square feet per gallon @ 1 mil dry film thickness
Viscosity	17—19 seconds (#2 Zahn Cup @ 77°F)
Sag Resistance	5 mils vertical @ 65—70°F
Solids*	26.0—27.2% by weight 1.96-2.07 lbs per gallon
VOC* (Volatile Organic Compounds)	Calculated: 544—548 g/l (4.55—4.57 lb/gal)
HAP* (Hazardous Air Pollutants)	Pounds HAP per Gallon: 0.0325—0.0329  Pounds HAP per Pound Solids: <0.8 (actual 0.0157—0.0168)  Pounds HAP per Volume Solids: <0.48 (actual 0.1680—0.1766)
Dry to Sand	20 minutes @ 65—70°F
Block Free	6 hours @ 65—70°F

\*Variations depend on gloss

CAUTION: Thinning will reduce film build and increase VOCs.

**APPLICATION PRECAUTIONS**

This product MUST be catalyzed with 03-419 Catalyst. Do not catalyze with any other Rudd acid catalyst.

Do not use catalyzed product beyond 30 days after catalyzation. Usability and performance may not always be determined from viscosity. Pot life will vary with storage conditions.

Do not use DuraFlex II 550 in heated spray equipment.

Total film build of the DuraFlex II 550 system must not exceed 5.0 dry mils.

Clear finishes will not prevent natural wood from changing color over time.

Finish, substrate and curing temperatures should remain above 60°F., extremes of temperature and humidity may affect product performance.

This product is not recommended for exterior use.

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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