

Marathon[™] 680

OPAQUE CONVERSION VARNISH - SATIN WHITE

Product Code: **310760.ST**

Marathon[™] 680 is an opaque acid-catalyzed conversion varnish 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 680 g/l VOC
NESHAP Compliant—JJ (furniture)
NESHAP Compliant—QQQQ (doors & windows)

Benefits

Non-yellowing
Tough mar-resistant finish
Excellent flow and leveling
Easy sand
Tintable to custom pastel & light colors
Formulated to maximize throughput
Self seal system
Fast dry to sand and recoat
Super-low HAP content

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	Thin 10-20% with recommended thinner. 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 1.5 fluid ounces of Rudd 03-143 Catalyst per gallon. Stir well during and after adding catalyst.

POT LIFE: 24 hours @ 65-70° F.

STAIN: When staining wood, use Rudd Colortools[™] Dye Stains, Colortools[™] Spray Only Stain, or Colortools[™] Wiping Stain.

SEAL: Apply one coat (3—4 mils wet) of 310760 Marathon as its own sealer. Allow to dry 25 minutes*, sand with 220/320 grit silicon carbide sandpaper before finishing.

FINISH: Apply two coats (3-4 mils wet) of 310760 Marathon. Allow 25 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
OTHER	
Pencil Hardness	Pass HB
Mar Resistance	Excellent
Adhesion	Excellent

SPECIFICATIONS

Coverage	500 square feet per gallon @ 1 mil dry film thickness
Viscosity	33-39 seconds (#2 Zahn Cup @ 77°F)
Sag Resistance	4 mils vertical @ 65—70°F
Solids*	45.0% by weight 3.9 lbs per gallon
VOC (Volatile Organic Compounds)	Calculated: 572 grams/liter (4.77 lb/gal) Catalyzed: 573 grams/liter (4.78 lb/gal)
HAP (Hazardous Air Pollutants)	Pounds HAP per Gallon: 0.043 Pounds HAP per Pound Solids: <0.8 (actual 0.011) Pounds HAP per Volume Solids: <0.48 (actual 0.136)
Dry to Sand	25 minutes @ 65—70°F
Block Free	8 hours @ 65—70°F
CAUTION: Thinning will reduce film build and may increase VOCs and HAPs unless using VOC Exempt and/or HAP-free thinner.	

APPLICATION PRECAUTIONS

Marathon 680 Opaque Conversion Varnish is formulated for use as a self-seal system.

Total film build of the Marathon system must not exceed 5.0 dry mils.

This product must be sanded between all coats to ensure proper adhesion. Always recoat within 8 hours of being sanded.

Tint only with Colortools™ or 844 Colorants. Do not exceed 8 fl. oz. of colorant per gallon of coating.

Do not use catalyzed product beyond 24 hour pot life. Usability and performance may not always be determined from viscosity.

Do not use alkaline based products to clean surfaces finished with Marathon conversion coating.

Do not use Marathon with heated spray equipment.

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.

For best results, use within 12 months of manufactured date.

Designed for professional use by spray application only.

Shipping & Storage Information

Flash Point: -4°F Pensky-Martin

OSHA Flammability Class: Flammable Liquid—Class IB

DOT Class: Paint, 3, UN 1263, PG II

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