

ClearBuild™ 680

WATER-CLEAR HIGH-BUILD PRE-CATALYZED LACQUER

Product Code: **651820**

ClearBuild™680 is a water-clear high solids, high build pre-catalyzed lacquer ideal for interior wood surfaces.

Ideal for

Furniture
Doors & Millwork
Cabinetry & Caseworks
Interior Wood Work

Exceeds KCMA performance tests
Federal AIM compliant 680 g/l VOC
NESHAP compliant—JJ (furniture)
NESHAP compliant—QQQQ (doors & windows)

Benefits

Water-Clear
Exceptional abrasion and mar resistance
Excellent water and chemical resistance
Non-yellowing
High build
Excellent flow and leveling
Easy sand
Superior blush resistance
Self-seal system
No HAP

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

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

SEAL: Apply one coat (3-5 mils wet) of ClearBuild 680 PreCat as it's own sealer OR select one of Rudd's Clear Lacquer Sealers. Allow to dry 30 minutes*, sand with 220/320 grit silicon carbide sandpaper before finishing.

FINISH: Apply two coats (3-5 mils wet) of ClearBuild 680 PreCat. Allow 30 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 will vary with film thickness, temperature, humidity and air movement.

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 2B
Mar Resistance	Excellent
Adhesion	Excellent

*** Contact your Sales Representative for available package sizes.***

SPECIFICATIONS

Coverage	375 square feet per gallon @ 1 mil dry film thickness
Viscosity	27-30 seconds (#2 Zahn Cup @ 77° F)
Sag Resistance	4 mils vertical @ 65-70°F
Solids*	29.8.3-31.5% by weight 2.35-2.51 lbs per gallon
VOC* (Volatile Organic Compounds)	Calculated: 642-653 g/l (5.35-5.44 lb/gl)
HAP* (Hazardous Air Pollutants)	Pounds HAP per Gallon: 0.0009—0.0009 Pounds HAP per Pound Solid: < 0.8 (actual 0.0003—0.0003) Pounds HAP per Volume Solids: <0.48 (actual 0.0039—0.0039)
Dry to Sand	30 minutes @ 65-70° F
Block Free	8 hours @ 65-70° F
Sheen	ST: 20, FL: 5
*Variations depend on gloss CAUTION: Thinning will reduce film build and increase VOCs.	

APPLICATION PRECAUTIONS

ClearBuild 680 PreCat has a limited shelf life of approximately 12 months from date of manufacture. Usability and performance may not always be determined from viscosity. Shelf life will vary with storage conditions.

Do not use ClearBuild 680 PreCat as a topcoat over stearated sanding sealers. Use ClearBuild 680 as it's own sealer OR select one of Rudd's Clear Lacquer Sealers.

Do not use ClearBuild 680 in heated spray equipment.

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

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

This product is not recommended for exterior use.

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

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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