

# DuraCat™ 680 Sealer

## WATER-CLEAR PRE-CATALYZED SANDING SEALER

Product Code: **651975**

DuraCat™ 680 Sealer is a water-clear, pre-catalyzed lacquer sanding sealer for use with Rudd Clear Pre-Catalyzed Lacquers.

### Ideal for

Furniture  
Millwork  
Cabinetry & Casegoods  
Interior Wood Work

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

### Benefits

Water clear  
Non-yellowing  
Excellent water and chemical resistance  
Low odor  
Easy sand  
Excellent flow and leveling  
Ultra low 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	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

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

**SEAL:** Apply one coat (3-5 mils wet) of DuraCat 680 PreCat Sealer. Allow to dry 20 minutes\*, sand with 220/320 grit silicon carbide sandpaper before finishing.

**FINISH:** Apply two coats (3-5 mils wet) of Rudd PreCat Clear Lacquer. 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 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.

<b>SPECIFICATIONS</b>	
Coverage	<b>290 square feet per gallon @ 1 mil dry film thickness</b>
Viscosity	21-25 seconds (#2 Zahn Cup @ 77° F)
Sag Resistance	5 mils vertical @ 65-70° F
Solids	25.3% by weight 1.92 lbs per gallon
VOC (Volatile Organic Compounds)	Calculated: 615 g/l (5.12 lb/gal)
HAP (Hazardous Air Pollutants)	Pounds HAP per Gallon: 0.032 Pounds HAP per Pounds Solid: < 0.8 (actual 0.0166) Pounds HAP per Volume Solids: <0.48 (actual 0.1764)
Dry to Sand	20 minutes @ 65-70° F
CAUTION: Thinning will reduce film build and increase VOCs.	

## APPLICATION PRECAUTIONS

DuraCat 680 PreCat Sealer 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 DuraCat 680 PreCat Sealer 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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