

# TruBuild™ 680 Black

## OPAQUE NC LACQUER

Product Code: **652995**

TruBuild™ 680 is a ready to use, non-catalyzed opaque black nitrocellulose lacquer for interior wood surfaces.

### Ideal for

Doors & Trim  
Interior wood work

Federal AIM compliant at 680 g/l VOC  
NESHAP compliant—JJ (furniture)

### Benefits

Fast dry  
Good vertical hang  
Economical—ready to spray  
High build—good flow and level  
Provides nice 'hand' or feel of finished wood  
Low odor  
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	Thin up to 20-30% 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. Thinning requirements may vary with changes in temperature and spray room conditions. 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

**SEAL:** Apply one coat (3—5 mils wet) of TruBuild Opaque NC Lacquer as its own sealer. Allow 20 minutes\* dry time and sand with 220/320 grit Silicon Carbide sandpaper before finishing.

**FINISH:** Apply two coats (4—5 mils wet) of Rudd TruBuild Opaque NC Lacquer (do not use with pre-catalyzed lacquer). Allow 20 to 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 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 containers prior to disposal. Dispose of in safe, approved manner.

Read Material Safety Data Sheet and label before using.

**KCMA FINISH TEST**

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 hour KCMA test with no softening, discoloration or film defects.
Cold Check	Passed 20 cycles @ 5 mils dry film
Pencil Hardness	2B
Mar Resistance	Good
Adhesion	Excellent

**SPECIFICATIONS**

Coverage	275 sq ft per gallon @ 1 mil dry film thickness
Viscosity	28-32 Seconds (#2 Zahn Cup @ 75°F.)
Sag Resistance	5 mils vertical @ 65-70°F.
Solids*	24.1—25.2% by wt
VOC (Volatile Organic Compounds)	Calculated: 650—656 g/l (5.43—5.47 lb/gal)
HAPs  (Hazardous Air Pollutants)	Pounds HAP per Gallon: 1.32-1.32 Pounds HAP per Pound Solid: < 0.8 (actual 0.68—0.72) Pounds HAP per Volume Solids:
Dry to Sand	20 minutes @ 65—70°F.
Block Free	8 hours/overnight
*Variations depend on sheen. CAUTION: Thinning will reduce film build and may increase VOCs and HAPs unless using VOC Exempt or HAP-free thinner.	

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

**APPLICATION PRECAUTIONS**

When finishing wood subject to frequent contact with water or high humidity, use Rudd PreCat Lacquer or Conversion Varnish.

Do not use TruBuild 680 Opaque NC Lacquer in heated spray equipment.

This product is not recommended for exterior use.

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 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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