

UltraClassic™ 680

WATER-CLEAR PRE-CATALYZED LACQUER

Product Code: **653042NF**

UltraClassic™ 680 is an economical water-clear, super-low HAP, ready to use, pre-catalyzed lacquer ideal for interior wood surfaces.

Ideal for

Doors & Millwork
Casework
Interior Wood Work

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

Benefits

Water-Clear
Resistant to yellowing
Good abrasion resistance
Enhanced blush resistance in high temp & humidity
High solids
Excellent flow and leveling
Excellent sanding properties
Economical self-seal system
Super-Low HAPs
Low odor

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 to 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

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 UltraClassic 680 PreCat Sealer or one coat of UltraClassic 680 PreCat as it's own 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 UltraClassic 680 PreCat. 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 will vary with film thickness, temperature, humidity and air

SAFETY PRECAUTIONS

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

Flammable Liquid: 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 B
Mar Resistance	Very Good
Adhesion	Excellent

SPECIFICATIONS

Coverage	315 square feet per gallon @ 1 mil dry film thickness
Viscosity	28-32 seconds (#2 Zahn Cup @ 77°F)
Sag Resistance	5 mils vertical @ 65-70°F
Solids*	26.5-27.6% by weight 2.07-2.10 lbs per gallon
VOC* (Volatile Organic Compounds)	Calculated: 662-667 g/l (5.52-5.56 lb/gal)
HAP* (Hazardous Air Pollutants)	Pounds HAP per Gallon: 0.058 Pounds HAP per Pound Solids: < 0.8 (actual 0.027—0.028) Pounds HAP per Volume Solids: < 0.48 (actual 0.2936—0.302)
Dry to Sand	25 minutes @ 65-70°F
Block Free	8 hours @ 65-70°F

*Variations depend on sheen. CAUTION: Thinning will reduce film build and may increase VOCs and HAPs unless using VOC Exempt and/or HAP-free thinners.

APPLICATION PRECAUTIONS

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

Do not use UltraClassic 680 PreCat as a topcoat over stearated sanding sealers. Use with 653040 UltraClassic 680 PreCat Sealer or use as a self-seal system.

Do not use UltraClassic 680 PreCat 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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