

**Technical Information**

**Product Codes:** DC-0519 Gloss (80+)  
DC-0516 Semi-Gloss (55-60)  
DC-0514 Medium Satin (40-45)  
DC-0513 Satin (30-35)  
DC-0512 Dull Satin (15-20)  
DC-0510 Flat (10 Max)

**Description:** AquaClad Clear water based finish is a single component, urethane self-crosslinked multiphase acrylic clear water base finish

- Product Advantages:**
- High solids and low odor
  - Fast Dry and stacking times
  - Excellent sand ability as self-seal system
  - Excellent film build properties
  - Excellent flow and leveling
  - Minimum grain raise
  - No critical recoat time
  - Excellent chemical & wear resistance
  - Excellent wood warmth
  - Meets KCMA and ASTM performance requirements, when applied to manufacture's specifications

**Field of Application:** Wood surfaces, kitchen cabinets, store fixtures, furniture and fine architectural woodwork.

**Physical Properties (DC-051X)**

Weight per gallon	8.61 lb./gal
Viscosity	65-70 Ku or 50-55 Zahn 3 @77°F
% Solids – by Weight	32%
% Solids – by Volume	30%
Theoretical Coverage at 1 Mil Dry	471sq. ft./gal Does not include spray loss. Coverage will vary depending on application method and coating thickness.
Flash Point	>200°F
Color	Clear
Gloss @ 60°	Gloss = 80+ Semi-Gloss = 55 to 60 Satin = 40 to 45 Medium Satin = 30 to 35 Flat = 10 max
EPA VOC:	.89 lbs. /gal.

## AquaClad – Self-crosslinked Urethane Modified Acrylic

EPA VOC:	106 g/L
Actual VOC:	.29 lbs. /gal.
Actual VOC:	35 g/L
Lbs. HAPS per lbs. Solids:	0
Lbs. VOC per lbs. Solids (actual)	.1055
Lbs. VOC per lbs. Solids (EPA)	.3239

### Surface Preparation

New Work	Sand raw wood with 120-180 grit sandpaper and remove dust. Sand between coats with 220-320 grit.
Stain Precautions	Oily stains must be fully cured before applying topcoat (48 hours)
Sealer Recommendations	None

### Mixing Instructions

Reduction	5% water as needed
Mixing	Always mix before use, do not shake

### Application Method & Notes

General Guidelines	Apply 2 to 3 coats at a rate of 3 to 5 wet mils per coat.
Air Spraying (Cup Gun):	Nozzle size: .066 Pressure: 35-45 PSI
Airless Spraying:	Tip size: .009 - .013 Spray pressure: 1450 – 2175 PSI
Airless, Air-Assisted / Air mix spraying:	Tip size: .009 - .013 Material pressure: 400 - 500 PSI Assist air pressure: 10 - 15 PSI
Recoat ability	Sand able and recoat able after 1-2 hours. at 68°F. Use Scotch-Brite <sup>®</sup> or 280-320 sand paper between coats. Sanding dust must be removed by blowing off or tack raging. For best adhesion, sand previous coat immediately before applying topcoat and apply the topcoat to the sanded surfaces within 6-8 hours.
Wet Film Thickness per coat	3-5 mils
Maximum Dry Film Thickness	Maximum film build of the total system should not exceed 6 mils dry, 15 mils wet.

### Clean Up

Soap and water - use acetone to remove dried coating

### Dry Times

Drying times and Drying conditions:	Conditions should NOT be below 65°F
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	<p>and 40% relative air humidity. Ideal conditions are 68°F to 77°F and 50-65% relative air humidity. Variations lead to drying and curing problems. Drying times listed may vary depending on film build, temperature, humidity and degree of air movement. Temperatures are based on actual board temperatures. Times may vary depending on length of time for boards to reach these temperatures.</p>
Touchable:	15-20 min. @ 68°F
Sand able and Recoat able:	1-2 hours @ 68°F
Flash-off Zone/Forced Drying/Channel Conditions	After adequate flash-off time at room temperature, may be force dried with circulating air temperatures up to 120°F
Ready for testing:	7 days

### Shelf Life and Storage

Storage Life:	12 months in the closed, original container
Storage Temperature:	60°F to 77°F in unopened container

### Cautions

**THESE PRODUCTS ARE DESIGNED FOR SHOP APPLICATION AND PROFESSIONAL USE ONLY.**

“Material Safety Data Sheets” are available from your Vogel Industrial Wood Coatings representative. Prior to use of this product, obtain and review the Material Safety Data Sheet for health and safety information. Read and observe all precautionary notices on container labels.

### Limited Warranty

The technical data and suggestions for use contained in this document are true and correct to the best of our knowledge at the date of issuance. The statements of this document do not constitute a warranty, expressed or implied, as to the performance of these products. Since Vogel Industrial Wood Coatings does not control the application of its products, or the condition of the surfaces to which they are applied, Vogel Industrial Wood Coatings’ liability will under no circumstances exceed replacement of the product. All technical information is subject to change without notice.