Optidur 7100
Polyurethane Tie Coat

Technical Data Sheet

Product Group

Polyurethane Tie Coat

Characteristics

Product Information

This polyurethane Tie Coat is a part of our high performance Optidur coating systems designed for the finishing of stained or exotic woods. The product is designed to improve the adhesion between the Optidur 8000, 8200 or 9000 and wood substrates that may contain oil blocking properties.

Note: Please contact your AkzoNobel Aerospace representative for further information on choosing the appropriate product system components (stack-up) for your application.

Components

Base, Curing Solution

Base	710-001A
Curing Solution	710-001B

Specifications

Qualified Product List

AkzoNobel	ANAC Specification

Product specifications are constantly changing, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products.

Surface Conditions

Cleaning

- Surface pretreatment is an essential part of the coating process
- Wood must be sanded with a 120 or 150 grit paper and free of dust and all contaminants. Plastic substrates should be scuffed with Scotch Brite to improve adhesion. Substrates that cannot be sanded should be wiped clean and degreased if possible.

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
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Internet: www.akzonobel.com/aerospace

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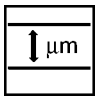
Instruction for Use

 Mixing Ratio (volume)	2.0 parts (2 gallons) Base 710-001A 1.0 parts (1 gallons) Curing Solution 710-001B
 Note	**Note:** Once mixed, this product will contain isocyanates. Take the necessary precautions for the handling and use of this product.
 Induction Time	None
 Initial Spraying Viscosity (25ºC/77ºF)	28 seconds at 25°C #4 Zahn signature cup
 Note	Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.
 Pot life (25ºC/77ºF)	3 hours
 Dry Film Thickness (DFT)	25.4 micron (mm) 1 mil **Note**: Total dry film build of the tie coat should not exceed 1 dry mil. The total system build will be dependent upon the build coat and topcoat applied.

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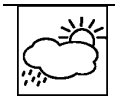
Application Recommendations

	Conditions	Temperature: Relative Humidity	18°C and above (64°F and above) 65% and below
	Note	The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.	
	Equipment	1.6 – 1.8 tip size 27-32 PSI at the spray gun	[HVLP and Compliant guns]
	Number of Coats	Apply 2 to 4 wet mills on a sanded surface. Let dry for 30 to 60 minutes and then apply a desired build coat or topcoat. If the drying time exceeds 4 hours, then sanding is required to keep good adhesion .	
	Cleaning of Equipment	Flush equipment immediately after use with lacquer thinner.	

Physical Properties

	Drying Times	At 20°C (68°F) Tack Free Time: Dry to Sand: Dry to to Stack	 30-60 minutes 4 hours 8 Hours
		At 50°C (122°F) Tack Free Time: Dry to Sand: Dry to to Stack	 5-10 minutes 20-30 minutes 4 Hours

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Theoretical Coverage	172.1 m^2 per liter ready to apply at 25 µm dry film thickness 1548.8 ft^2 per US gallon ready to apply at 1.0 mil dry film thickness
Dry Film Weight	39.8 g/m^2/25 micron 0.008 lbs/ft^2/1.0 mil
Volatile Organic Compounds	Max 700 g/l admixed Max. 5.83 lb/gal
Gloss (60º)	85 – 99 GU
Color	Amber
Flash-point	710-001A -6°C / 21°F 710-001B -6°C / 21°F
Storage	Store the product dry and at a temperature between 5 - 38°C/40 - 100°F. per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.
Shelf life 5 - 38°C (40 - 100°F)	12 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf-life information.

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Safety Precautions	Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDS's are available on request.

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