Optidur 9000
High Gloss Polyester Clear Top Coat

Technical Data Sheet

Product Group

Polyester Clear Top Coat

Characteristics

Product Information

This polyester top coat is designed for the finishing of interior wood substrates. This top coat is used as part of the high performance Optidur coating system. This top coat is applied over an Optidur tie coat and/or Optidur build coat/sealer.

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, Accelerator

Base:	900-001A
Curing Solution:	900-001B
Activator:	900-001C
Fire Retardant:	FR-1100
Pot Life Extender (Optional)	150-002PLE
Flow Additive (Optional)	150-001FA

Note

Note: The mixing order is very important. Please refer to the mixing instructions in the section below titled “Instructions for Use”

Note also that the Curing Solution 900-001B should never be placed in direct contact with 900-001C Activator. It is essential that 900-001B and 900-001C be stored in different locations **to avoid a potentially explosive reaction.**

Specifications

Qualified Product List

ANAC

For most recent up-date or missing specifications please check the qualified product list (QPL) on **www.aerospace.akzonobel.com**

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
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Surface Conditions

Cleaning

- Surface pretreatment is an essential part of the painting process
- Prepare surface by cleaning and sanding smooth, and excess dust must be removed. Then sand with 320 grit paper before application of Optidur 9000 Top Coat.

Note:

- Apply the Optidur 7100 tie coat first if the veneer is stained or unstained and if Optidur 8200 build coat/sealer is used
- Apply the Optidur 7100 tie coat first if the veneer is stained, and when using the Optidur 8000 build coat/sealer (roll coater applied).
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Instruction for Use

Mixing Ratio (volume)

100 part(s)	Base	900-001A
1.5 - 2.0 part(s)	Curing Solution	900-001B
1.0 - 1.5 part(s)	Activator	900-001C
5.0 part(s)	Fire Retardant	FR-1100
6 parts max by volume	Flow Additive (**Optional**)	150-001FA
1.8 parts max by volume	Pot Life Extender (**Optional**)	150-002PLE

Note

Note: The mixing order is very important.

First, add the FR-1100 to the **base** 900-001A. If using the pot life extender and/or flow additive, add these to the **base component** as well.

Second, after the additives are combined into the base, then add the 900-001B Curing Solution into the Base mixture and mix well (hand stirred only). Then, finally the 900-001C Activator is added to the mixture and mixed thoroughly by hand. Never add the curing solution and activator simultaneously.

- The optional flow additive may help reduce orange peel depending on user spraying capability.
- The optional pot life extender is recommended for ambient temperatures at 95 F or above in order to get a pot life of 20 minutes.

Note also that the Curing Solution 900-001B should never be placed in direct contact with 900-001C Activator. It is essential that 900-001B and 900-001C be stored in different locations **to avoid a potentially explosive reaction.**

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Induction Time	None
Initial Spraying Viscosity (25ºC/77ºF)	38 - 42 seconds #2 Zahn at 25°C
Note	Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters.
Pot life (25ºC/77ºF)	15 – 20 minutes
Dry Film Thickness (DFT)	200 – 385 micron (µm) 8.0 – 15.0 mils

Application Recommendations

Conditions	Temperature:	13 – 35°C 55 – 95°F
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.	

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Equipment	1.6 – 1.8 tip size 27-32 PSI at the spray gun	[HVLP and Compliant guns]
Number of Coats	Spray 2-4 uniform coats, with each coat being sprayed as a cross coat achieving 5 mils total per coat. Wait 15 minutes between coats. **Note**: After application is completed, flash off for 1 hour before baking. Bake at 100 degrees F for 8-12 hours.	
Cleaning of Equipment	. Flush equipment immediately after use with Acetone only.	

Physical Properties

Drying Times (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Full cure Dry to topcoat Dry hard	3 days 15 minutes 12 Hours
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 6.7 g/l admixed Max. 0.1 lb/gal	

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Gloss (60º)	85 – 99 GU
Color	Amber

Flash-point		
	900-001A Base	32°C / 90°F
	900-001B Curing Solution	100°C / 212°F
	900-001C Activator	-3°C / 27°F
	150-002PLE Pot Life Extender	-3°C / 27°F
	150-001FA Flow Additive	-20°C / -4°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.

Note: We recommend keeping a pail containing water in the paint shop and use it to store any used cups containing catalyzed Optidur 9000 after gelling has begun. Doing so will reduce fire hazard and the risk of the cup fuming

Shelf life
5 - 38°C
(40 - 100°F)

900-001A	Base 6 months
900-001B	Curing Solution 12 months
900-001C	Activator 12 months
150-002PLE Pot Life Extender	12 months
150-001FA Flow Additive	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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