

## DESCRIPTION

Double Coat Karaat is a high solid two component varnish based on saturated polyester resins, transparent pigments, modified isocyanate hardeners and UV filters.

## PRINCIPAL CHARACTERISTICS

- Specially developed to restore and brighten discoloured and wheathered wood or to enhance the colour of new wood;
- Fills wood grain;
- Excellent application properties, easy to apply by brush roller or spray;
- Excellent levelling, after curing no brush marks or orange peel will be visible;
- Good resistance to various chemicals and (sea) water;
- Good scratch and mar resistance;
- Excellent gloss retention, non-yellowing;
- Also suitable as coating system for moulds for pre-fabricated concrete parts;
- Normally two coat Double Coat Karaat are applied followed by Double Coat Dubbel UV.

## COLOURS AND GLOSS

Light oak, mahogany and teak - High gloss

## BASIS PROPERTIES (AT 23 °C AND 50% R.H.)

Density	: approx. 1,1 g/cm <sup>3</sup>
Solid content	: approx. 58 % (volume)
Recommended d.f.t.	: 30 - 40 µm (dry), depending on application
Dust dry after	: approx. 2 hours
Full cure after	: approx. 7 days, see additional information
Recoating interval	: min. 24 hours, see additional information max. unlimited, provided gritpapered, clean and dry
Shelf life	: separate components, stored cool and dry in original packaging, minimum 12 months
Flash point (DIN53213)	: base component 48 °C hardener 150 °C

## SPREADING RATE

At 30 µm (d.f.t.)	: 19,3 m <sup>2</sup> /l
At 40 µm (d.f.t.)	: 14,5 m <sup>2</sup> /l

The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

## SUBSTRATE CONDITION AND TEMPERATURE

Wood	: moisture content maximum 12%, pre-treated with one coat of Variopox Injection resin and sanded with grit paper P120-180;
Previous varnishes	: Previous varnish in good condition, dry and free from contamination and loose particles; sanded with grit paper P120-180. Double Coat Karaat is not suitable to be applied to previous coats one component varnish.

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

## INSTRUCTIONS FOR USE

Before use, mix base and hardener components thoroughly.

Mixing ratio	: 75,0 base : 25,0 hardener (by weight) 75,0 base : 25,0 hardener (by volume)
--------------	--

Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : 10 minutes at 25 °C  
 20 minutes at 20 °C  
 30 minutes at 10 °C  
 Pot life : 1 hours at 25 °C  
 2 ½ hours at 20 °C  
 4 hours at 10 °C

Application with :

	Brush/roller	Air spray	Airless spray
Type thinner	Brush thinner	Spray thinner	See additional information
% of thinner	0 - 5 %	10 - 15 %	
Nozzle orifice	n.a.	1,2 – 1,4 mm	
Nozzle pressure	n.a.	2 - 3 bar	
Cleaning	Brush thinner	Spray thinner	

**ADDITIONAL INFORMATION**

- Recoating and curing of Double Coat Karaat

	10 °C	20 °C	25 °C
Minimum	48 hours	24 hours	16 hours
Maximum, without sanding	3 days	2 days	1 day
Maximum, after sanding with grit paper P320-P400	unlimited	unlimited	unlimited
Fully cured after	14 days	7 days	3 days

- Types of wood  
 When Double Coat Karaat is applied to wood such as teak we recommend to degrease the surface thoroughly with Double Coat Degreaser. Do not use thinner, acetone or mineral spirits. Leave the surface to dry for 30 minutes and apply a coat of Variopox Injection resin first. After 24 hours sand the surface with grit paper P120-180 and apply a first coat of Double Coat Karaat.
- Application of Double Coat Karaat by brush or roller
  - Use oval brushes or solvent resistant mohair or moltoprene rollers.
  - Double Coat Karaat may be applied without the use of solvent.
  - For optimal levelling up to 3% Double Coat Brush thinner may be added. The quantity depends on application temperature and conditions.
- Application of Double Coat Karaat by spray
  - Application of Double Coat by spray is only recommended for professional users only;
  - Clean spray equipment thoroughly with clean Double Coat Spray thinner before start of application.
  - Adjust the viscosity with Double Coat Spray thinner to 20 to 22 s DIN 4 after the induction time.
  - Apply a mist coat first, followed by a full cross layer after 15 minutes.
- Application of Double Coat Karaat by airmix/aircoat spray
  - Adjust the viscosity of the mixture (base and hardener) with Double Coat Spray Thinner to approx. 50 s DIN 4.
  - Use an airmix or aircoat system, good results are obtained with a Wagner Cobra 40/10 with a material pressure of 5 Bar and an airpressure of 2 ½ Bar.
  - Use a nozzle of 0,009 inch with angle 60°.

- Sanding Double Coat Karaat

The best adhesion and gloss is achieved by sanding Double Coat between each coat. Use for every layer a finer grit paper, starting from P240-P320-P360-P400.

**SAFETY INFORMATION**

See the corresponding Material Safety Data Sheet for detailed instructions on safety, disposal and health.

Date: November '12  
457-99999

*Disclaimer*

*Although the information and recommendations are presented in good faith and believed to be correct at date of issue, De IJssel Coatings B.V. makes no representations as of the completeness or accuracy thereof. In no event De IJssel Coatings B.V. will be responsible for damages of any nature whatsoever resulting from the use of this information.*