



KF Series FUSION™ Quick Dry Post-Cat Topcoat

The KF Series Fusion™ Quick Dry is a line of solvent borne, two component, alkyd/amino resin based conversion varnishes. They are yellowing resistant topcoats that feature fast dry and easy sanding along with outstanding chemical, moisture & abrasion resistance. They are clear topcoats that can be used in a self-sealing system or in conjunction with EK8 Katilac™ Vinyl Sealer (catalyzed 5%) on high demand furniture and cabinet applications.

KF Series Fusion™ Quick Dry topcoats are extended pot-life products, having a pot-life up to 3 days pot-life after being catalyzed.

<p>SUGGESTED APPLICATIONS:</p> <ul style="list-style-type: none"> • cabinets • household furniture • interior trim and millwork • office furniture • kitchen and bath components • high demand furniture <p>KEY PERFORMANCE FEATURES</p> <ul style="list-style-type: none"> • non-yellowing • excellent hardness • fast dry • outstanding mar and scratch resistance • ultra low formaldehyde • outstanding chemical and moisture resistance • excellent flow and levelling • conforms to KCMA & AWI/TR-4 & AWMAC System #5 Conversion Varnish Standards <p>RELATED PRODUCTS EK8 Pre-Catalyzed Vinyl Sealer (catalyzed 5%) B7406 Rich Wiping Stain T5255 Zip Spray Stain</p>	<p>PHYSICAL PROPERTIES</p> <table> <tr><td>Available Sheens</td><td>15,25,40,90</td></tr> <tr><td>Weight Solids</td><td>36% +/-1.00%</td></tr> <tr><td>Volume Solids</td><td>29% +/- 1.00%</td></tr> <tr><td>Viscosity</td><td>25-30" @ 25°C Ford 4</td></tr> <tr><td>Specific Gravity</td><td>0.9480 +/- 0.01 gms/cc @ 25°C</td></tr> <tr><td>VOC</td><td>603 g/l</td></tr> <tr><td>Typical coverage</td><td>8-10 m² / ltr @ 1 mil dry</td></tr> </table> <p>ADDITIONAL CHARACTERISTICS</p> <table> <tr><td>Catalyzation:</td><td>5% by volume of 1CAT catalyst up to 3 days (if stored in closed pails @ 25°C)</td></tr> <tr><td>Pot-Life:</td><td></td></tr> <tr><td>Reduction:</td><td>max 10% by volume T4424 / T4409 Lacquer Thinner</td></tr> <tr><td>Retarder:</td><td>n/a</td></tr> <tr><td>Clean-up:</td><td>T4420 215 Gun Wash Universal</td></tr> <tr><td>Shelf-life:</td><td>1 year from date of manufacture</td></tr> </table> <p>Dry Times 26°C (-78°F) 50%RH</p> <table> <tr><td>To Touch</td><td>10 minutes</td></tr> <tr><td>To Sand</td><td>20-30 minutes</td></tr> <tr><td>To Stack/Pack</td><td>10-12 hours</td></tr> </table> <p><small>Note: Drying times will decrease at higher temperatures/lower humidity and will increase at lower temperatures/high humidity</small></p>	Available Sheens	15,25,40,90	Weight Solids	36% +/-1.00%	Volume Solids	29% +/- 1.00%	Viscosity	25-30" @ 25°C Ford 4	Specific Gravity	0.9480 +/- 0.01 gms/cc @ 25°C	VOC	603 g/l	Typical coverage	8-10 m ² / ltr @ 1 mil dry	Catalyzation:	5% by volume of 1CAT catalyst up to 3 days (if stored in closed pails @ 25°C)	Pot-Life:		Reduction:	max 10% by volume T4424 / T4409 Lacquer Thinner	Retarder:	n/a	Clean-up:	T4420 215 Gun Wash Universal	Shelf-life:	1 year from date of manufacture	To Touch	10 minutes	To Sand	20-30 minutes	To Stack/Pack	10-12 hours
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COATING PREPARATION - Ensure product is stirred well and brought to room temperature before use. Product may be sprayed by conventional, airless and air-assisted airless spray. Add 5% 1CAT Catalyst to unreduced product slowly under agitation. Thin with Lacquer Thinner to product as required, agitate. Pot life is up to 3 days at room temp in closed pails.

SURFACE PREPARATION - Wood surface should be clean, dry and free from any oil or grease. Moisture content of the wood should be 7-9%. Stains, colour coats, glazes etc. should be applied according to manufacturer's directions should be dried prior to application of sealers/topcoats. Multi-step colourant systems should be avoided unless they are thoroughly tested for adhesion and compatibility. All colour systems should be examined for colour fastness / fade resistance prior to use. For best results use Katilac stains, toners or colourant systems. Contact a Katilac Tech Service Representative for colour system recommendations.

APPLICATION - This product is designed to be applied in ambient conditions of 12-32°C (-55-90°F) and below 50% relative humidity.

KF Series Fusion™ Quick Dry topcoats can be used self-sealing or in conjunction with EK8 Katilac™ Vinyl Sealer catalyzed 5%. Apply product in full uniform coats ideally applied at a rate of 3 to 4 mils wet. Total film thickness of the finished system (sealer and topcoat) should not exceed 4 dry mils. Coating should be thoroughly dried and sanded smooth between coats. Sand with 240-320 grit professional finishing steared, silicon carbide sandpaper. It is recommended that the finished item be conditioned for 12 hours at room temperature prior to stacking and packing.

SAFETY – During application, always wear eye protection, gloves and appropriate work clothing to minimize contact. Use a respirator and safety glasses at all times when spraying. Explosion proof ventilation is required with special consideration for enclosed or confined areas. Use caution when handling flammable liquids and eliminate sources of ignition and uncovered containers from the work place. Vapours formed from this product may travel or be moved by air currents and ignited by pilot lights, light switches, other flames, smoking, sparks, heaters, electrical equipment, static discharges or other ignition sources at locations distant from the product.

KF Series FUSION™ Quick Dry Post-Cat Topcoat (cont'd)

PERFORMANCE TESTING / FILM CHARACTERISTICS

All performance testing is based on a composite of ASTM, AWI, ANSI and KCMA Standards

Household Chemical Resistance (ASTM D1308)

- test samples consist of 1 mil dry film on glass
- aged 7 days at room temperature prior to testing
- testing was performed by placing 1 milliliter of reagent on the surface of the dry film, under a watch glass for time as noted

Distilled Water (D1308.6.1.1)	24 hrs	No effect
Ethyl Alcohol (D1308.6.1.3)	24 hrs	No effect
Coffee @ 180F (D1308.6.1.13)	24 hrs	No effect
Vinegar (D1308.6.1.4)	24 hrs	No effect
Mustard (D1308.6.1.12)	2 hrs	No effect
Vegetable Oil (D1308.6.1.11)	24 hrs	No effect
Dish Detergent (D1308.6.1.8)	24 hrs	No effect

Note: A complete list of resistance tests with industrial and household chemicals can be found under ADDITIONAL STAIN TESTS

Hot Print Resistance (ASTM D 2091-96)

- test samples consisted of 1 mil dry film aged for 24 hours at room temperature prior to print testing
- duck cloth under a weight of 4 psi was then placed on dry film surface for a defined temperature/time
 - 72F (18 hrs) 4 psi...pass
 - 120F (1 hr) 4 psi.....pass
 - 140F (1 hr) 4 psi.....pass

Hot/Cold Cycling Test (ASTM D 1211-97)

- test samples were coated on red oak at 4 mils dry and aged 21 days at room temperature prior to testing.
- one cycle consisted of:
 - 120F / 70% RH for 1 hour room temperature for 1 hour
 - -5F for 1 hour
- specimens examined for discolouration, blistering, cold cracking and film failure

No signs of failure at 10 cycles

Flammability Testing (ASTM E 84- 08a) Surface Burn Rating

- test samples consisted of fiberglass reinforced cement board coated with 4 mils dry of KF Series Fusion™ Quick Dry
- samples were aged for 21 days at room temperature prior to testing

Flame Spread Index.....5.0 Class 1 / Class A
Smoke Development.....5.0 Class 1 / Class A

DISPOSAL - Disposal of chemicals and their solutions should be done according to local, provincial and federal regulations. Product Material Safety Data Sheets are available and should be consulted when handling products. These products are for Industrial and professional use only; Application directions must be followed.

KCMA Testing (ANSI/KCMA A161.1.1.2000)

Test samples consist of solid red oak coated at 4 mils dry and aged for 21 days at room temperature

A. Chemical Testing

- Vertical position for 24 hrs, water washed, dried, examined

Vinegar	Pass	Lemon Juice	Pass
Orange Juice	Pass	Grape Juice	Pass
Ketchup	Pass	Coffee	Pass
Olive Oil	Pass	100 proof alcohol	Pass
Mustard	Pass		

B. Detergent & Water Resistance Test

- Test panel edge immersed in KCMA detergent solution 24hrs
 - Removed, dried and examined
- PASS – no signs of blistering, whitening, delamination, swelling

C. Heat Resistance Test

- Test panel placed in test chamber @ 120F/70% RH for 24hrs
- PASS – no signs of discolouration, whitening, delamination or swelling

D. Hot/Cold Cycle Test

- One cycle consists of 1 hr @ 120F / 30 min room temp / 1 hr - 5F
- PASS – 10 cycles with no signs of discolouration, blistering, cold checking or any film failure

Additional Stain Tests

Testing conducted according to AWI, ASTM & KCMA Standards

- test samples consist of 1 mil dry film on glass
- aged for 21 days at room temperature
- testing was performed by placing 1 milliliter of reagent on the surface of the dry film, under a watch glass for time as noted

Ketchup	24 hrs	5	Windex	24 hrs	5
Palmolive Sol.	16 hrs	5	Mustard	1 hr	5
50% Ethanol	24 hrs	5	Acetone	1 hr	5
4% NaOH	1 hr	5	Water	24 hrs	5
Olive Oil	24 hrs	5	Boiling Water	16 hrs	5
Tomato Juice	16 hrs	5	Motor Oil	16 hrs	5
2% Ammonia	24 hrs	5	Grease/Oil	16 hrs	5
Nail Polish Rem.	1 hr	5	Lighter Fluid	16 hrs	5
Lemon Juice	24 hrs	5	Vinegar	24 hrs	5
Red Wine	24 hrs	5	1% Tide Sol.	16 hrs	5
Coffee @ 180°F	24 hrs	5			

Rating: 1-poor 2-fair 3-good 4-very good 5-excellent

WARRANTY – Katilac Coatings Inc. warrants that its products are free from defects in manufacture for a period of one (1) year from date of purchase, if used prior to expiration date and applied and used in accordance with Katilac Coatings' most current published specifications applicable to such products. Katilac Coatings Inc. expressly disclaims all other warranties, express or implied, including the implied warranties of merchantability and fitness for purpose. Katilac Coatings Inc. disclaims all liability for incidental, consequential or indirect damages of any nature whatsoever. This warranty cannot be changed or modified whether by course of dealing, custom or trade or otherwise, unless agreed to in writing by Katilac Coatings Inc.