



MIROTONE

Leading the way in coating systems since 1938

Technical Data Sheet

MIROBILD AC 3680 Ultra Gloss Clear Topcoat

MIROBILD AC 3680 is an ultra-gloss, clear acid catalysed topcoat with exceptional gloss that has been specifically formulated for the casket industry.

Product Advantages

- Results in an excellent high gloss finish over DAP board when applied over MIROBILD AC 3622 Clear Sealer.
- High build, provides the maximum build with the minimum number of coats
- Fast drying allows quicker processing time and early block stacking.

Typical Applications

Caskets

Product Properties

Build:	Excellent
Sandability:	Excellent
Vertical Hold Up:	Excellent
Solvent Resistance:	Good
Water Resistance:	Excellent
Levelling & Flow:	Excellent
Sink Back:	Minimal

Typical Properties

Colour:	Clear
Gloss:	Full Gloss

Coverage: 6-7 m² per litre at 150 micron wet film build. This is dependent on the application equipment / gun set up and the article being coated.

Mixing Ratio (by volume):

For extended pot life in warm conditions and maximum flexibility:

20 Parts MIROBILD AC 3680 Part A + 1 Part MIROBILD AC 3800 Universal Catalyst or MIROBILD AC 3810 Quick Dry Catalyst by volume.

For improved early resistance to block stacking marks from packing and during transportation in winter and cold conditions:

10 Parts MIROBILD AC 3680 Part A + 1 Part MIROBILD AC 3800 Universal Catalyst or MIROBILD AC 3810 Quick Dry Catalyst by volume.

Any mixing ratio between 10A:1B and 20A:1B is approved.

Mix A & B and then add thinner. Allow mixed product to stand for 15 minutes prior to thinning, this will ensure

that maximum film hardness and clarity is obtained. Failure to allow time for reaction to take place may result in a hazy film.

Pot Life: 1-2 days at 25°C

Pot life varies significantly with ambient temperature, humidity and the quantity mixed. Pot life is longer at lower temperatures and shorter at higher temperatures.

Thinning: Thin 10-25% with MIROSOL 1220 (Fast), 1294 (Medium), 1242 (Slow)

In hot or draughty conditions up to 10% MIROSOL 1218 Ultra Slow Thinner may be added. Do not exceed 10% addition as it will retard the drying and could lead to problems with sanding, printing and blocking. Use faster thinners to achieve the required viscosity and then use (only if required) a small amount of MIROSOL 1218 to improve flow and levelling.

In damp, cool or high humidity conditions, up to 10% MIROSOL 1297 Retarder may be added to help prevent blushing (a milkiness or haze in the film). Heating the application environment e.g. warming with infra-red lamps and avoid spraying early in the morning and late evening when temperatures are at their coldest, will also help to reduce the risk.

Application Viscosity: 18-25 seconds BS4 Flow Cup at 25°C.

Wet Film Thickness (WFT): 100-150 microns per coat.

Application Methods:

Suction Gun:	Use 1.5 to 2mm (59-79 thou) orifice with 350-400kpa (50-55 psi).
Pressure Pot:	Use 1.5 to 2mm (59-79 thou) orifice with pressure pot air-cap. Gun pressure 350-400kpa (50-55 psi) and a pot pressure of 45kpa (6 psi) max.
Airless Spray:	Use 0.23 to 0.33mm (9-13 thou) orifice, 15cm fan (dependent on job) with regulated pump pressure of 350-400kpa (50-55 psi).
Air Mix Guns:	Settings similar to airless spray with the air-assisted regulator pressure at 70-90kpa (10-15psi).
Curtain Coating:	Viscosity 40-50 seconds.

Drying:	Dust Free:	15-20 minutes
	Touch Dry:	25-30 minutes
	Sanding:	40-90 minutes
	Topcoat:	Within 24 hours of sanding
	Block Stacking:	24 hours

Low temperatures or heavy film thickness will retard drying times and cause frying upon application of subsequent coats.

Recommended Sealers: MIROBILD AC 3622 Clear Sealer

Always test the substrate before application as many timbers or veneer/glue combinations can discolour when coated with acid catalysed coatings (i.e. huon pine, myrtle, Tasmanian blackwood or beech). Use a MIROTHANE PU clear coating system to reduce the risk of discolouration.

Application Equipment Clean Up: Clean all equipment using MIROSOL 1222 or 1286 Thinner

Shelf Life: MIROBILD AC Part A – 24 months
MIROBILD AC Part B – 12 months

Packaging: MIROBILD AC Part A – 20 litres
MIROBILD AC Part B – 0.5, 2, 4, 20 litres

Refer to the MIROBILD AC Product Information Guide for more information.

Health & Safety

Before handling, refer to the Material Safety Data Sheet for health and safety information. Ensure that all personnel using this product have read and understood this data sheet and the associated MSDS and packaging label before using this product.

Mirotone Pty Ltd Australia (Head Office)

ABN 40 000 041 136
21 Marigold Street,
Revesby NSW 2212 Australia
P +61 2 9795 3700 F +61 2 9771 3601
sales@mirotone.com.au

Mirotone (NZ) Ltd New Zealand (Head Office)

32 Cryers Road,
Auckland, 1730, New Zealand
P +64 9 272 2730 F +64 9 272 2733
information@mirotone.co.nz

Mirotone (Thailand) Co., Ltd

83 Moo 4, Poochaosamingprai Rd,
Samrong Klang, Prapadaeng,
Samutprakam, 10130, Thailand
P +66 2 754 4451 F +66 2 754 4450

www.mirotone.com