



## 320 Diamolac 1k HB Precat Clear Lacquer

320 Diamolac HB Precat Clear Lacquer is a high quality, single component, nitrocellulose modified pre-catalysed lacquer. It has been specifically designed for industrial application on interior furniture and general woodwork. 320 Diamolac HB Precat Clear Lacquer delivers a high build with silky smooth feel.

- **Product:** modified pre-catalysed nitrocellulose lacquer.
- **Gloss** 10%, 30%, 50%, 100% gloss levels
- **Thinning:** TZ075 Lacquer Thinners,  
(Precat HB Lacquer may be thinned up to 10% by vol.)
- **Drying Time** Tack free 20-30 minutes. Recoat 2-3 hours.  
(Oven curing for 20 min @ 40° C may reduce recoating schedule to approximately 30 min. Allow timber to cool to approximately ambient temperatures before recoating.)
- **Interior Exposure** Very Good
- **Yellowing Characteristics** Typical of nitrocellulose based lacquer
- **Water Resistance** Suitable only for splash resistance, typical of nitrocellulose lacquers. Wet areas should be coated with two component chemically resistant coatings.
- **Exterior Exposure** Not suitable (Must be protected from direct sunlight, rain and water condensation)
- **Container Size** 4Lt, 20Lt,
- **Sealer** May be used as a self sealing system however for open grain timber it is recommended to seal with 320 Diamoseal HB Sealer. May also be applied over suitable two component polyurethane sealers.
- **Coverage** Theoretical 15-20 square metres per litre  
Practical 6-8 square metres per litre (Spray Application)

**Uses:** Used as an industrial grade quick drying NC pre-catalysed lacquer over suitably prepared timber surfaces. 320 Diamolac HB Precat Clear Lacquer is ideal for use in industrial production lines for coating most internal furniture. Exhibits excellent film build with exceptional feel, ease of use, short recoat times and good durability.

### APPLICATION

Timber must be of suitable grade for furniture manufacture with a moisture content not exceeding 12%. Timber must be prepared and sanded with at least 180 grit sand paper and wiped clean prior application of coatings. Avoid applying coatings over oily timbers or knots containing sap, a suitable barrier coat may be necessary to avoid delamination or discolouration of topcoats.

### **AUSTRALIAN DISTRIBUTOR - Superior Timber Coatings**

Unit 13, 257 Colchester Road Kilsyth (Vic) 3137Ph. 03 9761 6899 [www.sales@stcoatings.com.au](mailto:sales@stcoatings.com.au)  
Unit 2, 13 Thames Avenue Klemzig (S. Aust.) 5087Ph. 08 7099 3659 [www.saleessa@stcoatings.com.au](mailto:saleessa@stcoatings.com.au) Website:  
[superiortimbercoatings.com.au](http://superiortimbercoatings.com.au)



# Superior Timber Coatings

(Akzolux Australia) ABN: 95 080 845978

## SYSTEM 1/ SELF SEALING

### Clear

1. Apply self-sealing coat of 320 Diamolac HB Precat Clear Lacquer 10% or 30% and allow 2 hours cure @ room temperature.
2. Sand with 320 - 400 grit paper and recoat with 320 Diamolac HB Precat Clear Lacquer at the desired gloss level.
3. If a third coat is needed allow two hours cure and repeat step 2.
4. If a third coat is needed allow two hours cure and repeat step 3.

### Stained

1. Apply stain of desired colour and allow for recommended drying time.
2. Apply self-sealing coat of 320 Diamolac HB Precat Clear Lacquer and allow 2 hours cure @ room temperature.
3. Sand with 320 - 400 grit paper and recoat with 320 Diamolac HB Precat Clear Lacquer at the desired gloss level.
4. If a third coat is needed allow two hours cure and repeat step 3.

## SYSTEM 2/ SEALING

### Clear

1. Apply 320 Diamoseal Precat HB Sealer and allow 1-2 hours cure @ room temperature.
2. Sand with 320 - 400 grit paper and recoat with 320 Diamolac HB Precat Clear Lacquer at the desired gloss level.
3. If a third coat is needed allow two hours cure and repeat step 2.

### Stained

1. Apply stain of desired type and colour and allow for recommended drying time.
2. Apply 320 Diamoseal Precat HB Sealer and allow 1-2 hours cure @ room temperature, 30min @ 40°C
3. Sand with 320 - 400 grit paper and recoat with 320 Diamolac HB Precat Clear Lacquer at the desired gloss level.
4. If a further coat is needed allow two hours cure at room temp or 30min @ 40°C and repeat step 3.

### **Note heavier coats will require longer recoat times**

(Force curing of 320 Diamolac HB Precat Clear Lacquer @ 40° C will allow a recoat time of approx 30 min)

## **AUSTRALIAN DISTRIBUTOR - Superior Timber Coatings**

Unit 13, 257 Colchester Road Kilsyth (Vic) 3137Ph. 03 9761 6899 [www.sales@stcoatings.com.au](mailto:sales@stcoatings.com.au)  
Unit 2, 13 Thames Avenue Klemzig (S. Aust.) 5087Ph. 08 7099 3659 [www.salessa@stcoatings.com.au](mailto:salessa@stcoatings.com.au) Website:  
[superiortimbercoatings.com.au](http://superiortimbercoatings.com.au)



## **PHYSICAL AND CHEMICAL PROPERTIES**

**Appearance** : Coloured liquid

**Odour:** Odour of Hydrocarbons

**Specific Gravity:** 1.00 – 1.30 Kg/l

**Solids Content by weight** : 27 – 30%

**Solubility in water g/l:** None

**Percentage volatile by volume** : 40 – 60%

### **Precautions:**

Heavier coats will require longer recoat times. Care must be taken not to apply excessively high film builds of precatalysed lacquers of this type as this may lead to film defects and cracking.

Although 320 Diamolac HB Precat Clear Lacquer is made from yellow resistant resins, nitrocellulose lacquers will yellow with age to some degree. Clear lacquer film will not prevent timber discoloration upon exposure to UV light.

320 Diamolac HB Precat Clear Lacquer exhibits good splash resistance to water however, single component nitrocellulose lacquers are not recommended for use on vanity or kitchen bench-tops which may be exposed to water pooling or in areas exposed to high humidity, in such conditions two component chemical resistant coatings are recommended.

Single component 320 Diamoseal Precat HB Sealer may be replaced with a suitable two component Polyurethane sealer if higher film builds and improved resistance properties are required. Follow the recommended recoat times of the sealer used and sand between coats with 320 – 400 grit sand paper.

All advice, recommendations, information or service provided by Superior Timber Coatings in relation to product manufactured or supplied by it or their use and application is given in good faith and is believed by Superior Timber Coatings to be appropriate and reliable. This information may be subject to change without notice. No warranty expressed or implied is made as to its accuracy, completeness or otherwise provided that the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon Superior Timber Coatings by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance void or prohibiting such exclusion limitation or modification. Superior Timber Coatings has no control on individual customer's application methods and or raw materials used and therefore can not be held responsible for product failure if recommended guidelines are not satisfied. Products are expected to perform as indicated provided the application procedures are adhered to.

### **AUSTRALIAN DISTRIBUTOR - Superior Timber Coatings**

Unit 13, 257 Colchester Road Kilsyth (Vic) 3137 Ph. 03 9761 6899 [www.sales@stcoatings.com.au](mailto:sales@stcoatings.com.au)  
Unit 2, 13 Thames Avenue Klemzig (S. Aust.) 5087 Ph. 08 7099 3659 [www.saleessa@stcoatings.com.au](mailto:saleessa@stcoatings.com.au) Website:  
[superiortimbercoatings.com.au](http://superiortimbercoatings.com.au)



# Superior Timber Coatings

(Akzolux Australia) ABN: 95 080 845978