



MIROTONE

Leading the way in coating systems since 1938

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MIROCAT PC 3220 Clear Topcoat

Technical Data Sheet

MIROCAT PC 3220 is a premium quality, high build, single pack, pre-catalysed clear lacquer for hot or cold application. MIROCAT PC 3210 is easy to use and results in a high build finish, with excellent surface hardness.

Product Advantages

- High solids content provides improved hold up for better overall appearance and reduces the number of coats required.
- Easy to use, achieve an excellent finish with minimal effort.
- Formulated on a very clear, low yellowing resin and contains UV absorbers to ensure maximum protection of the substrate from UV light.
- High in can viscosity allows the applicator to adjust the coating viscosity to suit their requirements.
- Good clarity, provide good grain definition and depth of colour.
- Excellent flow and levelling results in a smooth even finish.

Typical Applications

Interior use only. Ideal for domestic furniture, children's toys and furniture, picture frames, musical instruments, joinery and antique restoration.

Product Properties

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

Typical Properties

Colour:	Clear
Gloss:	10%, 30%, 60% & Full Gloss

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

Thinning: Subdued Gloss - Thin up to 30% with MIROSOL 1222 or 1220 (Fast), 1294 (Medium), 1242 (Slow)
Full Gloss - Thin 20-30% with MIROSOL 1222 or 1220 (Fast), 1294 (Medium), 1242 (Slow)

Application Viscosity: 50-60 seconds BS4 Flow Cup at 25°C.

Wet Film Thickness (WFT): 150-200 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).
Hot Spray: Temperature guide 35-40°C.

Drying: Dust Free: 4-8 minutes
Touch Dry: 10-15 minutes
Sanding: 2-3 hours
Topcoat: Within 24 hours of sanding
Block Stacking: 24 hours

Low temperatures and heavy film thickness will retard drying times.

Recommended Sealers: MIROCAT PC 3220 Clear Topcoat (as its own sealer)
MIROCAT PC 3241 Clear Sealer
MIROCAT PC 3242 Clear Sealer
MIROCAT PC 3244 Clear Sealer
MIROTHANE PU 5533 Clear Sealer
MIROTHANE PU 5545 Clear Sealer

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

Shelf Life: 24 months

Packaging: 4 litres, 20 litres & 205 litres

Refer to the MIROCAT PC 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.