# DURALAQ® HB PRODUCTION LACQUER

## 1LL.63X

### Features
- 30% Solids Content
- Ready To Spray Viscosity
- Resists Cold Checking
- Amber Hue
- Fast Drying
- Cost Savings

### General Description
Lenmar® Duralaq® 1LL.63X Series, high build, 30% solids, production lacquers are ideal for most interior wood surfaces. Its primary benefits include exceptional amount of solids for build, and fast drying. The ready-to-spray viscosity saves time and insures job-to-job consistency and performance. Only the highest quality raw materials are uniquely blended into this lacquer which gives this production topcoat its high build and easy application. Once dry, this finish will resist cold checking for lasting durability. This lacquer is pre-mixed in four separate sheen levels. For a true non-yellowing finish, try Lenmar Ultra-UniLaq™ 1M.97X CAB Acrylic Series.

### Recommended For
Fine Furniture, Window & Door Trim, Baseboards & Moldings, Interior Doors & Hand Rails, Other Interior Wood Finishing

### Limitations
- Do not use over pickle stains, pastel or off-white finishes.
- Entire system not to exceed 4 mils dry.
- Not for use on floors.

### Product Information

#### Colors — Standard:
- 1LL.639 Gloss
- 1LL.636 Semi-Gloss
- 1LL.634 Satin
- 1LL.632 Dull-Rubbed

#### Tint Bases:
N/A

#### Special Colors:
N/A

### Certification & Qualifications:
The products supported by this data sheet contain a maximum of 680 grams per liter VOC /VOS (5.7 lbs/gal.) excluding water & exempt solvents.

### Technical Data

<table>
<thead>
<tr>
<th>Clear/Gloss</th>
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</thead>
<tbody>
<tr>
<td>Vehicle Type</td>
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<tr>
<td>Pigment Type</td>
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<tr>
<td>Weight Solids</td>
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<tr>
<td>Volume Solids</td>
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<tr>
<td>Coverage per Gallon at 1 mil DFT</td>
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<tr>
<td>Recommended Film Thickness</td>
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</table>

Coverage calculation does not include spray loss or equipment inefficiency. Also allow for wood species, surface preparation, surface defects and porosity of substrate to affect spread rates.

### Dry Time

<table>
<thead>
<tr>
<th>Temperature @ 75 °F (23.8 °C) @ 50% RH</th>
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<tbody>
<tr>
<td>– To Sand 25 – 30 Minutes</td>
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<tr>
<td>– To Recoat 30 Minutes</td>
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High humidity and cool temperatures will result in longer dry recoat times.

### Dries By
Evaporation

### Viscosity
26 – 30 Seconds (Zahn #2)

### Flash Point
25 °F

### Gloss / Sheen
Gloss/Semi-Gloss/Satin/Dull Rubbed

### Surface Temperature
- Min. 68 °F
- Max. 90 °F

### Thin With
Do Not Thin

### Clean Up Thinner
A.406 or 1A.519 Lacquer Thinner

### Weight Per Gallon
7.7 – 7.9 lbs

### Storage Temperature
- Min. 50 °F
- Max. 90 °F

### Volatile Organic Compounds (VOC)
658 Grams/Liter
5.5 Lbs./Gallon

◊ Reported values are for Clear/Gloss. Contact dealer/distributor for values of other bases or colors.
WARNING! If you scrape, sand, or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Informational Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

Application

ENTIRE SYSTEM SHOULD NOT EXCEED MORE THAN 4 MILS DRY. LENMAR PRODUCTS ARE DESIGNED FOR INTERIOR USE, BY SPRAY APPLICATION ONLY.

Over properly prepared wood surfaces apply one full coat of 1C.399, or other approved nitrocellulose sealer, allow it to dry, then sand. Select the desired sheen from the DuraLaq® 1LL.63X Series topcoats, shake well and apply two even wet coats of 3–5 mils. Allow them to dry, scuff sanding between each coat.

For additional resistance to moisture and chemicals, try the following Lenmar® Finishing Systems: Ultra UniLq® Acrylic 1M.97X series, UltraLaq® Precat 1D.33X series, or MegaVar® 1M.430X Series.

ENTIRE SYSTEM SHOULD NOT EXCEED 4 MILS DRY.

Specifications

Moisture content of wood should be no higher than 9%. Wood must be free of surface contaminants. Sand wood with no finer than 150-grit sandpaper and remove all dust. Mix all products thoroughly and apply by spray only. Check with equipment manufacturer for proper settings to achieve good atomization. Small amounts of 1A.114 Lacquer Retarder may be necessary during adverse weather conditions to achieve optimal atomization. Apply one coat of sealer, 3–4 wet mils, allow to dry, then sand with 280-320 grit silicon carbide sandpaper. Apply 2 coats of the DuraLaq® 1LL.63X series products, in the desired sheen from the DuraLaq® 1LL.63X series

Clean Up

Clean up with 1A.406 or 1A.519 Lacquer Thinner.

Environmental Health & Safety Information

DANGER!
Harmful if swallowed
Harmful if inhaled
Causes skin irritation
Causes serious eye irritation
Suspected of causing cancer
May damage fertility or the unborn child
Causes damage to organs
May cause damage to organs through prolonged or repeated exposure
May be fatal if swallowed and enters airways
Highly flammable liquid and vapor

Prevention: Obtain special instructions before use. Do not handle until all safety precautions have been read and understood. Use personal protective equipment as required. Wash face, hands and any exposed skin thoroughly after handling. Do not eat, drink or smoke when using this product. Use only outdoors or in a well-ventilated area. Wear eye/face protection. Do not breathe dust/fume/gas/mist/vapors/spray. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Keep container tightly closed. Ground/bond container and receiving equipment. Use explosion-proof electrical/ventilating/lighting/equipment. Use only non-sparking tools. Take precautionary measures against static discharge.

This document represents hazards of the product referenced above. Refer to the individual Safety Data Sheet for hazards of the specific product you will be using.

KEEP OUT OF REACH OF CHILDREN

This product is intended for Shop or OEM applications. This product may also be compliant under Architectural and Industrial Maintenance regulations in some jurisdictions for field application to stationary structures. Check local regulations.

READ ALL DIRECTIONS BEFORE USE. UNDERSTAND ALL DANGERS WITH THIS PRODUCT PRIOR TO USE.

Refer to Safety Data Sheet for additional health and safety information.