

# DuPont™ 18320S™ & 18321S™ INTERIOR WOOD SYSTEM



## DuPont™ 18320S™ & 18321S™ Interior Wood System

DuPont Marine Finishes Interior Wood System is designed to deliver excellent appearance and durability for interior cabin surfaces while reducing overall material usage and labor cost.

DuPont™ 18320S™ Clear Polyurethane Filler-Sealer delivers

- Excellent clarity
- Fast dry times
- Outstanding sandability
- Excellent weatherability and humidity resistance

DuPont™ 18321S™ Polyurethane Clearcoat has

- Excellent clarity
- Fast dry times
- Outstanding sandability
- Low overspray
- UV protection

**Contact your local authorized  
DuPont Marine Finishes distributor  
to place your order.**

**To find a distributor in your area,  
call 1-800-GET DUPONT or visit  
[www.performancecoatings.dupont.com](http://www.performancecoatings.dupont.com)**

*Beautiful colors. Excellent results. Outstanding performance.*



**Marine Finishes**

# DuPont™ 18320S™ & 18321S™

## INTERIOR WOOD SYSTEM

### Highlights from our Technical Data Sheet

#### Description

DuPont™ 18320S™/18321S™ is a clear polyurethane coating system designed to deliver excellent appearance and durability for interior cabin surfaces. This interior wood system delivers excellent clarity, dry times, and sandability while filling/sealing substrate for final clearcoat application.

#### Components

DuPont™ 18320S™ Clear Polyurethane Filler-Sealer  
DuPont™ 18120S™ Urethane Activator  
DuPont™ 18122S™ Slow Urethane Activator (optional)

#### Mix Ratio

Thoroughly mix prior to activation. Filter activated material prior to spray application.

#### Two Component System Parts by Volume

DuPont™ 18320S™ Clear Polyurethane Filler-Sealer 4  
DuPont™ 18120S™ /18122S™ Urethane Activator 1

#### Additives

None Recommended

#### Substrates and Surface Preparation

Surface preparation is critical to final appearance. All substrate should be sanded. See the individual Product Data Sheets for specific surface preparation information. For wood surfaces, see preparation recommendations provided in the DuPont™ 18320S™ product data sheet.

#### Gun Setup

Both DuPont™ 18320S™ and DuPont™ 18321S™ can be applied with conventional, HVLP, air-assisted airless, and electrostatic spray equipment using pressure, siphon, or gravity fluid delivery. Due to high productivity (fast cure) of DuPont™ 18320S™, a two-component (plural) system may be necessary for high volume production.

#### Conventional Fluid Tip

Pressure Pot 1.2mm – 1.6mm (.047" - .063")  
Siphon Feed 1.2mm – 1.6mm (.047" - .063")  
Gravity Feed 1.2mm – 1.6mm (.047" - .063")

#### HVLP

Pressure Pot 1.2mm – 1.6mm (.047" - .063")  
Siphon Feed 1.2mm – 1.6mm (.047" - .063")  
Gravity Feed 1.2mm – 1.6mm (.047" - .063")

**Call your authorized DuPont Marine Finishes distributor for full details. Log on to [www.performancecoatings.dupont.com](http://www.performancecoatings.dupont.com) and use the distributor locator to find the jobber in your area.**



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#### Fluid Delivery

Conventional 10-12 ozs/min  
HVLP 10-12 ozs/min

#### Air Pressure

Conventional 50 – 60 psi atomizing air  
HVLP 25 – 30 psi atomizing air

#### Application

A 3-coat process is recommended for both DuPont™ 18320S™ and DuPont™ 18321S™ application. See individual product data sheets for specific application information.

#### Dry Times

##### Force Dry at 120°F (49°C)

Flash Before Force Dry none required  
Dry to Touch 10 minutes (after cool down)  
Dry to Sand/Polish 30 minutes (after cool down)

##### Air Dry at 70°F (21°C)

Flash Between Coats 3 – 5 minutes  
Dust Free 10 minutes  
Dry to Sand 3 hours (8 hours recommended)  
*\* Infrared drying is not recommended.*

#### VOC

	Less Exempts (LE)	As Packaged (AP)
DuPont™ 18320S™	4.8 lbs/gal	4.5 lbs/gal
Ready-to-Spray DuPont™ 18320S™ With DuPont™ 18120S™	4.8 lbs/gal	4.5 lbs/gal
DuPont™ 18321S™	4.2 lbs/gal	2.9 lbs/gal
Ready-to-Spray DuPont™ 18321S™ With DuPont™ 18120S™	4.2 lbs/gal	3.2 lbs/gal

#### Dry Film

Gloss ≥ 90 measured at 60°, with DuPont™ 18321S™ Clearcoat

#### Coating Performance

	DuPont™ 18320S™	DuPont™ 18321S™
Chemical and Solvent Resistance	Very Good	Very Good
Humidity Resistance	Excellent	Excellent
Acid and Alkali Resistance	Very Good	Very Good
Abrasion Resistance	Very Good	Very Good
Flexibility	Very Good	Very Good
Weatherability	—	Excellent

#### Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves. Do not allow material or overspray to enter drains or waterways.

**Beautiful colors. Excellent results.  
Outstanding performance.**