

## DuPont™ 18320S™ Clear Polyurethane Filler-Sealer

### Type

DuPont™ 18320S™ is a high-productivity clear-pigmented polyurethane filler-sealer.

### Description

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

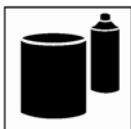
### Recommended Uses

DuPont™ 18320S™ is recommended for use with DuPont™ 18321S™ as part of a wood cabinetry finishing system. This system is designed to provide excellent appearance while reducing overall material usage and labor cost in the production of high-build, mirror-finish wood surfaces.

### General Information for Use

#### Components

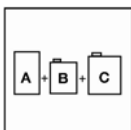
DuPont™ 18320S™ Clear Polyurethane Filler-Sealer  
 DuPont™ 18120S™ Urethane Activator  
 DuPont™ 18122S™ Slow Urethane Activator (optional)



See DuPont™ 18321S™ product data sheet for clearcoat information.

#### Mix Ratio

Thoroughly mix DuPont™ 18320S™ prior to activation. Filter activated material prior to spray application.

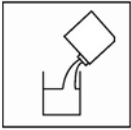


<i>Two Component System</i>	<i>Parts by Volume</i>
DuPont™ 18320S™ Clear Polyurethane Filler-Sealer	4
DuPont™ 18120S™ /18122S™ Urethane Activator	1



### Pot Life and Induction Time

Pot life is 30 minutes at 70°F (21°C).  
No induction time is required prior to application.



### Additives

None Recommended

### Guidelines for Use



### Substrates and Surface Preparation

Surface preparation is critical to final appearance. All substrate should be sanded, using 240 grit or higher sandpaper. Wood substrates should be thoroughly dried and tacked prior to application.



### Gun Setup

DuPont™ 18320S™ 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), a two-component (plural) system may be necessary for high volume production.

#### *Conventional*

Pressure Pot  
Siphon Feed  
Gravity Feed

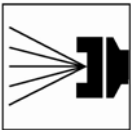
#### *Fluid Tip*

1.2mm – 1.6mm (.047" - .063")  
1.2mm – 1.6mm (.047" - .063")  
1.2mm – 1.6mm (.047" - .063")

#### *HVLP*

Pressure Pot  
Siphon Feed  
Gravity Feed

1.2mm – 1.6mm (.047" - .063")  
1.2mm – 1.6mm (.047" - .063")  
1.2mm – 1.6mm (.047" - .063")

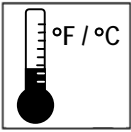


### Fluid Delivery

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

### Air Pressure

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



## Environmental Conditions

Substrate and ambient temperature must be between 50°F (10°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated paint above 110°F (43°C) may cause gelation.



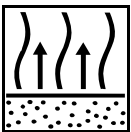
## Application

A 3-coat process is recommended for DuPont™ 18320S™ application. Spray the first coat medium wet, with a wet film build of approximately 1.0 mil. Allow the coat to flash 3-5 minutes before the next coat. Repeat with a second and then third coat. Once the 3-coat process is completed, allow the coating to dry for 2 hours at 70°F (or 30 minutes at 120°F). Repeat the 3-coat process (additional 3 coats with 3-5 minute flash in between each coat). After the second 3-coat process is completed, allow the coating to dry for at least 8 hours at 70°F. The coating should be sanded smooth with 320grit (or higher) sandpaper and wiped/tacked. The surface should appear smooth and free of any texture from underlying wood grain. Additional DuPont™ 18320S™ application processes are recommended if texture remains, with subsequent sanding and cleaning. Excessive sealer film build may cause a slight cloudy color shift. Once the wood grain is suitably filled, sanded and cleaned; the substrate is ready for clearcoat finishing.

If the filler-sealer is sanded through to bare wood, apply additional DuPont™ 18320S™ and finish as above.

DuPont™ 18320S™ can be applied by brush or roller, allowing 10 to 15 minutes flash between coats. Activate as recommended under Mix Ratio then reduce 10% with the appropriate reducer, depending upon temperature.

DuPont™ 18765S™	Low Temperature Reducer (< 70° F)
DuPont™ 18775S™	Medium Temperature Reducer (70 - 85° F)
DuPont™ 18785S™	High Temperature Reducer (>85° F)



## 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.*



## Recoat

If DuPont™ 18320S™ is being recoated after 24 hours or longer, scuff sand with 320 grit or lower paper.



## Cleanup Solvents

DuPont™ 3642S™ or Nason® 481-16™ Thinner.

## Physical Properties

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

## Factory-Packaged Filler-Sealer

Color	Cloudy
Closed Cup Flash Point	20°F – 73°F
Shelf Life	2 years (Unopened at 50° – 110°F)

## Ready-to-Spray

Theoretical Coverage	470 ft <sup>2</sup> /gal at 1 mil dry film thickness
Weight Solids	38%
Volume Solids	29%
Gallon Weight	7.8 lbs/gal

## Coating Performance

Chemical and Solvent Resistance	Very Good
Humidity Resistance	Excellent
Acid and Alkali Resistance	Very Good
Abrasion Resistance	Very Good
Flexibility	Very Good

## 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.

E-R 4687/K-17180

Revised 11/2007

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