



Product Information

Acrylac 423-95XX

PRODUCT DESCRIPTION

Acrylac is a waterborne acrylic modified polyurethane dispersion.

Acrylac is a wear-resistant, fast drying and environmentally clean lacquer. It is resistant to conventional detergents and household cleaners.

Acrylac is designed for wooden surfaces in general, and can be used as a topcoat for stains, etc. It can be used for various surfaces when properly prepared. The lacquer is very suitable for wooden floors as well as interior doors and frames.

SPECIFICATION VALUES

Gloss:	As required
Flash Point:	N/A
Specific Gravity:	1.03
Weight per Gallon:	8.6 lbs.
Solids by Weight:	35%
Solids by Volume:	33%
Fire Hazard Class:	0
Health Hazard Class:	1
Viscosity at 25°C (77°F):	55-60" Z#2
VOC:	189 g/l
Lbs. VOC/Gallon:	1.58 lb/gal
Lbs. VOC/Lbs. Solids:	0.21
Lbs. VHAPs/Lbs. Solids:	0.14

FEATURES

Note: Acrylac must be stored free of frost. Keep from freezing.

SPECIFICATION INFORMATION

Shelf Life: 12 months recommended if unopened and stored between 15°C - 25°C (59°F - 77°F). Always rotate stock.

Coverage: Coverage is sq. m/L at 1 mil dry and 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Mixing Ratio: For special purposes a hardener, 999-069, can be added. It has to be reduced with water 1:1 before being added 4% to the Acrylac. This mixture has only a twelve-hour pot life.

Reduction: Normally Acrylac does not need to be thinned, except as mentioned above. The tools can be cleaned with water and soap.

DIRECTIONS FOR USE

Surface Preparation:

New wooden surfaces: The wood must be dry and free of dust and dirt, etc. The first coat, the sealer, should be applied either as is or thinned a maximum 10% with water. When the lacquer is dry, sand it with fine sandpaper (i.e. 280, 320) and remove all sanding dust by using a vacuum cleaner or a damp cloth. Then apply one more coat, undiluted, depending upon the resistance and filling required.

N.B. If there is a need for extra durability, a hardener can be used (999-069), but most often it is not required because the lacquer by itself is very durable.

Pre-lacquered wooden surfaces: Remove loose and poorly adhering lacquer. Ensure fixed finish is cleaned well and washed with water. A cup of vinegar per pail of water may be added for the second last wash. The surface must be completely dry before applying a sealer coat of lacquer. Evaporation from cracks and joints can take longer.

Sand with 150 grit sandpaper after applying sealer coat. Remove sanding dust with a vacuum cleaner and wipe with a slightly damp cloth. If sanding through other types of lacquer or varnishes, various shades may appear due to different penetration. Bare wood seals with lacquer. Then apply one or two more coats, undiluted, depending upon the need for resistance and filling.

Waxed or stained wood surfaces: All wax, etc. must be removed with clean rags and washed with mineral spirits (varsol). After cleaning, it is recommended to make a test application to see if the lacquer adheres and dries. If not, removal of old finish or sanding is required.

When the preparation and sealing have been completed, apply one or two coats, undiluted, depending upon the resistance and filling required.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this Technical Data Sheet will likely result in unsatisfactory film appearance or film failure. The completed coating system should be checked for required properties prior to start-up of production.

APPLICATION

Method of Application:

		Viscosity	Wet Film	Dry Film
Spray	- Conventional	Z #2/20-24"	4-5 mils	1.5 mils
	- Airless	Z #2/20-24"	4-5 mils	1.5 mils
	- HVLP	Z #2/20-24"	4-5 mils	1.5 mils

All measurements recommended are based on results at temperatures of 20°C (68°F). Viscosity will vary depending on the temperature of the liquid.

Drying Times:

At 68°F/20°C	(Minimum Required)	At 122°F/50°C	(Minimum Required)
Tack Free:	10-15 minutes	Tack Free:	Flash off before entering oven
Dry to Sand:	2-3 hours	Dry to Sand:	45 minutes
Dry to Stack:	Overnight	Dry to Stack:	4 hours

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

Chemcraft International Inc. views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

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Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.