

# AKVA LINE™ 215 PRECATALYZED W/B CLEAR

EM55030XX (20,40,60,90 Gloss)



Becker Acroma

## DESCRIPTION:

Akva Line™ 215 Precatalyzed W/B Clear is a fast drying, waterborne, acrylic finish for a wide range of interior wood products. It's fast drying and stacking features make it suitable for many interior wood applications where process efficiency is crucial. With excellent clarity, Akva Line™ 215 is a great finish choice for dark coloured woods and stains. Akva Line™ 215 is low VOC and formaldehyde free.

## HIGHLIGHTS:

- » **Fast Drying**
- » **Excellent Clarity**
- » **Good Stacking Properties**
- » **Formaldehyde Free**
- » **Minimal Grain Raise**
- » **Low VOC**
- » **Light Fast**
- » **Non-Yellowing Performance**

## PRODUCT DATA:

Colour:	Wet: Clear Dry: Clear	VOC (as packaged, maximum, less water and exempt solvents):	1.93 lbs/gal or 232 g/l
Solids % by Vol.:	26 % (Theoretical)	VOC (emitted):	0.68 or 81 g/l
Solids % by Wt.:	29 % (Theoretical)	Lbs. VHAPs / Lbs. Solids:	0.00
Weight / Gal.:	8.63 lb	Flash Point (PMCC):	Does Not Flash
Viscosity 25°C / 77°F:	#4 Ford: 45-50 Sec.	Photo Chemically Reactive:	No
Viscosity 25°C / 77°F:	DIN 4: 35-40 Sec.	Shelf Life:	12 months (at 15-25° C / 59°-77° F)
Viscosity 25°C / 77°F:	Zahn #2 sig.: 60-70 Sec.	Theo. Coverage@1mil dry	416 Sq. Ft./Gal. 100% Efficiency

## MIXING / APPLICATION:

**Working Temp:** >18° C, 65° F substrate, coating and air  
**Hardener:** N/A  
**Catalyzation:** N/A  
**Pot Life:** N/A  
**Mixing:** Mix thoroughly to ensure uniform consistency.  
**Sealer:** Apply as a self-sealed system, or over Akva Line™ Sanding Sealer.  
**Reducer:** May be reduced with water if needed.  
**Application:** 75 - 110 (g/m<sup>2</sup>) Approx. 3 – 4.5 wet mils; Min 1 mil wet –Max 4.5 mil wet @ 60%RH  
**Surface Prep:** Substrate should be clean and free of grease and oil. Moisture content of the wood should be between 6%-8%. For white wood sanding, use 150 or 180 grit sandpaper. For sealer sanding, use 320 grit sandpaper. Always sand the sealer-coat within 8 hours prior to top-coating to improve adhesion.  
**Use Directions:** For interior use only. Stir thoroughly before application to avoid variations in gloss. Stack only when the surface temperature is below 35°C / 95 ° F. Dry time can be directly impacted by many factors, including film thickness. Users are urged to test the system under shop conditions.  
**App. Equip.:** Conventional & HVLP Siphon (gravity) Feed and Pressure Pot Systems and Airless Air Assist Equipment.  
**Tinting:** Can be tinted with Chroma Chem 896 tinters up to 5 %. Prior to application test a sample piece to assure proper colour match.

## DRYING TIMES TO SAND / STACK:

Method	Drying Temp.	Drying Time (@ 60 % RH and thickness @ 1 mil dry)
Air Drying	20° C / 68° F	30-45 min. dry to <b>sand and recoat</b> / 3-4 hr. dry to <b>stack</b>

**APPLICATION RECOMMENDATIONS:**

**APPLICATION EQUIPMENT SETTINGS**

Method of Application	Wet Film		Dry Film	
	Mils	g/m <sup>2</sup>	Mils	Microns
Conventional – Siphon Fed	3 – 4.5 mils	70-110 g/m <sup>2</sup>	0.7 – 1.1 mils	18 - 28 microns
Conventional – Pressure Pot	3 – 4.5 mils	70-110 g/m <sup>2</sup>	0.7 – 1.1 mils	18 - 28 microns
Airless Air Assist	3 – 4.5 mils	70-110 g/m <sup>2</sup>	0.7 – 1.1 mils	18 - 28 microns
HVLP - Siphon Fed	3 – 4.5 mils	70-110 g/m <sup>2</sup>	0.7 – 1.1 mils	18 - 28 microns
HVLP - Pressure Pot	3 – 4.5 mils	70-110 g/m <sup>2</sup>	0.7 – 1.1 mils	18 - 28 microns

All measurements and application equipment settings are based on application at temperature of 68°F. Viscosity will vary depending on the temperature of the liquid. The application equipment setting recommendations are guidelines only. The settings are starting point recommendations and adjustments to the equipment settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer’s recommendations for equipment set-up.

**REDUCTION – TIP SIZE – PSI SETTINGS**

**Conventional Equipment Siphon Feed:**

Reduce to 28-32 seconds with water in a #4 ford viscosity cup, nozzle size 0.060 inches (1.5mm) – 0.080 inches (1.8 mm), atomizing air 25 psi (1.7bar)–40 psi (2.8 bar).

**Conventional Equipment Pressure Pot:**

To be used as is, if needed reduce with water. nozzle size 0.060 inches (1.5mm) – 0.080 inches (1.8 mm) Atomizing air 25 psi(1.7 bar) - 40 psi (2.8 bar), Pot pressure 7 psi (0.48 bar) to 10 psi (0.68 bar)

**Airless Air Assist Equipment:**

To be used as is, if needed reduce with water, nozzle size , tip size.013 inches (0.33mm) - .016 inches (0.41mm), fluid pressure 290 psi (20 bar) – 580psi(40 bar), atomizing air 15psi (1.0 bar) to 20psi (1.5 bar).

**HVLP Equipment Siphon Feed:**

Reduce to 28-32 seconds with water in a #4 ford viscosity cup, 0.60 inch (1.5mm) -.080inch (1.8MM) nozzle, atomizing air 25 psi (1.7 bar) -40 psi (2.8bar).

**HVLP Equipment Pressure Pot:**

To be used as is, if needed reduce with water, nozzle size 0.060 inches (1.5 mm) – 0.080 inches (1.8 mm), atomizing air 25psi (1.7 bar) - 40 psi (2.8 bar). Pot pressure 7 psi (0.48 bar) to 10 psi (0.68 bar)

**PRODUCT NOTES**

- Like most water based products, Akva Line 215™ should not be force dried the first couple of minutes to avoid mud-cracking.
- Using as a self sealed system, some stains may appear lighter.
- Using a solvent based sealer is not recommended in combination with Akva Line 215™.
- Oak or other woods rich in tannic acids can discolour. Users are urged to test the system under shop conditions.
- Cherry may turn green when coated with Akva Line 215™. Users are urged to test the system under shop conditions.
- Maximum recommended dry film thickness for total coating system is 5 dry mils.

**CONTACTS:**

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**TESTING:** Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

**FOR INDUSTRIAL SHOP APPLICATION:** Thoroughly review Material Safety Data Sheet (MSDS) for safety information and cautions prior to using this product. For Regulatory compliance data (i.e. VOC, HAPS, etc.), obtain an Environmental Data Sheet (EDS) prior to using the product. A MSDS and/or EDS is available from your local distributor or representative. Please direct any questions or comments to 1-800-524-5979.

**NOTE:** Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result. Becker Acroma is a brand of The Sherwin-Williams Company.