AP P-CAT CLEAR LACQUER TOPCOAT

NG508C005	**05 Gloss**	**NG508C020**	**20 Gloss**	**NG508C035**	**35 Gloss**
NG508C055	**55 Gloss**	**NG508C080**	**80 Gloss**	**DV507WC00**	**OXP P-Cat Catalyst**

DESCRIPTION:

NG508C AP P-CAT CLEAR LACQUER TOPCOAT SERIES is a pre-catalyzed lacquer platform designed for general wood markets such as the furniture and kitchen cabinet industries. **NG508C** offers high performance, fast dry, high solids and build, with good early hardness characteristics. **NG508C** has no reportable VHAPS.

HIGHLIGHTS:

» 20% Higher Solids ***» Meets KCMA Standards*** ***» Good Flexibility***
» Good Moisture Resistance ***» Good Chemical Resistance*** ***» Contains UV Absorbers***

PRODUCT DATA:

Colors:	**Wet:** Water White **Dry:** Clear	**VOC (as packaged):**	5.18 lb/gal, 621 g/l
Solids % by Wt.:	25% (Theoretical)	**VOC (emitted) as Mixed & Reduced**	5.31 lb/gal, 630 g/l
Solids % by Vol.:	33% (Theoretical)	**Lbs. VHAPs / Lbs. Solids:**	None
Weight / Gal.:	7.94 lb/gal	**Flash Point (PMCC):**	-15.6º C / 4ºF
Viscosity 23ºC / 73ºF (Zahn #2)	**NG508C005** 20-25 seconds **All Others:** 25-30 seconds	**Photo Chemically Reactive:**	No
Rec. Film Thickness	Wet: 3-5 / Dry: 0.8 – 1.3 mils	**Spreading Rate (No Loss)**	580 sq ft/gal @ 1.25 mils DFT
***Gloss @ 60º**	+/- 5º Gloss Variation	**Shelf Life: Unopened / Uncatalyzed:**	2 year (at 15-25º C / 59º-77º F)

Gloss variation can occur due to environmental conditions and substrate differences

MIXING / APPLICATION:

Working Temp: >18º C, 65º F substrate, coating and air
Hardener: **DV507WC00 OPTI P-CAT CATALYST**
Catalyzation: 2.3% **(3 oz. per gallon)** Parts by volume
Pot Life: 4 months. (23º C / 73º F) after catalyzation
Mixing: Add Catalyst under agitation. Use proper graduated cup for measuring. Be attentive to the correct ratio. Add thinner after catalyst. Add thinner to desired viscosity, typically about 20%.
Sealer: Can be self-sealed or used as a topcoat.
Reducer: **Reduce** as needed for application up to 20% with **TT5906000 Thinner 0988 HAPS Free**
Application: 100-125 (g/m²) Approx. 3-5 wet mils; Min 3 mil wet – Max 5 mil wet @ 60%RH
Surface Prep: Sand well with 320-400 grit sandpaper. Topcoat within 8 hours of sanding.
Use Directions: For interior use only. Add hardener and reducer then mix thoroughly before application. Stack only when the surface temperature is below 35ºC / 95 º F. Quicker stacking times are achievable relative to the amount of product that is applied.
App. Equip.: Conventional & HVLP Siphon and Gravity Feed and Pressure Pot Systems and Airless Air Assist Equipment.
Tinting: N/A
Ind. Standards: Meets KCMA specifications as a self-seal system.

DRYING TIMES:

Method	**Drying Temp.**	**Drying Time (77ºF @ 50% RH)**
Air Drying	25º C / 77º F	10-15 minutes **to touch**, 15-20 minutes **to handle**, 30-45 minutes **to recoat & sand**, 8 hours minimum **to pack** **Force Dry** @ 110ºF – 140ºF = 5-10 minutes (allow to cool for 1 hour before packing)

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, AcromaPro cannot make any warranties as to the end result.

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APPLICATION RECOMMENDATIONS:

APPLICATION EQUIPMENT SETTINGS

Method of Application	Wet Film Mils / g/m²	Dry Film Mils / Microns
Conventional – Siphon Fed	3.5 – 4.5 mils / 90-110 g/m²	1.7 - 2.2 mils / 43-56 microns
Conventional – Pressure Pot	3.5 – 4.5 mils / 90-110 g/m²	1.7 - 2.2 mils / 43-56 microns
Airless Air Assist	3.5 – 4.5 mils / 90-110 g/m²	1.7 - 2.2 mils / 43-56 microns
HVLP - Siphon Fed	3.5 – 4.5 mils / 90-110 g/m²	1.7 - 2.2 mils / 43-56 microns
HVLP - Pressure Pot	3.5 – 4.5 mils / 90-110 g/m²	1.7 - 2.2 mils / 43-56 microns

All measurements and application equipment settings are based on application at a 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 18-21 sec. #4 Ford viscosity cup (20-22 sec Sig. Zahn 2 cup), nozzle size 0.070 inches (1.8 mm) to 0.080 inches (2.0 mm), atomizing air 40 psi (2.8 bar) to 50 psi (3.5 bar).
Conventional Equipment Pressure Pot:
Reduce to 18-21 sec. #4 Ford viscosity cup (20-22 sec Sig. Zahn 2 cup), nozzle size 0.070 inches (1.8 mm) to 0.080 inches (2.0 mm), atomizing air 40 psi (2.8 bar) to 50 psi (3.5 bar), Pot pressure 7 psi (0.48 bar) to 10 psi (0.68 bar)
Airless Air Assist Equipment:
Reduce to 18-25 sec. #4 Ford viscosity cup (20-25 sec Sig. Zahn 2 cup), tip size 0.013 inches (0.33 mm) to 0.016 inches (0.41 mm), fluid pressure 290 psi (20 bar) to 580 psi (40 bar), atomizing air 11 psi (0.8 bar) to 17 psi (1.2 bar).
HVLP Equipment Siphon Feed:
Reduce to 17-21 sec. #4 Ford viscosity cup (19-22 sec Sig. Zahn 2 cup), nozzle size 0.070 inches (1.8 mm) to 0.080 inches (2.0 mm), atomizing air 35 psi (2.4 bar) to 45 psi (3.1 bar).
HVLP Equipment Pressure Pot:
Reduce to 17-21 sec. #4 Ford viscosity cup (19-22 sec Sig. Zahn 2 cup), nozzle size 0.070 inches (1.8 mm) to 0.080 inches (2.0 mm), atomizing air 20 psi (1.37 bar) to 25 psi (1.72 bar). Pot pressure 7 psi (0.48 bar) to 10 psi (0.68 bar)

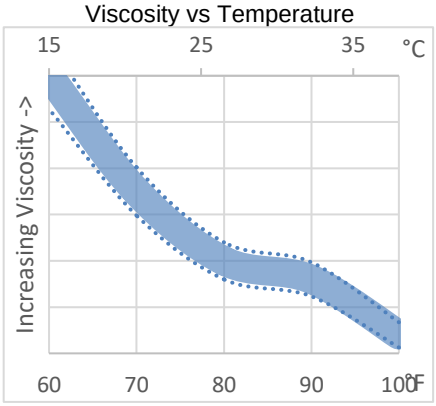
CONTACTS:

PH: AcromaPro USA and Canada / 1-888-277-1448
www.AcromaPro.com

PRODUCT NOTES

- Maximum recommended dry film thickness for total coating system is 4 dry mils. Heavier film build may cause cracking.
- Temperatures must be above 68°F during application and cure to ensure acceptable coating properties.
- AP P-CAT CLEAR LACQUER TOPCOAT must be catalyzed 2.3% by volume (3 oz per/gal) with the recommended catalyst. Do not over catalyze as this may cause cracking over time.

Viscosity vs Temperature



The above chart is for information only and should not be used as product specifications.

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