

Product Codes:

423-9520	Low Gloss
423-9535	Satin
423-9550	Semi-Gloss
423-9590	Gloss

VISCOSITY:	Zahn #2 signature cup 58 sec at 25°C
FLASH POINT:	NA (>93°C)
DENSITY (Kg/L):	1.03
SOLID (% by weight):	36%
SOLID (% by volume):	33%
SHELF LIFE (months):	12

Product Description: Acryllak is an acrylic modified polyurethane waterborne clear finish. Acryllak is a wear resistant, fast drying and environmentally clean lacquer. It is resistant to conventional detergents and household cleaners.

Uses: Acryllak 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.

Environmental Data (as supplied):

VOC less exempt lb/gal:	1.57
VOC lb/gal:	0.65
VOC less exempt g/l:	188
VOC g/l:	78
VOC lb/lb Solid:	0.21
VHAPs lb/lb Solid:	0.14

See individual compliance sheets for specific data

Application Data:

SUGGESTED USES:	Clear Waterborne Lacquer
MIXING RATIO:	NA
POT LIFE:	NA
APPLICATION VISCOSITY:	Zahn #2 signature cup 58 seconds
REDUCER:	Water if necessary
RETARDER:	NA
CLEAN-UP SOLVENT:	Soap and water when wet, 4:1 water:100-119 if dried
APPLIED FILM THICKNESS:	3-5 wet mils (exceeding this can cause haze)

Directions for Use

Acryllak WB Clear TC
423-95XX

Surface Preparation:

Substrate to be coated should be sanded with 150 or 180 grit sandpaper prior to coating. This product may be used self-sealed or sealed with 423-10XX line Aqualux.

General information:

Mix material before use. Apply by spray at wet film builds of 3-5 mils. Application and drying conditions must be at temperatures of 18°C or higher and at a humidity of less than 65%. Increased air flow or drying temperatures, including the use of infrared, will greatly decrease dry times.

Further coats may be applied after complete drying followed by sanding with 280/320 grit sandpaper. Second and subsequent coats must be applied the same day as the board is sanded.

Product must be agitated thoroughly at all times to ensure product consistency. Contact with metal surfaces should be avoided.

Film build should not exceed 2 dry mils per coat. Total film build must not exceed 4 dry mils.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION.

Drying Times:

	At 20°C (Minimum Required)	At 50°C (Minimum Required)
Tack Free Time:	20 minutes	Flash off before entering oven
Dry to Sand:	2-3 hours	45 minutes
Dry to Stack:	Overnight	4-6 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.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

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.

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