TECHNICAL DATA SHEET

AKRYLAK 202

CAB-ACRYLIC TOPCOAT

Formaldehyde free

DESCRIPTION

AKRYLAC 202 CAB-acrylic topcoat that features a water white clear finish with excellent non-yellowing properties. Great for use as a clear coat over white, stained, metallic finishes or natural unstained woods.
The Akrylak 202 is a versatile product which can be used as a single component or as a 2 component with optional catalyst. This high-performance clear topcoat, meets or exceeds KCMA testing providing a finishing system that has excellent chemical and moisture resistance. can be used as a single component or 2 component with optional catalyst.

PRODUCT DATA

Color	Clear	**VOC less exempts**	730.13 g/L	6.09 lb/gal
Solids % by Vol	20% ± 2%	**VOC actual**	754.86/L	6.30 lb/gal
Solids %by Wt	27% ± 2%	**Photochemical reactive**	No	
Density	0.92	**Flash Point (PM/CC)**	N/A	
Viscosity 23°C/73°F #4 Ford	15	**Shelf life**	6 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	20, 35,50,90/Available in other gloss level	**Theo-coverage @1 mil dry**	320-330 Sq.Ft/gal	6 m^2/L

PREPARATION/APPLICATION

Working Temp >18°C/65°F surface, coating and air

Catalyzation 10 % by volume using C 99 catalyst - 10 parts AKRYLACK 202 to 1 part C 99 catalyst.

Pot life 6 hours (23°C/74°F)

Reducer Product can be applied without reduction. If reduction is needed to optimize application, reduce 15-25% by volume with DEDE L THINNER (medium).or DEDE SL THINNER (slow).
To help reduce trapped air, blushing or orange peel, use Retarder LR236 at a maximum of 5%.by volume

Film thickness Min 4 mil wet –Max 5 mil wet

Suggested Sealer MV 22 Sealer, VS VINYL SEALER, FK 70 SEALER

Application

- Color Wood-Stain or tone as desired and dry thoroughly.
- Seal-Apply a full coat of a recommended LORCHEM sealer at 4.0 – 6.0 wet mils. See sealer data sheet for details.
- Air dry 30-45 minutes, sand with 240, 320 paper. Topcoat within 8 hours of sanding
- Topcoat – apply AKRYLAC 202 at 4.0 - 6.0 mils wet
- For more depth or build, sand and apply an additional coat.

Surface Preparation Wood surface must be clean, dry, and finish sanded with 180 grit sandpaper Substrate should be clean and free of grease and oil to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.

Use Directions For interior use only. Catalyze, adjust viscosity and stir thoroughly before application to avoid variations application. 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 cup gun and Airless/Air Assist Equipment.

Tinting Can be tinted up to 20% maximum with universal colorants 844.

Cleanup Clean tools/equipment immediately after use with T 750 LORCHEM cleaner gun or a quality lacquer thinner or acetone. Always follow manufacturer's safety recommendations when using any solvent.

Standards This product meets KCMA and CKCA standards when used over recommended LORCHEM sealers.

DRYING TIMES

Method	Drying temperature .	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	**Dust free time**	3-4 minutes	**Dry to sand**	30-60 minutes
		Dry to touch	10 minutes	**Dry to recoat**	30-60 minutes
		Dry to Handle	15-25 minutes	**Dry to stack**	12 hours
Force dry	45to 60°C/110-140°F	10-20 Minutes			

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Minimum curing temperatures of 23°C/74°F must be maintained throughout curing cycle to achieve the film integrity as stated in product features.

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APPLICATION RECOMMENDATIONS

APPLICATION EQUIPMENT SETTINGS

Method of Application	Air Pressure (PSI)	Fluid Pressure (PSI)	TIP size (mm / inch)	Application Viscosity (#FORD 4)	Thickness Film (Mils)
Conventional spray	40-50	08-12	1.8-2/0,070-0,078	18-21	3-5
Airless Spray	10-18	300-600	0,28-0,33/0,011-0,012	18-21	3-5
HVPL	35-45	8-12	1.19-1,39/0,047-0,055	18-21	3-5

Note: All measurements and application equipment settings are based on application at a temperature of 23°C/74°F. Viscosity will vary depending on the temperature of the liquid. The above-mentioned application equipment recommendations are guidelines only. The noted settings are starting point recommendations and that adjustment to the settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

SPECIFICATIONS

- For interior use only.
- Must be agitated before and during using.
- Must be catalyzed with C99 catalyst at a level of 10% by volume. Over catalyzing or using incorrect catalyst may result in blooming, cracking and poor adhesion.
- Store at room temperature (under25°C/ 80° F) after catalyzation. Higher temperatures will reduce the pot life.
- Can be used as a self-sealing or over recommended LORCHEM sealer. Please contact your LORCHEM representative for system recommendations.
- Total film thickness of systems must not exceed 7.0 mils dry film because heavier films may cause cracking tendency.
- Yellowing over white and pastel colors may occur due to the yellowing tendency of the color system (stain, basecoat, etc.), and not to the clear Acrylic topcoat.

CAUTIONS

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.

THESE PRODUCT ARE DESIGNED FOR INDUSTRIAL SHOP APPLICATION AND PROFESSIONAL USE ONLY

Thoroughly review Safety Data Sheet (SDS) for safety information and cautions prior to using this product. Please direct any questions or comments to your local representative.

PDS

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 ,preparation and application which are not known or under our control, LORCHEM cannot make any warranties related to the product or the performance of the product. Moreover, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is not caused by the quality of the product.

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