PRE-CAT 24 SEALER

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DESCRIPTION

PRE-CAT 24 Sealer is a precatalysed sealer with fast dry to sand and recoat time for interior natural or stained woodwork. This fast-drying sealer is easy to sand and is pre-reduced for ready to spray application. For use under recommended LORCHEM precatalyzed topcoats.

PRODUCT DATA

Color	Clear	**VOC less exempts**	683.42 g/L	5.70 lb/gal0
Solids % by Vol	15% ± 2%	**VOC actual**	687.84 g/L	5.74 lb/gal
Solids %by Wt	22% ± 2%	**Photochemical reactive**	No	
Density	0.89	**Flash Point (PM/CC)**	N/A	
Viscosity 23°C/73°F (Ford #4)	23± 2	**Shelf life**	6 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	Flat	**Theo-coverage @1 mil dry**	180 Sq.Ft/gal	4 m^2/L

PREPARATION/APPLICATION

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

Catalyzation N/A

Pot life N/A

Reducer Product is normally applied without reduction. If reduction is needed to adjust drying or build, reduce 10-15% by volume with DX 180 THINNER (Medium), DX 195 THINNER (slow).

Film thickness Min 4 mil wet –Max 5 mil wet

Recommended Topcoat UNILAC 100, AVERSA 90

Application

- Color Wood-Stain or tone as desired and dry thoroughly.
- Seal- Apply a full coat of PRECAT 24 at 4.0 – 6.0 wet mils.
- Allow to dry. Sand with 240, 320 paper, or sponges as required. Topcoat within 8 hours of sanding.
- Topcoat – apply a recommended topcoat 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, free of grease and oil and finish sanded with 180 grit sandpaper to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.

Use Directions For interior use only. 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 & HVLP Siphon Feed, Pressure Pot Systems and Airless/Air Assist Equipment.

Tinting Can be tinted up to 10% 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.

DRYING TIMES

Method	Drying temperature.	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	**Dust free time**	4-6 minutes	**Dry to sand**	1 hour
		Dry to touch	20-30 minutes	**Dry to recoat**	1 hour
		Dry to Handle	1 hour	**Dry to stack**	6 hours
Force dry	45to 60°C/110-140°F	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.
- This product should be thoroughly sanded within 4 hours of being applied. If the sealer is not topcoated the same day, it should be resanded immediately before topcoating to insure optimum intercoat adhesion.
- Do not apply more than one coat of sealer for build. Multiple coats of topcoat are recommended rather than multiple coats of sealer.
- Store at room temperature (under 25°C/ 80° F). Higher temperatures will reduce the storage life.
- Can be used over recommended LORCHEM Topcoat. 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 show cracking tendencies.

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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