TECHNICAL DATA SHEET

POLYACRIL 130

ACRYLIC TOPCOAT

DESCRIPTION

Polyacril 130 is low sheen acrylic catalyzed topcoat with excellent non-yellowing properties. This high-performance clear topcoat meet or exceed KCMA test requirements providing a finishing system that has excellent chemical and moisture resistance and built in scratch resistance.

Formaldehyde free

PRODUCT DATA

Color	Clear	**VOC less exempt**	751.76 g/L	6.27 lb/gal
Solids % by Vol	21% ± 2%	**VOC**	731.76 g/L	6.11 lb/gal
Solids %by Wt	37% ± 2%	**Photochemical reactive**	No	
Density	0.95	**Flash Point (PM/CC)**	N/A	
Viscosity 23°C/73°F #4 Ford	24-27	**Shelf life**	6 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	Flat (2-5)	**Theo-coverage @1 mil dry**	335-345 Sq.Ft/gal	8-9 m^2/L

PREPARATION/APPLICATION

Working Temp	>18°C/65°F surface, coating and air
Catalyzation	10 % by volume using C 95 catalyst - 10 parts POLYACRIL 130 to 1 part C 95 catalyst.
Pot life	4 hours (23°C/74°F)
Reducer	Reduce 15-30% by volume with DEDE L THINNER (medium).or DEDE SL THINNER (slow). To help reduce trapped air, blushing or orange peel, use Retarder LR 236 at a maximum of 5%.by volume
Film thickness	Min 4 mil wet –Max 5 mil wet
Suggested Sealer	VS SEALER, FK 70 SEALER, MV 22
Application	♦ Color Wood-Stain or tone as desired and dry thoroughly ♦ Seal-Apply a full coat of recommended sealer at 4.0 – 5.0 wet mils. See sealer data sheet for details. ♦ Allow to dry. Sand with 240, 320 paper, or sponges as required. Topcoat within 8 hours of sanding ♦ Topcoat – apply POLYACRIL 130 at 4.0 - 5.0 mils wet ♦ For more depth or build, sand and apply an additional coat. ♦ Do not exceed 7.0 mils DFT for the total system.
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 & 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 T750 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**	2-3 minutes	**Dry to sand**	30-45 minutes
		Dry to touch	20 minutes	**Dry to recoat**	30-45 minutes
		Dry to Handle	30-45 minutes	**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 stirred before and during using.
- Must be catalyzed with C95 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.
- Do not use as a self-sealing system because of a potential for lifting in multi-coat application, and poorer overall performance properties.
- Can be used 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 show 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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