

COLUMBIA

Industrial Supplies



Maintenance and Care Instruction For AcromaPro Top-Coat Systems

AcromaPro's coatings are known for their excellent durability. They meet or exceed the testing standards set forth by leading international Kitchen Cabinet Associations.

1. General cleaning should be performed with a cloth dampened with warm water and a mild dish detergent.
2. A cloth dampened with mineral spirits may remove stains, marks, or spots that are not removed by general cleaning.

CAUTION:

- Do not use cleaners that contain abrasives.
- Do not use cleaners that contain ammonia – they may discolor.
- It is always recommended that a small inconspicuous area be tested when using any cleaner.
- Avoid bearing down as this may cause burnishing.

These instructions are general industry cleaning procedures, and are offered with no expressed warranty implied.



UNICLEAR™ POST CATALYZED TOPCOAT

DM53150XX (10,15,20,25,40,50,60,80 Gloss)

DESCRIPTION:

Uniclear™ Post Catalyzed Topcoat is a high performance, fast drying, extremely durable, acid cured conversion varnish for interior woodworking. It has high solids, yet creates a beautiful close to the grain look with excellent self-sealing, easy to sand properties. This conversion varnish has excellent chemical resistance and meets KCMA/CKCA standards. Uniclear™ Post Catalyzed Topcoat provides excellent clarity and is both water white and non-yellowing.

PRODUCT DATA:

Color:	Wet: Clear Dry: Clear	VOC (as packaged, maximum, less water and exempt solvents):	4.74 lbs/gal or 567 g/l
Solids % by Vol.:	34 % (Theoretical)	VOC (emitted):	4.74 lbs/gal or 567 g/l
Solids % by Wt.:	42 % (Theoretical)	Lbs. VHAPs / Lbs. Solids:	0.17 before catalyzed
Weight / Gal.:	8.16 lb	Flash Point (PMCC):	13° C / 55.4° F
Viscosity 23°C / 74°F:	#4 Ford: 26-31 Sec.	Photo Chemically Reactive:	Yes
Viscosity 23°C / 74°F:	DIN 4: 19-23 Sec.	Shelf Life:	1 year (at 15-25° C / 59°-77° F)
Viscosity 23°C / 74°F:	Zahn #2 sig.: 20-24 Sec.	Theo. Coverage@1mil dry	545 Sq. Ft./Gal. 100% Efficiency

MIXING / APPLICATION:

Working Temp: >18° C, 65° F substrate, coating and air
Catalyzation: 10% by volume using either Catalyst 2750 (standard), Catalyst 494 (slow), or Catalyst 309 (HAPS free, fast).
Pot Life: 8 hrs. (23° C / 74° F)
Mixing: Mix thoroughly to ensure uniform consistency. Add catalyst under agitation then add solvent to adjust viscosity if necessary.
Sealer: Can be used as a self-sealed system or over Care Seal™ or Care Seal™ HS Post Catalyzed Sealers.
Reducer: Thinner 219 (regular), Thinner OC 140 (fast), Thinner 309 (fast, HAPS free), Thinner 419 (slow, HAPS free).
Application: 75 - 100 (g/m²) Approx 3 - 4 wet mils
Surface Prep: Substrate should be clean and free of grease and oil. Moisture content of the wood should be between 6%-8%. White Wood sand with 180 grit sandpaper. Sand the first coat (with 280 to 320 paper) to eliminate grain raising and improve adhesion of the subsequent coat. Topcoat within 8 hours of sanding.
Use Directions: For interior use only. Mix thoroughly before application. Stack only when the surface temperature is below 35°C / 95 ° F. 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 and Pressure Pot Systems and Airless Air Assist Equipment.
Tinting: Can be used with Chroma Chem 844 colorants. Do not exceed 5% black or blue. All other colorants can be used to a maximum of 10%. Do not exceed 10% total colorant. Prior to application, test a sample piece to ensure proper color match.
Ind. Standards: This product meets KCMA and CKCA standards.

DRYING TIMES TO SAND / STACK / RECOAT WINDOW:

Method	Drying Temp.	Drying Time (@ 60 % RH and thickness @ 1 mil dry)
Air Drying	20° C / 68° F	1hr. dry to sand / 4 – 5 hr. dry to stack
*Forced Drying	70° C / 158° F	30-40 min. dry to sand / 1 -2- hr. dry to stack

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APPLICATION RECOMMENDATIONS:
APPLICATION EQUIPMENT SETTINGS

Method of Application	Wet Film		Dry Film	
	Mils	g/m ²	Mils	Microns
Conventional – Siphon Fed	3 – 4 mils	75-100 g/m ²	1.0-1.4 mils	25.4-35.5 microns
Conventional – Pressure Pot	3 – 4 mils	75-100 g/m ²	1.0-1.4 mils	25.4-35.5 microns
Airless Air Assist	3 – 4 mils	75-100 g/m ²	1.0-1.4 mils	25.4-35.5 microns
HVLP - Siphon Fed	3 – 4mils	75-100 g/m ²	1.0-1.4 mils	25.4-35.5 microns
HVLP - Pressure Pot	3 – 4mils	75-100 g/m ²	1.0-1.4 mils	25.4-35.5 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 seconds #4 ford viscosity cup, nozzle size 0.070 inches (1.8mm) – 0.0 inches (2.0 mm), atomizing air 40 psi (2.8bar)–50 psi (3.5 bar).

Conventional Equipment Pressure Pot:

Reduce to 18-21 seconds #4 ford viscosity cup, nozzle size 0.472 inches (1.2mm) – 0.055 inches (1.4 mm), atomizing air 40 psi (2.8 bar)–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 seconds #4 ford viscosity cup, tip size .011 inches (0.28mm) - .013 inches (0.33mm), fluid pressure 290 psi (20 bar) – 580psi(40 bar), atomizing air 11psi (0.8 bar) to 17psi (1.2 bar).

HVLP Equipment Siphon Feed:

Reduce to 17-21 seconds #4 ford viscosity cup, .061inch (1.5mm) -.072inch (1.8MM) nozzle, atomizing air 35psi (2.4bar) -45 psi (3.1bar).

HVLP Equipment Pressure Pot:

Reduce to 17-21 seconds #4 ford viscosity cup, 0.472 inches (1.2mm) – 0.055 inches (1.4 mm) nozzle, atomizing air 20psi (1.37 bar) -25 psi (1.72 bar). Pot pressure 7 psi (0.48 bar) to 10 psi (0.68 bar)

CONTACTS:

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www.AcromaPro.com


PRODUCT NOTES

- To help reduce trapped air, blushing or orange peel, use Retarder 0987 at a maximum of 2% by volume.
- For better flow and leveling, use Thinner 419 at a maximum of 3% by volume.
- Do not catalyze in an unlined metal container.
- Gloss may vary when recoating.
- This product meets KCMA and CKCA standards when used as a self-seal system or over a recommended AcromaPro sealer.
- Maximum recommended dry film thickness for the total coating system is 6 dry mils.
- Can be used over recommended AcromaPro water-based and solvent-based stain systems. Please contact your AcromaPro representative for system recommendations.

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.