

Technical Data Sheet

EM1520-0010

Lacroma Clear 10 SP

Product description

Multicoat lacquer with very good adhesion to AC and UV-coatings. Applied on stain the product will reach relative similar outlook like 2K PUR lacquer. The stackability after "force-dry" and "vertical-ovens" are limited.

Product data

Gloss:	8-12	Gardner 60°	
Solid content:	36 ±1	[weight %] theoretical	
Specific gravity:	1040 ±30	[kg/m ³]	
Viscosity:	60-66	[s] DIN 4	test performed at 23 °C
PH:	7,4-7,9		
Frost sensitive:	Yes		
Storing:	6 months	At 5-30 °C	
Process Temperature:	18-30 °C	To achieve the best result and consistency follow the application and surface temperatures given in Schedule of Application for each specific technology and production line.	

Recommended application method

Method	Hardener	Amount hardener [Parts by vol]	Dilutant	Application viscosity	Application amount [g/m ²]	Notes
Air mix spraying			Water	delivered	80-120	
Air less spraying			Water	delivered	80-120	Paint pressure should be above 120 bar
Stir well before use!						
Cleaning:	XX699					
	Water					

Drying

Method	Drying condition	Drying time	Notes
Forced drying	70 °C	15-20 min	depends on amount
Air Drying	20 °C	1-2h	depends on amount

All kind of drying requires good ventilation and circulation
Do not stack before surface temperature below 30 °C

Curing

UV-dose	Min UV dose [mJ/cm ²]	Rec min Peak. [mW/cm ²]	Min UV dose [mJ/cm ²]	Rec min Peak. [mW/cm ²]
	Hg lamps (280-320 nm)	Hg	Ga lamps (390-450 nm)	Ga
Full cure	N/A			
Semi cure	N/A			

Note - Required Peak/Energy is depending on several factors, such as substrate, amount of application, number of layers and type of UV oven / reflectors. Recommended Peak/Energy values will be stated in the finishing instruction/process control submitted by technician.

General information

According to Swedish legislation we provide information regarding dangerous materials. The Safety Data Sheet contains facts about the components, primarily solvents and acids which present the dangerous characteristics. The Safety Data Sheet will be sent on request. All values and recommendations above are to be considered as guidance only. Many factors beyond our control may have an influence on the coating result. Should a problem arise, please contact us and we will advise accordingly. We reserve the right to alter the above specifications.

Date issued: 2017-02-27 (Valid 1 year from issue date)

Latest update: 160930