

Technical Data Sheet

EM635-0010

Lacroma Clear 10

Product description

One pack waterborne clear lacquer for surface treatment of furniture and fittings of most woods. Fast drying and easy to sand. Designed for forced drying. Gives a tough and resistant surface.

Product data

Gloss:	7-12	Gardner 60°	
Solid content:	33 ±1	[weight %] theoretical	
Specific gravity:	1040 ±30	[kg/m ³]	
Viscosity:	24-28	[s] DIN 4	test performed at 23 °C
pH	8,1-8,6		
Frost sensitive:	Yes		
Storing:	12 months	At 5-30 °C	Storing at higher temperature reduces shelf life, do not expose to direct sunlight
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.

Mixing/Application

Recommended application method	Hardener	Amount hardener [Parts by vol]	Dilutant	Application viscosity	Application amount [g/m ²]	Notes
Air mix spraying			Water	delivery	80-110	
Air less spraying			Water	delivery	80-110	Paint pressure above 120 bar
Stir well before use!						
Cleaning:	XX699					
	Water					

Drying

Method	Drying condition	Drying time	Notes
Jet air	50-55°C	10-20 min	Depends on amount
Air Drying	20-25 °C	40-50 min	Depends on amount

All kind of drying requires good ventilation and circulation

Do not stack before surface temperature below 30 °C

Exterior products: should not be exposed to water, water condensation or temperatures below 0 °C with in 48 h after application

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 application amounts and 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.

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