

Technical Data Sheet

EX1620-0111

Lacroma wax

Product description

One component waterborne wax lacquer for interior furnitures and fittings. Intended originally for pine substrates but usable for all different wood substrates, as a one layer application. For a smoother finshed surface a light post sanding are recomended. Fast drying and more environmental friendly than solventborn alternatives

Product data

Gloss:	N/A	Gardner 60°	
Solid content:	41 ±1	[weight %] theoretical	
Specific gravity:	1200 ±30	[kg/m³]	
Viscosity:	400-600	[mPas] Rheometer	test performed at 23 °C
pH	7-9		
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 achive 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/m²]	Notes
Air mix spraying			Water	delivered	60-80	
Air less spraying			Water	delivered	60-80	Paint pressure should be above 120 bar
Dipping/Flow coating			Water	delivered	60-80	

Stir well before use!

Cleaning:	XX699
	Water

Drying

Method	Drying condition	Drying time	Notes
Jet air/ IRM	50 °C	5-8 min	depends on amount
Air Drying	20 °C	15-30 min	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/cm2]	Rec min Peak. [mW/cm²]	Min UV dose [mJ/cm2]	Rec min Peak. [mW/cm²]
	Hg lamps (280-320 nm)	Hg	Ga lamps (390-450 nm)	Ga

Full cure

Semi cure

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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