

Beckers



Becker Acroma

## Becker Acroma Product Application Recommendations

For: Euroclear DM 5319-00## Innovat Clear DM5329-00##

### Substrate Preparation

Sand wood substrate to 150 grit on open grain woods, 180 on closed grain woods. Substrate to be cleaned, and free of grease and oil. Moisture content of the wood to be between 6%-8%.

### Ambient Conditions

Temperatures of coating, substrate and ambient conditions should be between 64F (18C) and 85F(30C) with a relative humidity between 20% and 70%

### Application Equipment

**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 (2.8 bar)–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 .011inches (0.28mm) - .013 inches (0.33mm), fluid pressure 290 psi (20 bar) – 580 psi(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 (3.1 bar).

**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)

*The above mentioned application equipment recommendations are guidelines only, please refer to your specific equipment manufacturer's recommendations for equipment set up.*

### **Catalysts Compatible with these Becker Acroma Products**

Catalyst 2750            DV5940                            Catalyst 494    DV5942  
Catalyst 309            DV5943

Please refer to your local Becker Acroma representative for a catalyst recommendation to suit your specific application. Catalyze virgin material 12% by volume. Refer to specific product information sheet for pot life information.

### **Reducers Compatible with these Becker Acroma Products**

Thinner OC140            DT5900                            Thinner 309    DT5903  
Thinner 219            DT5910                            Thinner 419    DT5914

Please refer to your local Becker Acroma representative for a reducer recommendation to suit your specific application

### **Retarders Compatible with these Becker Acroma Products**

(maximum addition 5%):

Retarder 0987            TT5907                            Retarder P    DT5918  
Lacquer Retarder      NT5914

Please refer to your local Becker Acroma representative for a retarder recommendation to suit your specific application

### **Maximum Film Build Per Coat**

150g / m or 6 wet mils

### **Total System Maximum Film Build**

The total maximum film build for the entire finishing system should not exceed 6 dry mils total

### **Sanding Between Applications of Product**

To maintain inter-coat adhesion, after each coat is applied it must be sanded before a subsequent coat is applied. A sanding grit no lower than 280 and no higher than 600 should be used. This sanding must occur within 8 hours of recoating.

### **Application Method**

1. Flush out application equipment with a compatible Becker Acroma Reducer
2. Accurately catalyze, reduce and mix the material to ensure proper uniformity. The material should be mixed at all times.
3. Adjust pressures on application equipment and ensure proper tip / nozzle size
4. Spray applications should have a 50% overlap between passes to ensure a uniform finish
5. Allow product to dry as recommended on the specific product information sheet
6. Flush out application equipment with a compatible Becker Acroma Reducer

### **Warning**

Always pre test the finishing material on the substrate to verify the suitability of the finishing system for your specific conditions