



Becker Acroma Product Application Recommendations

For: Satin White Precat Lac.	NG52002-90013
White Precat Lac. Semi-Gloss	NG52002-90016
White Precat Primer Filler	ND52002

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.

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. Reduce to achieve desired viscosity.

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

120g / m or 5 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