



Becker Acroma Product Application Recommendations

For: Akvasurf Recent New ED5561-9002

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%.MC. Woods that are abnormally high in tannic acid may tend to change the color of the coating when dried.

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 22-25 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 22-25 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 22-25 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 22-23 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 22-23 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

Compatible Becker Acroma Catalysts

Not Applicable

Compatible Becker Acroma Reducers

Clean filtered water

Compatible Becker Acroma Retarders

Not Applicable

Maximum Film Build Per Coat

110g / 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 intercoat 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 measure the viscosity and adjust to application values. Mix the material well to ensure a homogeneous blend
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 product information sheet
6. Flush out application equipment with water.

Warning

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