

NAW1300

Luster Lac Professional White Undercoat – 680 VOC

Date: August 31, 2017 (supersedes all previous revisions)



GENERAL INFORMATION

Axalta's LUSTER LAC™ Professional White Lacquer Undercoat is a versatile, nitrocellulose, white lacquer undercoat formulated for use in interior finishing. It is a very fast drying and easy to apply undercoat with excellent hiding, flow and build properties. It is easy to touch-up, recoat and repair and has excellent sanding properties. For Wood Substrates Only.



1. PRODUCTS

- NAW1300



2. MIXING RATIO

- Before using, mix product by hand, or use mechanical agitation such as an air mixer until there is no material on the bottom of the container. All products should be stirred well before use and, for best results, continuously agitated while in use.



3. SHELF LIFE @ 77°F (25°C)

- 24 months



4. CLEAN UP

- Clean equipment with warm water. If coating has dried, acetone may be required to remove dried film. Keep container closed when not in use to avoid skinning



5. ADDITIVES



6. SURFACE PREPARATION

- Surface must be clean and dust free with a moisture content of 6-8% prior to finishing. Remove all dust, dirt, wax and wood marks. Proper sanding and preparation of the wood is critical to achieving consistent results.
- On new wood, finish sand surface with 150-180 grit sandpaper
- On previously finished wood, remove all old paint or varnish and follow new wood procedure.



7. COMPANION PRODUCTS

- NAW130X Series Luster Lac™ White Lacquers



8. TECH NOTES



9. SUBSTRATES

- Commonly used furniture and cabinetry woods
- MDF/HDF

NOTE: Not to be used on exterior applications



10. APPLICATION

- Use only equipment with plastic, stainless steel, or Teflon coated valves and parts



11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	10-15 minutes
Flash between coats	20-30 minutes
To Stack	12-16 hours



12. FORCE DRY

Flash	5-8 minutes
Bake	15 minutes @ 125° F
Cool Down	10 minutes
Stack	2 hours after cool down



13. GUN SET UP

Gravity Feed	1.6mm – 1.8mm
Siphon Feed	1.8mm – 2.0mm
Airless	10 – 15 thousandths
Air-Assisted Airless	11 – 15 thousandths

AIR PRESSURES

Gravity Feed	30-35psi (2.0 – 2.4 bar)
Siphon Feed	35-40 psi (2.4 – 2.8 bar)
Air-Assisted Airless	5-10 psi (0.3 – 0.7 bar)
See spray gun manufacturer data for more information	



14. PHYSICAL DATA

Viscosity	95-115 KU (Stormer)
Weight Solids %	47.50%
Volume Solids %	26.59%
Actual VOC	609.66 g/l
VOC Ratio (lb.voc/lb.solids)	0.36lb VHAP/lb solid
Regulatory VOC (less water and exempt solvents)	1.10lb VOC/lb solid
Weight Per Gallon	9.70 lbs/gal
Flash Point	22°F Closed Cup
Theoretical Coverage	426.5 ft/gal @ 1 mil dry
VHAP (lb.HAP/lb.solids)	0.36lb VHAP/lb solid
Photochemically Reactive	Yes
Coating Category	White

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Application Notes:

Always pre-test the system on your substrate to verify suitability of the application. Stir thoroughly before use and occasionally during use. Apply by spray only, using Conventional Air, HVLP, Airless or Air-Assisted Airless equipment.

Apply at a rate of 3–4 wet mils. Sand with 240–320 grit, no fill sandpaper. Remove sanding dust before continuing with topcoat application.

This product must be topcoated. Topcoat with NAW130X Series 680 VOC White Lacquers.

DO NOT APPLY more than two coats at 3-4 wet mils per coat. Maximum film thickness of the total coating system MUST NOT EXCEED 4 dry mils.

Drying Time:

Dry to touch: 10-15 minutes

Dry to sand and recoat: 20-30 minutes (depending on ambient conditions)

This product is best applied when surface and air temperatures are between 55°–90° F (12°–32°C) and when relative humidity is below 50% during application and drying time. Low temperatures, poor air circulation or high humidity will extend dry times. Abnormal conditions of temperature or humidity may adversely affect product performance.

Clean Up:

Refer to your local regulations for compliance requirements for cleaning solvents. Dispose of dirty solvent and cleaning rags in a safe and compliant manner. Solvent or lacquer soaked rags should be stored in water-filled, closed containers prior to disposal.

Precautions:

These products are recommended for professional application and are designed for interior use only. Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and to avoid potential need for costly refinishing. Axalta Industrial Wood Coating products are designed to protect and enhance the natural beauty of wood, but cannot eliminate natural discoloration or deterioration of wood as it ages

Additional notes:

Do not mix with other finishing systems or deviate from these finishing recommendations. Axalta will not be held liable for finish failures resulting from the mixing of products or deviations from finishing recommendations.

Storage:

Store in a cool, dry place. Close all containers after use. Do not store near heat or sparks. Spills should be cleaned up with non-sparking tools. [See the product MSDS for complete safety information.](#)

Warning:

Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and avoid potential need for costly refinishing. All dry times listed are as tested under ideal indoor environmental conditions of 78°F (26°C) with relative humidity not exceeding 50%. These products are recommended for use under temperature conditions of 55°-90° F (~12-32°C) and when relative humidity is below 50% during application and drying time. Low temperatures, poor air circulation or high humidity will extend dry times. **Axalta strongly recommends against use of these products if temperatures of air, material, or surface to be coated are below 55°F (12°C) or below the dew point. Abnormal conditions of temperature or humidity may adversely affect product performance.** Please contact your authorized Axalta Industrial Wood Coating distributor for additional product use recommendations and finishing guidance.