# GENERAL INFORMATION

Axalta’s Luster Lac™ Premium White Lacquers are high quality, nitrocellulose lacquer topcoats formulated for use in interior finishing. They are very fast drying and easy to apply topcoats with excellent hiding, flow, and build properties. These products are designed to be used in conjunction with a companion White Lacquer Undercoat for best results. Containers are short-filled and the product is controlled for tint strength for easy color mixing. This product is designed for professional application only. For Wood Substrates Only.

# PRODUCTS

* NAW1319 – Gloss
* NAW1316 – Semi-Gloss
* NAW1312 - Satin

# 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.

# SHELF LIFE @ 77°F (25°C)

* 24 months

# CLEAN UP

● 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.

# ADDITIVES

# 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.

# COMPANION PRODUCTS

* NAW1460 Luster Lac™ White Lacquer Undercoat-550VOC

# TECH NOTES

# #SUBSTRATES

* Commonly used furniture and cabinetry woods
* MDF/HDF

**NOTE:** Not to be used on exterior applications

# APPLICATION

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

# FLASH / DRY TIMES

**AIR DRY @ 77°F (25°C)**

|  |  |
| --- | --- |
| Dry to touch | 15-20 minutes |
| Flash between coats | 30-40 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 |

# 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 |

1. **PHYSICAL DATA**

|  |  |
| --- | --- |
|  Viscosity |  70-80 KU (Stormer) |
|  Weight Solids % | 38.49-42% |
|  Volume Solids % | 24.34-25.96% |
|  Actual VOC | 3.02-3.21lbs/gal of Product |
|  VOC Ratio (lb.voc/lb.solids) | 0.86-0.92lb VOC/lb solid |
|  Regulatory VOC (less water and exempt solvents) | 544.71-545.06 g/l |
|  Weight Per Gallon | 8.51-8.88 1bs/gal |
|  Flash Point | 22ºF Closed Cup |
| Theoretical Coverage | 390-416 ft/gal @ 1 mil dry |
|  VHAP (lb.HAP/lb.solids) | 0.11-0.13lb VHAP/lb solid |
|  Photochemically Reactive  | No |
|  Coating Category |  White |

**Application Notes:**

**General:**

Always pre-test the system on your substrate to verify suitability of the application. First-Prime the wood with NAW1460 Luster Lac™ Professional White lacquer Undercoat for best results.

**Tinting:**

This product can be tinted with approved, high quality industrial colorants such as Opticolor XP. (Check with your Valspar Distributor for other approved colorants). **NEVER** tint with colorants that contain glycol. Maximum tint load is 4 oz per gallon (3% by volume).

Colorants must be mixed in completely with mechanical agitation before use. Apply by spray only, using Conventional Air, HVLP, Airless, or Air Assisted Airless equipment. Apply at a rate of 3-4 wet mils per coat. Sand between coats with 240-320 grit, no fill sandpaper. Remove sanding dust before applying the next coat. DO NOT APPLY more than two coats at 3-4 wet mils per coat when used in conjunction with the undercoat. Maximum film thickness of the total coating system MUST NOT EXCEED 4 dry mils.

Dry Time

Dry to touch: 15-20 minutes

Dry to sand: 30-40 minutes (depending on ambient conditions)

This product is best applied when surface and air temperatures are between 55°–90° F (12º–32ºC)

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 55º-90º 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.