

NUF450X

Amarium™ Conversion Lacquer

Date: February 14, 2018 (supersedes all previous revisions)



GENERAL INFORMATION

Axalta's Amarium Conversion Lacquer is a high performance, pre-catalyzed lacquer formulated for use on kitchen cabinets, furniture, or anywhere a tough, durable coating is needed. Amarium Conversion Lacquer is designed to be a self seal system, but may be used with an approved companion sealer if desired. For professional use only. For Wood Substrates Only.



1. PRODUCTS

- NUC4509 – Gloss
- NUF4502 – Satin
- NUF4506 – Semi Gloss
- NUF4501 – Matte
- NUF4504 – Soft Gloss



2. MIXING RATIO

- All products should be stirred well before use and, for best results, continuously agitated while in use.



3. SHELF LIFE @ 77°F (25°C)

- 9 months from the manufacturing date as packaged.



4. 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.



5. ADDITIVES

- None



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

- NUS4010
- NUS4020
- 383-1902-00
- 383-9905-00
- Graintone Plus™ color system



8. TECH NOTES

- Pre-catalyzed, no catalyst required



9. SUBSTRATES

- Commonly used furniture and cabinetry woods
- MDF/HDF

NOTE: Not to be used on exterior applications



10. APPLICATION

- See details under **Application Notes**



11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	10-15 Minutes
Flash between coats	30-40 Minutes
To Stack	16 Hours



12. FORCE DRY

Flash	8 – 10 Minutes
Bake	15 Minutes @ 125°F
Cool Down	10 Minutes ambient
Stack	After cool down



13. GUN SET UP

Gravity Feed	1.4 mm - 1.8 mm
Siphon Feed	1.4 mm - 1.8 mm
Airless	10 – 15 thousandths
Air-Assisted Airless	11 – 15 thousandths

AIR PRESSURES

Gravity Feed	30-35 psi (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	32-35 Zahn EZ #2
Weight Solids %	30.46-31.00%
Volume Solids %	22.3-23.3%
Actual VOC	4.96-5.01lbs/gal of Product
VOC Ratio (lb.voc/lb.solids)	2.08-2.14lb VOC/lb solid
Regulatory VOC (less water and exempt solvents)	626-630 g/l
Weight Per Gallon	7.63-7.67 lbs/gal
Flash Point	1°F Closed Cup
Theoretical Coverage	358-362 ft/gal @ 1 mil dry
VHAP (lb.HAP/lb.solids)	0.09 lb VHAP/lb solid
Photochemically Reactive	No
Coating Category	Clear



Application Notes:

General:

Always pre-test the system on your substrate to verify suitability of the application.

If staining, use an approved Axalta Industrial Wood Stain and let dry per the directions on the Technical Data Sheet for the stain you choose.

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 3-5 wet mils per coat. Sand between coats with 240-320 grit, no fill type sandpaper. Remove sanding dust before applying the next coat. This finish must be sanded between coats for proper adhesion.

DO NOT APPLY more than three coats at 3-5 wet mils per coat when used as a self seal system. Maximum film thickness of the total coating system MUST NOT EXCEED 4 dry mils.

DryingTime:

Dry to touch: 10-15 minutes

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

Do not apply if the material or substrate temperature is below 55°F.

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.

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 Coatings 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 60-100°F (16-38°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 60°F (16°C) or below the dew point. Abnormal conditions of temperature or humidity may adversely affect product performance.** Please contact your authorized Axalta Industrial Wood Coatings distributor for additional product use recommendations and finishing guidance.