

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



### GENERAL INFORMATION

Axalta's Amarium Production Pre-Catalyzed Lacquers are an excellent workhorse product formulated to offer good durability and value. They offer good mar, solvent, chemical and moisture resistance. When properly applied as a self-seal system or with the companion sealer, the film properties of this system provide a tough, durable finish that passes KCMA performance standards. This product is designed for professional application only. For Wood Substrates Only.



### 1. PRODUCTS

- NUF2852
- NUF2856



### 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



### 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. 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.

### 6. COMPANION PRODUCTS

- NUS2850 Amarium™ Production Pre-Catalyzed Lacquer Sealer-275 VOC
- Graintone Plus™ stain system



### 7. TECH NOTES

- No thinning is recommended.



### 8. SUBSTRATES

- Commonly used furniture and cabinetry woods
- MDF/HDF

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



### 10. APPLICATION

- Apply at a rate of 3-4 wet mils per coat. Sand between coats with 240-320 grit, no fill sandpaper. This finish must be sanded between coats for proper adhesion. Whether using this product as a self seal system or using in conjunction with the companion sealer, a total of three coats will be necessary to pass KCMA performance standards. DO NOT APPLY more than four coats at 3-4 wet mils per coat. Maximum film thickness of the total coating system MUST NOT EXCEED 4 dry mils.



### 11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	15-20 Minutes
Flash between coats	30 - 45 Minutes
To Stack	16 - 24 Hours

### 12. FORCE DRY



Flash	8 - 10 Minutes
Bake	15 Minutes @ 125°F
Cool Down	10 Minutes ambient
Stack	2 hours 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	16-19 sec EZ Zahn #2 @77°F
Weight Solids %	21.1-21.35%
Volume Solids %	14.46-14.53%
Actual VOC	0.48-0.49lbs/gal of
VOC Ratio (lb.voc/lb.solids)	0.32lb VOC/lb solid
Regulatory VOC (less water and exempt solvents)	273.5-274.56 g/l
Weight Per Gallon	7.19-7.21 lbs/gal
Flash Point	1°F Closed Cup
Theoretical Coverage	231-233 ft/gal @ 1 mil dry
VHAP (lb.HAP/lb.solids)	0.00lb VHAP/lb solid
Photochemically Reactive	No
Coating Category	Clear

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#### Application Notes:

##### General:

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

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. This finish must be sanded between coats for proper adhesion. Whether using this product as a self seal system or using in conjunction with the companion sealer, a total of three coats will be necessary to pass KCMA performance standards. DO NOT APPLY more than four 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: 15-20 minutes

Dry to sand and recoat: 30-45 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.