

WW71
WATER-BORNE UV-LACQUER SYSTEMS FOR DIFFERENT KIND OF INTERIOR WOOD SURFACES
**AKVI COLOR
LUMINOL CLEAR 25**
**378-S
005 3330**

The water-borne system WW71 is uv-lacquer system for wood furniture, panels, frames, kitchen cabinetS, doors etc. This system can be used as clear or with Akvi Color, Dicco Color or Dicco Lasyr stains.

Akvi Color is water-borne wood stain and tintable with Akvi Tone colorants. Dicco Color is solvent-borne wood stain which contains soluble light resistant dyestuff. Dicco Lasyr is semi-transparent wood stain and tintable with Tamaspeed Premium colorants.

Luminol Clear 25 is water-borne fast drying uv-lacquer for interior furniture applications. The lacquer has very good scratch and chemical resistance as well as good stacking properties. It is especially suitable for fast production lines.

LACQUER SYSTEM WITH STAIN

	Product	Application method	Application
1x staining	Akvi Color	Spraying,	60 - 80 g/m ²
1x priming	Luminol Clear 25	Spraying	70 - 100 g/m ²
1x top lacquering	Luminol Clear 25	Spraying	70 - 100 g/m ²

PRODUCT PROPERTIES

Solid Content 3 - 25 volume-% (378-s)
32 volume-% (005 3330)

Specific gravity 1.0 kg/l (378-s)
1.0 kg/l (005 3330)

Gloss (ISO 2813/60°) Semi-matt (005 3330)

Application methods Airless, air assisted airless and conventional spraying.

Drying times/50°C

	Dry to sand	Dry to stack
Akvi Color	3 - 10 min	3 - 10 min
Luminol Clear 25	Flash-off 1-2 min + 2-4 min conventional drying before UV-curing.	

Required UV-energy 600 mJ/cm² UVA-dose with Mercury –lamp.

Thinner Water.

Colours Clear. Akvi Color, Dicco Color or Dicco Lasyr stains can be used before lacquering.

SURFACE PREPARATION	Dirt, dust and other unfamiliar material must be removed from the surface. Wooden material should be sanded before application with sand paper 150 - 240 mesh. All sanding dust must be removed before application.
APPLICATION CONDITIONS	During application and drying the temperature of the air, paint and surface should be at least +18 °C. The relative humidity should not exceed 70 %. Good ventilation is needed during drying process.
APPLICATION	<p>Stir Akvi Color stain carefully before application. Apply an even coat on the dry and clean surface and let it dry.</p> <p>Stir Luminol Clear 25 carefully before application. Thin the lacquer with water if necessary. Apply an even coat and dry the lacquer about 3-5 min in conventional oven and then fiNal curing with uv-lamps.</p> <p>Sand the surface carefully with sand paper 320 or 400 mesh and remove sanding dust before the second application.</p> <p>Apply second coat same way as first coat. The lacquer is stackable immediately after uv-curing.</p> <p>Application with airless or conventional spraying system. Nozzle size is 0.009 - 0.013" and spraying distance from the object is about 20 - 25 cm.</p>
MAINTENANCE LACQUERING	<p>Wash down the surface with MAALIPESU detergent and rinse carefully with water. Remove old loose lacquer with scraper. Sand down surface and remove the sanding dust.</p> <p>Stir Kiva Interior lacquer, Merit Jahti or Unica Super well before use. Apply evenly 1 - 2 thin coats of lacquer. Sand lightly after the first coat and remove sanding dust before the second application.</p>

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The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. The quality of the product is ensured by our operational system, based on the requirements of ISO 9001 and ISO 14001. As manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

The product is intended for professional use only and shall only be used by professionals who have sufficient knowledge and expertise on the proper use of the product. The information above is advisory only. To the extent permitted by applicable law, we shall not approve of any liability for the conditions under which the product is being used or for the use or application of the product.

In case you intend to use the product for any other purpose than that recommended in this document without first getting our written confirmation on the suitability for the intended use, such use takes place at your own risk.