

SETAFLEX 540

CONVERSION VARNISH TOPCOAT



DESCRIPTION

SETAFLEX 540 is a high solid conversion varnish that leaves a durable scratch resistant, unique smooth to the touch finish. SETAFLEX 540 has excellent application and includes UV absorbers for enhanced UV resistance and color stability. Designed for use on interior wood surfaces like kitchen cabinets, vanities, chairs, tables, etc. Available in HAPS free version.



PRODUCT DATA

Color	Clear	VOC less exempts	630.16 g/L	5.26 lb/gal
Solids % by Vol	35% ± 2%	VOC regulatory	608.95 g/L	5.08 lb/gal
Solids %by Wt	43% ± 2%	Photochemical reactive	No	
Density	0.97	Flash Point (PM/CC)	N/A	
Viscosity 23°C/73°F #4 Ford	34-38	Shelf life	6 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	20,35,50,90/Available in other gloss level	Theo-coverage @1 mil dry	550-560 Sq.Ft/gal	11-12 m²/L

PREPARATION/APPLICATION

Working Temp	>18°C/65°F surface, coating and air
Catalyzation	10 % by volume using C A76 or C A73 Catalyst- 10 parts SETAFLEX 540 to 1part C A76 or C A73.
Pot life	8-12 hours (23°C/74°F)
Reducer	Reduce 15-30% by volume with DX 180 THINNER (Medium), DX 195 THINNER (slow). To help reduce trapped air, blushing or orange peel, use Retarder LR236 at a maximum of 5%.by volume
Film thickness	Min 4 mil wet –Max 5 mil wet
Suggested Sealer	MAXISIL 340, VS SEALER
Application	<ul style="list-style-type: none"> Color Wood-Stain or tone as desired and dry thoroughly Seal-Apply a full coat of recommended sealer at 4.0 – 5.0 wet mils. See sealer data sheet for details. Allow to dry. Sand with 240, 320 paper, or sponges as required. Topcoat within 8 hours of sanding Topcoat – apply SETAFLEX 540 at 4.0 - 5.0 mils wet For more depth or build, sand and apply an additional coat.
Surface Preparation	Wood surface must be clean, dry, and finish sanded with 180 grit sandpaper to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.
Use Directions	For interior use only. Catalyze, adjust viscosity and stir thoroughly before application to avoid variations application. Dry time can be directly impacted by many factors, including film thickness. Users are urged to test the system under shop conditions.
App equip.	Conventional & HVLP Siphon Feed, Pressure Pot Systems and Airless/Air Assist Equipment.
Tinting	Can be tinted up to 10% maximum with universal colorants 844.
Cleanup	Clean tools/equipment immediately after use with T 750 LORCHEM cleaner gun or a quality lacquer thinner or acetone. Always follow manufacturer's safety recommendations when using any solvent.
Standards	This product meets KCMA and CKCA standards when used over recommended LORCHEM sealers.

DRYING TIMES

Method	Drying temperature.	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	Dust free time	4-6 minutes	Dry to sand	1-2 hours
		Dry to touch	20-30 minutes	Dry to recoat	1-2 hours
		Dry to Handle	1-2 hours	Dry to stack	24 hours
Force dry	45to 60°C/110-140°F	Minutes			

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Minimum curing temperatures of 23°C/74°F must be maintained throughout curing cycle to achieve the film integrity as stated in product features.

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APPLICATION RECOMMENDATIONS

APPLICATION EQUIPMENT SETTINGS

Method of Application	Air Pressure (PSI)	Fluid Pressure (PSI)	TIP size (mm / inch)	Application Viscosity (#FORD 4)	Thickness Film (Mils)
Conventional spray	40-50	08-12	1.8-2/0,070-0,078	18-21	3-5
Airless Spray	10-18	300-600	0,28-0,33/0,011-0,012	18-21	3-5
HVPL	35-45	8-12	1.19-1,39/0,047-0,055	18-21	3-5

Note: All measurements and application equipment settings are based on application at a temperature of 23°C/74°F. Viscosity will vary depending on the temperature of the liquid. The above-mentioned application equipment recommendations are guidelines only. The noted settings are starting point recommendations and that adjustment to the settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

SPECIFICATIONS

- For interior use only.
- Must be stirred before and during using.
- Must be catalyzed with C A76 or C A73 catalyst at a level of 10% by volume. Over catalyzing or using incorrect catalyst may result in blooming, cracking and poor adhesion.
- C A73 and C A76 are acids. To prevent acid corrosion and pitting, do not catalyzed in an unlined metal container and all equipment should made of stainless steel.
- Store at room temperature (under 25°C/ 80° F) after catalyzation. Higher temperatures will reduce the storage life.
- Can be used over recommended LORCHEM sealer. Please contact your LORCHEM representative for system recommendations.
- Total film thickness of systems must not exceed 7.0 mils dry film because heavier films may show cracking tendency.

CAUTIONS

TESTING

Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

THESE PRODUCT ARE DESIGNED FOR INDUSTRIAL SHOP APPLICATION AND PROFESSIONAL USE ONLY

Thoroughly review Safety Data Sheet (SDS) for safety information and cautions prior to using this product. Please direct any questions or comments to your local representative.

PDS

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling ,preparation and application which are not known or under our control, LORCHEM cannot make any warranties related to the product or the performance of the product. Moreover, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is not caused by the quality of the product.

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