Envirolak

Technical Data Sheet
ELACW400 XX
Revision Date: 7/28/23

AVAILABLE SHEENS:	ELACW400 10	10 Gloss - Flat
	ELACW400 20	20 Gloss - Low Gloss
	ELACW400 30	30 Gloss - Satin

NAME: **ENVIROCRYL 400 WHITE TOPCOAT**

DESCRIPTION: Envirocryl 400 series is a white one-component acrylic water based finish. The coating is easy to work with, fast drying and offers good feel and early block resistance in an economical package.

USES: This product is designed for interior wood finishing applications such as cabinetry, furniture and millwork.

PRODUCT PREPARATION: Reduction is generally not required. Product should be at room temperature and mixed thoroughly prior to finishing to ensure consistency and gloss. This product can be used as a 2K with the addition of 5% CAT100-LV or 3%CAT150.

SANDING: Substrate should be sanded with 180 grit sandpaper prior to finishing. Sand primer with 320 grit or Superfine Sponges.

RECOMMENDED APPLICATION:

Spray type:		**Air Assisted Airless**
Fluid Pressure:		400-600 PSI
Air Pressure:		20-25 PSI (triggered)
Tips:	Kremlin	04114, 06114, 09114, 09154
	Wagner	0950, 1150, 1350, 1360, 1380
	Graco/CA and others	411, 413, 511, 513, 611, 613
Spray type:		**Airless**
Fluid Pressure:		2000-2200 PSI
Tips:	Fine Finish or Ultra Finish	308, 408, 508
Reduction:		Not required, water or RX010
Spray type:		**Cup Gun (gravity)**
Air Pressure:		20-25 PSI
Tips:		1.5 - 1.8
Reduction:		Not required, water or RX010
Wet Film Build:		5-7 mils
Grams per 1/10 sq. metre: (250x400mm board)		15-21 grams (3g/wet mil)
Number of Coats:		1 - 2
Maximum Dry Film Build:		6 mils
Coating Temperature at Application:		18°C (65°F) or higher

Manufactured in Canada by Performance Finishing Solutions
4800 Eastgate Parkway, Units 3&4, Mississauga, Ontario, L4W 3W6
Tel: (905) 629-7007 **Fax: (905) 629-7865**
www.envirolak.com

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PHYSICAL PROPERTIES:	Specific Gravity:	1.17 ± 2%
	Viscosity:	3500 cps @20°C
	Solids Content:	38.5% by weight
	Flash Point:	>75°C
	VOC's (Less Exempt):	170 g/L, 1.42 lb/gal

DRYING TIMES:

Air dry: (20°C/68°F)	Dry to Touch	20-25 minutes
	Dry to Sand	1 hour
	Dry to Recoat	1-2 hours
	Dry to Stack	2 hours
	Note: Gentle air movement (recirculator or fan) while parts are drying will reduce dry to sand times by 20-40%	
Conventional Oven: (40-45°C/104-113°F)	Dry to Touch	10-15 Minutes
	Dry to Sand	30 Minutes
	Dry to Recoat	30-60 minutes
	Dry to Stack	1 hour
Sun-Spot IR Cure: (Recommended)	Flash off	2 Minutes
	Direct Cure	4-5 Minutes @60-70°C (140-160F)
	Rack Cure	10 minutes @10%+ power
	Cool Down	10-20 Minutes
	Product is dry to stack (or sand) after cooling	

TYPICAL SYSTEMS:

Substrate: MDF
ELPR170 Envirothane 170 White Primer High Solids, 2 coats no sanding
Sand level using 320 grit sandpaper
ELACW40020 Envirocryl White Topcoat 20 Sheen

Substrate: Natural woods and veneers
ELPR160 Envirocryl 160 White Primer
Sand 320 grit sandpaper
ELPR160 Envirocryl 160 White Primer
Sand 320 grit sandpaper
ELACW40020 Envirocryl White Topcoat 20 Sheen

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GENERAL INFORMATION:

Use stainless steel or plastic equipment for all water based products. When switching between solvent and water based products in the same spray equipment we suggest the following:

From Solvent to Water: Wash with acetone, then wash with water.
From Water to Solvent: Wash with water, then wash with acetone.

Keep containers closed when not in use and wash all equipment well. Keep from freezing.
These products are designed for industrial use only. Please refer to the Safety Data Sheet prior to use.

SHELF LIFE: 12 months in unopened containers

STORAGE: Store in a tightly closed container at room temperature (18-25°C/64-75°F) and protect