

MAXISIL 340

CONVERSION VARNISH SEALER

DESCRIPTION

MAXISIL 340 is a two-component conversion varnish sealer for interior woodwork. This fast-drying sealer has excellent sandability, good build and excellent hang on vertical surfaces. It is an excellent sealer for recommended LORCHEM postcatalysed topcoats. Typical applications include kitchen cabinets, vanities, chairs, office as well as other interior wood applications. Available in HAPS free version.



PRODUCT DATA

Color	Clear	VOC less exempts	646.06g/L	5.39 lb/gal
Solids % by Vol	31% ± 2%	VOC actual	607.48 g/L	5.07 lb/gal
Solids %by Wt	39% ± 2%	Photochemical reactive	No	
Density	0.94	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°)	Flat	Theo-coverage @1 mil dry	490-500 Sq.Ft/gal	11-12 m ² /L

PREPARATION/APPLICATION

Working Temp	>18°C/65°F surface, coating and air
Catalyzation	10 % by volume using C A72 Catalys t- 10 parts MAXISIL 340 to 1 part C A72. catalyst
Pot life	8-12 hours (23°C/74°F)
Reducer	Product is normally applied without reduction. If reduction is needed to adjust drying or build, reduce 15-20% 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 Topcoat	SETAFLEX 540, DIAMOS 420, VIDAPLUS 330
Application	<ul style="list-style-type: none"> ◆ Color Wood-Stain or tone as desired and dry thoroughly. ◆ Seal- Apply a full coat of MAXISIL 344 at 4.0 – 5.0 wet mils. ◆ Air dry 20-30 minutes, sand with 240, 320 paper, or sponges as required. Topcoat within 8 hours of sanding. ◆ Topcoat – apply recommended topcoat at 4.0 - 5.0 mils wet. ◆ For more depth or build, sand and apply an additional coat. ◆ Do not exceed 7.0 mils DFT for the total system.
Surface Preparation	Wood surface must be clean, dry, free of grease and oil 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 T750 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 test requirements when used under recommended LORCHEM Topcoat.

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 hour
		Dry to touch	20-30 minutes	Dry to recoat	1 hour
		Dry to Handle	1 hour	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 A72 catalyst at a level of 10% by volume. Over catalyzing or using incorrect catalyst may result in blooming, cracking and poor adhesion.
- C A72 is an acid. To prevent acid corrosion and pitting, do not catalyzed in an unlined metal container and all equipment should be made of stainless steel.
- This product should be thoroughly sanded within 4 hours of being applied. If the sealer is not topcoated the same day, it should be resanded immediately before topcoating to insure optimum intercoat adhesion.
- Do not apply more than one coat of sealer for build. Multiple coats of topcoat are recommended rather than multiple coats of sealer.
- Store at room temperature (under 25°C/ 80° F) after catalyzation. Higher temperatures will reduce the storage life.
- Can be used under recommended LORCHEM Topcoat. 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 tendencies.

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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