

<b>AVAILABLE SHEENS:</b>	ELACW400 10 ELACW400 20 ELACW400 30	10 Gloss - Flat 20 Gloss - Low Gloss 30 Gloss - Satin
<b>NAME:</b>	<b>ENVIROCRYL 400 WHITE TOPCOAT</b>	
<b>DESCRIPTION:</b>	Envirocyl 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.	
<b>USES:</b>	This product is designed for interior wood finishing applications such as cabinetry, furniture and millwork.	
<b>PRODUCT PREPARATION:</b>	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.	
<b>SANDING:</b>	Substrate should be sanded with 180 grit sandpaper prior to finishing. Sand primer with 320 grit or Superfine Sponges.	
<b>RECOMMENDED APPLICATION:</b>	Spray type: Fluid Pressure: Air Pressure: Tips: Kremlin Wagner Graco/CA and others	<b>Air Assisted Airless</b> 400-600 PSI 20-25 PSI (triggered) 04114, 06114, 09114, 09154 0950, 1150, 1350, 1360, 1380 411, 413, 511, 513, 611, 613
	Spray type: Fluid Pressure: Tips: Fine Finish or Ultra Finish Reduction:	<b>Airless</b> 2000-2200 PSI 308, 408, 508 Not required, water or RX010
	Spray type: Air Pressure: Tips: Reduction:	<b>Cup Gun (gravity)</b> 20-25 PSI 1.5 - 1.8 Not required, water or RX010
	Wet Film Build: Grams per 1/10 sq. metre: (250x400mm board) Number of Coats: Maximum Dry Film Build: Coating Temperature at Application:	5-7 mils 15-21 grams (3g/wet mil) 1 - 2 6 mils 18°C (65°F) or higher

**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:  
(25°C/77°F)**

Dry to Touch	20-25 minutes
Dry to Sand	1 hour
Dry to Recoat	1-2 hours
Dry to Stack	2 hours

Note: These dry times are with gentle air movement (recirculator or fan) while parts are drying.

**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 Envirocyl White Topcoat 20 Sheen

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

**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

Disclaimer: Every reasonable precaution is taken in the manufacture of our products to ensure that they comply with our standards. The information given herein is correct to the best of our knowledge. Any suggestions made by us covering the use of our products are based on experience and/or tests believed to be reliable. However, because the use of any product of our manufacture is completely beyond our control, including for example, the method and conditions of application, no guarantee or warranty, expressed or implied, is made. Manufacturer's maximum liability shall be to replace such quantity of product determined by our laboratory to be defective. User shall determine the suitability of the product for his intended use and assumes all risk and liability in connection therewith.