



AXON PRODUCTS

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WOOD TECHNICAL DATA

AST-928 **CLEAR SEMI-GLOSS ACRYLATE TOPCOAT - UV CURABLE**

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This clear, sprayable, acrylate topcoat provides maximum durability and depth. It also has excellent mar and scratch resistance properties. It should be used when the part will not be buffed and polished. **AST-928** can be applied to achieve an open-grain "furniture" look or in multiple coats for a closed grain "full-fill" look.

GENERAL RULES:

1. This product should be stored no longer than 6 months from date of manufacture. It should be kept in its original container in a dark, cool, dry place away from a source of heat and at a temperature below 86°F.
2. For best performance the temperature of the product and the room should be 69 - 79°F and the relative humidity 35 - 75%.
3. The substrate needs to be well sanded with 180 - 220 grit paper, and must be free from dust and grease. The moisture content of the substrate should vary from 8 - 12%.
4. An **ISC/ISB Series** insulator should be applied before coating with **AST-928** on woods such as Teak, Rosewood, and other exotic woods with a high content of tannin, or parts that are stained.
5. If higher fill is required, a UV Sealer may be sprayed, cured and sanded with 220 - 320 grit, cleaned and blown off with clean high-pressure air. (Also, multiple coats of **AST-928** may be applied when sanded between coats.)

UV CURING:

AST-928 Clear Semi-Gloss Acrylate Topcoat -UV Curable makes it possible to cure with high or low pressure to maintain consistent gloss. High-powered cure is recommended at 1600-1800 mj2.

Please consult your Axon Products Technical Representative when considering UV curing.

SPRAYING:

Most spray equipment can be used. It is important that the topcoat be applied as "wet" as possible without sagging (approximately 3 - 4 mils gives best results). Keep air pressure low, i.e. 30 - 45 psi at the gun. Avoid dry spraying. Unlike lacquers, acrylate does not have enough solvent to completely re-wet dry spray.

Graco 700N	Conventional spray gun 1.8 mm #2N tip and needle, #21 air cap
DeVilbis JGHV530	HVLP spray gun (pressure feed) FX tip and needle, #705 air cap

The **AST-928** Clear Semi-Gloss Acrylate Topcoat works very well on various types of automated spray equipment