

# AMERISTAR 66 CLEAR

DM53660XX (10, 20, 40, 60 Gloss)

## DESCRIPTION

Ameristar 66 Clear is a post-catalyzed acid cured clear coating with high build properties. This product is fast drying with short curing times and can be stacked quickly. Ameristar 66 Clear delivers a soft feel and is easy to sand. It is non-yellowing and suitable for self sealing over all shades of stains, even pastels and whites. Ameristar 66 Clear is HAPs compliant and low in formaldehyde. This product has good sag resistance and is designed for vertical or flat spray applications. Ameristar 66 Clear offers outstanding flow and levelling, great scratch resistance, and excellent chemical strength.

## PRODUCT DATA:

<b>Colour:</b>	Clear	<b>VOC (as packaged, maximum, less water and exempt solvents):</b>	530 g/l or 4.43 lbs/gal
<b>Solids % by Vol.:</b>	36 % (Theoretical)	<b>VOC (emitted):</b>	530 g/l or 4.43 lbs/gal
<b>Solids % by Wt.:</b>	46 % (Theoretical)	<b>Lbs. VHAPs / Lbs. Solids:</b>	0.04 as supplied
<b>Weight / Gal.:</b>	8.15 lb/gal	<b>Flash Point (PMCC):</b>	13 ° C / 55 ° F
<b>Viscosity 23°C / 73°F:</b>	<b>DIN 4:</b> 18-21 sec.	<b>Photo Chemically Reactive:</b>	No
		<b>Shelf Life:</b>	1 year (at 15-25° C / 59°-77° F)
		<b>Theo. Coverage@1mil dry</b>	579 Sq. Ft./Gal. 100% Efficiency

## MIXING / APPLICATION:

**Working Temp:** >18° C, 65° F substrate, coating and air  
**Hardener:** 2750 Regular Solvent; 494 Slow Solvent; 309 HAPs Free Solvent, 944 Slow HAPs Free.  
**Catalyzation:** 12 % Parts by volume  
**Pot Life:** 24 hrs. (23° C / 73° F)  
**Mixing:** Mix thoroughly to ensure uniform consistency. Add catalyst under agitation then add solvent to adjust viscosity if necessary.  
**Sealer:** Can be used as self sealed system or over Care Seal FF5310 or Care Seal II HS FF5321  
**Reducer:** Thinner 219 - Regular; Thinner OC 140 - Fast; Thinner 309 - Haps Free, Thinner 419 – Slow, Haps Free  
**Application:** 75-100 (g/m<sup>2</sup>) Approx. 3-4 wet mils  
**Surface Prep:** Substrate should be clean and free of grease and oil. Moisture content of the wood should be between 6%-8%. Sand 150 grit on open grain and 180 grit on closed grain wood. Sand the first coat ( with 280-320 paper) in order to eliminate grain raising, if any, and improve adhesion of the subsequent coat. Topcoat within 8 hours of sanding  
**Use Directions:** For interior use only. Mix thoroughly before application. Stack only when the surface temperature is below 35°C / 95 ° F. Quicker stacking times are achievable relative to the amount of product that is applied.  
**App. Equip.:** Conventional & HVLP Siphon Feed and Pressure Pot Systems and Airless Air Assist Equipment.  
**Ind. Standards:** This product meets the quality standard Conversion Varnish Transparent for AWI. It also meets KCMA and CKCA standards.

## DRYING TIMES TO SAND / STACK / RECOAT WINDOW:

Method	Drying Temp.	Drying Time (@ 60 % RH and thickness @ 1 mil dry)
<b>Air Drying</b>	20° C / 68° F	3-4 hours to sand / 2 - 3 hr. to stack
<b>Forced Drying</b>	70° C / 158° F	20-30 minutes to sand / 1-2 hours to stack

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## APPLICATION RECOMMENDATIONS:

### APPLICATION EQUIPMENT SETTINGS

Method of Application	Wet Film		Dry Film	
	Mils	g/m <sup>2</sup>	Mils	Microns
Conventional – Siphon Fed	3 – 4 mils	75-100 g/m <sup>2</sup>	1.08-1.44 mils	27-36 microns
Conventional – Pressure Pot	3 – 4 mils	75-100 g/m <sup>2</sup>	1.08-1.44 mils	27-36 microns
Airless Air Assist	3 – 4 mils	75-100 g/m <sup>2</sup>	1.08-1.44 mils	27-36 microns
HVLP - Siphon Fed	3 – 4 mils	75-100 g/m <sup>2</sup>	1.08-1.44 mils	27-36 microns
HVLP - Pressure Pot	3 – 4 mils	75-100 g/m <sup>2</sup>	1.08-1.44 mils	27-36 microns

All measurements and application equipment settings are based on application at a temperature of 68°F. Viscosity will vary depending on the temperature of the liquid. The application equipment setting recommendations are guidelines only. The settings are starting point recommendations and adjustments to the equipment settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

### REDUCTION – TIP SIZE – PSI SETTINGS

#### Conventional Equipment Siphon Feed:

Reduce to 18-21 sec. #4 Ford viscosity cup (20-22 sec Sig. Zahn 2 cup), nozzle size 0.070 inches (1.8 mm) to 0.080 inches (2.0 mm), atomizing air 40 psi (2.8 bar) to 50 psi (3.5 bar).

#### Conventional Equipment Pressure Pot:

Reduce to 18-21 sec. #4 Ford viscosity cup (20-22 sec Sig. Zahn 2 cup), nozzle size 0.070 inches (1.8 mm) to 0.080 inches (2.0 mm), atomizing air 40 psi (2.8 bar) to 50 psi (3.5 bar), Pot pressure 7 psi (0.48 bar) to 10 psi (0.68 bar)

#### Airless Air Assist Equipment:

Reduce to 18-21 sec. #4 Ford viscosity cup (20-22 sec Sig. Zahn 2 cup), tip size 0.013 inches (0.33 mm) to 0.016 inches (0.41 mm), fluid pressure 290 psi (20 bar) to 580 psi (40 bar), atomizing air 11 psi (0.8 bar) to 17 psi (1.2 bar).

#### HVLP Equipment Siphon Feed:

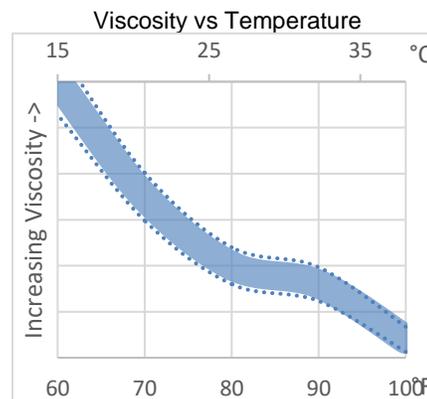
Reduce to 17-21 sec. #4 Ford viscosity cup (19-22 sec Sig. Zahn 2 cup), nozzle size 0.070 inches (1.8 mm) to 0.080 inches (2.0 mm), atomizing air 35 psi (2.4 bar) to 45 psi (3.1 bar).

#### HVLP Equipment Pressure Pot:

Reduce to 17-21 sec. #4 Ford viscosity cup (19-22 sec Sig. Zahn 2 cup), nozzle size 0.070 inches (1.8 mm) to 0.080 inches (2.0 mm), atomizing air 20 psi (1.37 bar) to 25 psi (1.72 bar). Pot pressure 7 psi (0.48 bar) to 10 psi (0.68 bar)

### PRODUCT NOTES

- Maximum recommended dry film thickness for total coating system is 6 dry mils. Heavier film build may cause cracking.
- Temperatures must be above 68°F during application and cure to ensure acceptable coating properties..



The above chart is for information only and should not be used as product specifications.

### CONTACTS:

PH: AcromaPro USA and Canada / 1-888-277-1448

[www.AcromaPro.com](http://www.AcromaPro.com)



**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.

**FOR INDUSTRIAL SHOP APPLICATION:** Thoroughly review Material Safety Data Sheet (MSDS) for safety information and cautions prior to using this product. For Regulatory compliance data (i.e. VOC, HAPS, etc.), obtain an Environmental Data Sheet (EDS) prior to using the product. A MSDS and/or EDS is available from your local distributor or representative. Please direct any questions or comments to 1-800-524-5979.

**NOTE:** 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 and methods of application which are not known or under our control, AcromaPro cannot make any warranties as to the end result.