



**DESCRIPTION**

**TOA INDUSTRIAL LACQUER** is produced from high quality Nitrocellulose and special pigment. It offers quick drying, high hardness and good color retention paint film.

**TYPICAL USE**

**TOA INDUSTRIAL LACQUER** is recommended for interior use, to decorate and protect wood, metal surfaces.

**PRODUCT DATA**

- **Components** : Binders, pigments, additives and solvents
- **Color** : Refer to catalogue
- **Paint film appearance:** Gloss (except #999; #911 matt)
- **Solid by volume** : 38 ± 2 %
- **Theoretical coverage** : 9.5 – 12.7 m<sup>2</sup>/liter/coat  
*Actual surface coverage will be depended on spreading ability of paint film, dry film thickness, surface irregularities, technique and wastage during painting.*
- **Volatile organic compounds (VOCs)** : ≤ 650 g/L
- **Flash point** : appx.20°C
- **Drying time (at relative humidity (RH) 50% & dry film thickness (DFT) 30µm - 40µm):**

○ <b>Surface temperature</b>	25°C	30°C	35°C
○ <b>Surface dry (touch dry)</b>	10 min	6 min	4 min
○ <b>Hard dry</b>	1.5h	1h	45 min
○ <b>Painting interval, minimum</b>	15 min	10 min	8 min

*Actual drying time and painting interval time may be longer or shorter than provided data, depended on environmental temperature, dry film thickness, ventilation, humidity and number of coating applied, etc.*

**RECOMMENDED PAINT FILM SYSTEM:**

SYSTEM	PRODUCT	COAT(S)	DRY FILM THICKNESS
<i>For metal surfaces:</i>			
Primer	TOA Industrial Lacquer Grey primer	1 - 2	40µm
Topcoat	TOA Industrial Lacquer	2	35µm
<i>For wood surface:</i>			
Primer	Appropriate primer for wood surface	1 - 2	-
Topcoat	TOA Industrial Lacquer	2	35µm

# Technical data sheet

## APPLICATION INSTRUCTION

### ▪ SURFACE PREPARATION

- **For metal surface:** make sure the surface is dry and clean, free from grease, oil, waxy contamination, rust or mill scale.
- **For wood surface:** sand out wood surface smoothly then fill all damage and gap by appropriate filler. Sand again and clean until no dust remained.

#### **For industrial purpose:**

- Oil and grease must be cleaned in accordance with SSPC-SP1, Solvent Cleaning.
- Surface should be blast cleaned, at least achieved Sa 2.0 – Sa 2.5 (ISO 8501-1:2007).
- With area cannot be blast cleaned, use power tools to clean the surface at least achieved St2 – St3 (ISO 8501-1:2007).

### ▪ APPLICATION

#### **Equipment / methods:**

Brush, conventional spray, airless spray

For airless spray gun:

- Nozzle tip size : 0.013” – 0.021”
- Angle to the surface : 65° – 80°
- Pressure at nozzle : 140 – 190 Kg/cm<sup>2</sup> (2.000 – 2.600 Psi)

#### **Paint film thickness:**

	Min	Standard	Max
- <b>Dry film thickness (DFT):</b>	30µm	35µm	40µm
- <b>Wet film thickness (WFT):</b>	79µm	92µm	105µm

*Film thickness will vary and is calculated as average.*

#### **Dilution ratio:**

**TOA lacquer thinner #71 or specialized thinner for lacquer paint are recommended.**

**Dilute paint : thinner = 1 : 1-2 by volume**

*Dilution percentage is depending on ambient temperature, relative humidity, paint film thickness, equipment and application method.*

## CERTIFICATION:

*JIS K 5531:2003\* – Japanese Industrial Standard for Nitrocellulose lacquer certified.*

*QCVN 08:2020/BCT – National technical regulation on the limits of lead content in paints certified.*



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## HANDLING AND STORAGE

The product must be stored in accordance with national regulations.  
Store in a dry, cool, good ventilation area; far from heat, open flame, flammable materials.  
Tightly closed when not in use.  
Keep out of reach of children.  
Stir well before use, paint should be used up when lid opened.  
Storage temperature is recommended at 25°C – 30°C.  
Do not apply when temperature is lower than 15°C or higher than 40°C.  
Do not apply when relative humidity exceeds 75%.  
Surface temperature should be at least 3°C higher than the dew point of the air.

## HEALTH AND SAFETY

Please do not handle until all safety precautions have been read and understood.  
Keep away from heat, sparks, open flame, hot surface. No smoking.  
Wear protective gloves, respirator, eye protection, protective clothing.  
Avoid contact with skin, eyes or ingestion. Go right to the nearest health center for help in case of ingesting paint or paint contacts with eyes.  
Avoid release to the environment. Treat discarded paint according to environmental law.  
See more guidelines in the Safety Data Sheet.

## PACKAGING

17.5 liter and 0.875 liter

## SHELF LIFE

48 months from manufacturing day when stored at 25°C – 30°C

## DISCLAIMER

The information in this data sheet is given to the best of TOA's knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, TOA cannot guarantee anything only the quality of the product itself. TOA reserves the right to change given data without notice.

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