

***Spraying Safecoat EcoLacq***  
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This a guide to assist professionals that are wanting to begin working with AFM Safecoat Ecolacq. One of the first things you need to do is put out of your mind that you are spraying lacquer or varnish. It is a completely different product and you will have a learning curve. Don't be afraid to buy up to a gallon to play with. I have learned more by trying to make it fail than anything else.

I use Titan sprayers for my work.

One thing I have learned is you have to set yourself up with separate equipment when spraying Ecolacq or Acrylacq.

**YOU CANNOT CONTAMINATE THE EQUIPMENT.**

I have one air assist sprayer and one maxim elite gun set aside for only Safecoat Ecolacq, Acrylacq and Polyureseal BP. I primarily have the maxim gun set up with gravity feed not siphon. It is an expensive investment but will pay for itself quickly in cleaning of equipment and quality of finish. From trial and error and trying to make it fail the biggest thing I learned is with the equipment. If I spray a non Safecoat product, clean equipment and then spray Ecolacq I get dimpling in finish. I have broken equipment down and cleaned for hours and still get dimpling. When I dedicated equipment solely for Safecoat products I have not had any failure in the finish. It is stunning.

I use the Titan multi finish 440 air assisted sprayer and the Titan maxim elite gun with the Capsray 115 HVLP. This unit is a 6 stage turbine and I use a 30' hose so air temp is completely reduced to room temp before hitting the product.

I have tried a standard 440i Impact airless with pour results.

When using either piece of equipment I DONOT reduce product at all.

The scope of work for a normal project are as follows:

- Complete sanding and prep. When sanding only use aluminum oxide paper
- Never use a tack rag to wipe down item. It will leave residue and will cause dimpling
- Vacuum and lightly wash
- Wipe down entire surface with denatured alcohol let dry
- Spray one coat transitional primer with airless let cure at least 8hrs. I do this to reduce color transfer if wood has any dark lining in it and to reduce grain rise
- Sand primer, vacuum, lightly wash and wipe down with denatured alcohol
- If using air assist I set air pressure at approx.. 18lbs and fluid pressure at 38-40lbs
- I use only a cat water based .015 tip. If you use standard .015 finish tip you will get air bubbles in your finish starting with second coat
- If using HVLP I use a number 3 tip with gravity feed setup
- I will also run it with turbine set for 6 stage. It allows much more control of air and product flow
- Slowly mix product. I gently roll container in my hands slowly for 3-5 minutes
- Have test board to adjust product flow to achieve desired fan with minimal atomization
- If too much atomization, product will start to dry before it hits surface which will cause uneven drying and discoloration or a blotchy look
- I spray/ hold gun approx.. 10"-12" from item. That is a distance I like.
- First pass is a fine spit coat then spray entire surface with a 50% overlap.
- When spraying, coats are much thinner than spraying traditional lacquers
- Spray items if possible in a horizontal position till you are used to the product. Each coat must be thinner than you think.
- When spraying in vertical position each coat must be thinner/lighter than you think as it will sag very easily
- Do 3 to 4 coats to achieve desired depth and finish that you would normally achieve with 2 coats of lacquer
- You must let product completely dry. I wait 6-8hrs between coats. You can't rush this product so projects will take longer to complete
- When sanding between coats use only aluminum oxide paper
- Wipe down with damp rag, let dry and then wipe down with denatured alcohol
- I normally only have to sand between 1st and 2nd coats
- When using HVLP pour Ecolacq through a filter when filling gravity feed cone to remove any larger particles so gun does not clog
- When using HVLP, I completely clean gun between coats. Warm water and safe choice cleaner.
- When using air assist I will leave machine charged with product. I roll hose up and lay it on floor not vertical on rig. Leaving it vertical on rig the solids will separate and fall to the bottom of each loop of hose. I also pull tip and set it in a small container of denatured alcohol till I spray the next coat. I also pull tip even if I stop for 15-20 minutes.

**NOTE: We recommend that you dedicate a 4x8 panel of veneer ply spraying the entire panel horizontally on one side and vertically on the other. This should help to establish your finishing protocols and get you comfortable with the process.**