



6 Margate Street, Botany NSW 2019
 P: (02) 9316 8034 F: (02) 9316 5474
 E: sales@pylon.com.au
 W: www.pylon.com.au

ACE-CAT

**Acid-Catalysed
 CLEAR
 SEMI-GLOSS, SATIN & FLAT**

DATA SHEET
 DS Ref: ACC101114



Manufactured under a certified quality assured system

Product Description

A low formaldehyde premium quality acid-catalysed coating for use on interior timber, veneer and MDF substrates. Ace-Cat has high solids, smooth 'off the gun' finish and is an easy to use system. Ace-Cat Clear can be used as a self-sealing coating or in conjunction with Pylon's Ace-Cat Sealer.

Principal Uses

- * Commercial & domestic furniture
- * Shop fitting & joinery
- * Built-in wardrobes
- * Kitchen doors
- * Internal doors

Features & Benefits

- * Low VOC & MIR
- * Low formaldehyde formula
- * Free of hydrocarbon solvents
- * High solids
- * High heat, alcohol & water resistance
- * Good resistance to abrasion
- * Excellent flow & self-levelling
- * Smooth 'off the gun' finish
- * UV Additive available



Solid Content

43%



Theoretical Coverage

5 - 6m² @ 150 WFT (wet film thickness)



Packaging

Part A	4Lt	20Lt
Part B	1Lt	25Lt



Mixing Instructions

Use a flat blade stirrer & mix **Part A** before and after adding **Part B** hardener.

Mix by volume:- 20 Parts A to 1 Part B
 Stir thoroughly and leave to stand for 10 minutes.

* Add appropriate thinner and re stir.

Ace-Cat Hardener

50mls per 1Lt of Part A



Thinning

* Add between 10 – 40% refer to page 2 'Application System Guide'.

Fast	Thinners C
Medium	Thinners A
Slow	Ace-Cat Thinners



Drying Times

Dust Free	20-30 mins
Touch Dry	40 - 60 mins
Sanding / Recoat	2 - 4 hrs
Full Cure	7 days

Tested at 25° C & 60% relative humidity @ 150 micron WFT



Pot life

24 – 36 hours

This data sheet and the relevant MSDS must be read and understood prior to application.



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Application System Guide
(based at 25° C and 60% humidity)

	% Thinners	Tip Size	Air Pressure		
			Gun	Pressure Pot	Pump
Suction Pot	25 - 40%	1.8 – 2.0mm	40 - 55psi	N/A	N/A
Gravity Pot	20 - 30%	1.8 – 2.0mm	40 - 55psi	N/A	N/A
Pressure Pot	20 - 30%	1.8 – 2.0mm	40 - 55psi	6-10psi	N/A
Air Assisted Airless	5 - 15%	11 – 13 thou	N / A	N / A	1000 -1500psi
Straight Airless	5 - 10%	11 – 13 thou	N / A	N / A	1000 -1500psi

- Refer to Pylon technical team for your specific requirements

Equipment Cleaning
MEK or Thinners C

Surface Preparation

- 1) All surfaces must be clean, dry and free from dust, grease, dirt and all other contaminants before proceeding and throughout the entire coating process.
- 2) For raw substrates fill small defects, cracks and holes with a suitable putty; allow sufficient time to dry as per manufacturers specifications.
- 3) **Sanding**
 - a. **Sealed Surfaces:** Sand with the grain using 280 – 400 grit free-cut sandpaper.
 - b. **Raw Timber & Veneers:** Sand with the grain using 180 - 240 grit free-cut sandpaper.
 - c. **Raw MDF:** Sand with 150 then 220 grit free-cut sandpaper.

Application Guidance

- Due to numerous species of timbers and veneers in today’s market, we advise that you contact Pylon’s technical team for your specific requirements.

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Problem Solving

- **Orange peel**; reduce the air pressure and/or adjust thinning ratio.
- **Solvent boil**; apply lighter coats, allow a longer flash off time or use a slower thinner.

Refer to Pylon technical team for your specific requirements

Storage Instructions

Store in an approved dangerous goods cabinet or bunker in dry condition below 30° C.

Shelf life; Part A & B - 12 months unopened.

Opened products; Part A & B - 6 months.

Warnings

Pylon Coatings advises that:

- you review, understand and follow this data sheet and the MSDS before use;
- it will only support a coating system that is exclusively Pylon products;
- the total dry film thickness should not exceed 200 microns;
- Ace-Cat Clear should be tested on the selected substrate before proceeding;
- Ace-Cat Clear is not recommended for any surface that will be submerged in water;
- Ace-Cat Clear is for selected internal surfaces;
- Ace-Cat Clear should only be applied when temperatures are above 10° C & below 35° C;
- Ace-Cat Clear may not cure properly whilst temperatures are below 10° C;
- Ace-Cat Clear is a specialised industrial coating and should only be applied by experienced and competent tradespeople.

Condition of Use

All Pylon Coatings products are manufactured from high-grade raw materials to ISO 2008 quality assured system. We have no control over the conditions under which these products are stored, transported, handled or used, so customers are advised to test the product before adapting them to their own use. The information contained in this data sheet is based on data appraised in our own laboratory and from comprehensive market research. Pylon Coatings can only control the quality and formulation of our own products, and therefore have no responsibility over the quality or consistency of other company's products or substrates that the products are being applied on. Due to the possible variations between our controlled laboratory test conditions and techniques, differences in application and the range of substrates in today's market, Pylon Coatings supplies its

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products only on the condition that the consumer is satisfied with the performance of the product in meeting their requirements.

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