

LENMAR FINISHING SYSTEM RECOMMENDATIONS

Technology Platform

Nitrocellulose Clear Lacquer, Water White

Basic recommendation, 1 coat of sealer, 2 coats of topcoat, sanding between coats, 3-4 wet mils per coat
 All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)
 Total Film Build should be between 2.0 - 4.0 dry mils

Sealer (Select one)

1C.203 21% Solids, Water White Sealer
 1C.423 23% Solids, Water White Sealer
 1C.397 28% Solids, Water White Sealer
 1C.360 22% Solids, Vinyl Sealer

First Topcoat (Select desired product and sheen)

1LL.21x Series 25% Solids, WW Lacquer

Final Topcoat (Select desired product and sheen)

1LL.21x Series 25% Solids, WW Lacquer

Nitrocellulose Clear Lacquer, Amber

Basic recommendation, 1 coat of sealer, 2 coats of topcoat, sanding between coats, 3-4 wet mils per coat
 All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)
 Total Film Build should be between 2.0 - 4.0 dry mils

Sealer (Select one)

1C.383 26% Solids, HV Production Sealer
 1C.399 26% Solids, HB Production Sealer

First Topcoat (Select desired product and sheen)

1LL.63x Series 27% Solids, High Bld Prod. Lacquer
 1LL.68x Series 29% Solids, High Vis. Prod. Lacquer

Final Topcoat (Select desired product and sheen)

1LL.63x Series 27% Solids, High Bld Prod. Lacquer
 1LL.68x Series 29% Solids, High Vis. Prod. Lacquer

Nitrocellulose Pigmented Lacquer Systems

Basic recommendation, 1 coat of undercoater, 2 coats of topcoat, sanding between coats, 3-4 wet mils per coat
 All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)
 Total Film Build should be between 2.0 - 4.0 dry mils

Undercoater (Select One)

1C.402 31% Solids, White Alkyd/NC Undercoater
 1C.358 43% Solids, White Alkyd/NC Undercoater

 1C.421 31% Solids, White NC/Maleic Undercoater
 1E.410 43% Solids, White NC/Maleic Undercoater
 1C.365 44% Solids, White NC/Maleic Undercoater

 1C.204 30% Solids, White Vinyl Undercoater
 1C.800 45% Solids, White Precat Vinyl Undercoater

 1C.216 42% Solids, Black Undercoater

First Topcoat (Select desired product and sheen)

1A.xx Series 37% Solids, White Conc. Topcoat
 1K01.99xx Series 45% Solids, White Lac. Tint System

Final Topcoat

1A.xx Series 37% Solids, White Conc. Topcoat
 1K01.99xx Series 45% Solids, White Lac. Tint System

1A.xx Series 30% Solids, Black Conc. Topcoat
 1A.xx Series 30% Solids, Black Conc. Topcoat

CAB/Acrylic Clear Finishes

Basic recommendation, 1 coat of sealer, 2 coats of topcoat, sanding between coats, 3-4 wet mils per coat
All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)
Total Film Build should be between 2.0 - 4.0 dry mils

Sealer (Select one)

1C.475 16% Solids, CAB/Acrylic Sealer

First Topcoat (Select desired product and sheen)

1M.97x Series 24% Solids, Cab/Acrylic Finish

Final Topcoat (Select desired product and sheen)

1M.97x Series 24% Solids, Cab/Acrylic Finish

CAB/Acrylic Pigmented Finishes

Basic recommendation, 1 coat of undercoater, 2 coats of topcoat, sanding between coats, 3-4 wet mils per coat
All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)
Total Film Build should be between 2.0 - 4.0 dry mils

Undercoater (Select one)

1C.900 49% Solids, White CAB/Acrylic Undercoater
1C.204 30% Solids, White Vinyl Sealer

First Topcoat (Select desired product and sheen)

1M.96x Series 34% Solids, White CAB/Acrylic

Final Topcoat (Select desired product and sheen)

1M.96x Series 34% Solids, White CAB/Acrylic
1M.97x Series 24% Solids, Cab/Acrylic Finish (if glazing)

Precatalyzed Clear Lacquer Systems

Basic recommendation, 1 coat of sealer, 2 coats of topcoat (or self-seal), sanding between coats, 3-4 wet mils per coat
All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)
Total Film Build should be between 2.5 - 5.0 dry mils

Sealer (Select one)

1C.360 22% Solids, Vinyl Sealer
1C.370 25% Solids, Precatalyzed Vinyl Sealer
1C.380 26% Solids, QD Precatalyzed Vinyl Sealer
1D.33x Series 27% Solids, Prem. Precat. Lac. (self-sealed)
1D.35x.NF Series 32% Solids, HS Precat. Lac. (self-sealed)

First Topcoat (Select desired product and sheen)

1D.33x Series 27% Solids, Prem. Precat. Lac.
1D.35x.NF Series 32% Solids, HS Precat. Lac.

Final Topcoat (Select desired product and sheen)

1D.33x Series 27% Solids, Prem. Precat. Lac.
1D.35x.NF Series 32% Solids, HS Precat. Lac.

Precatalyzed Pigmented Lacquer Systems

Basic recommendation, 1 coat of undercoater, 2 coats of topcoat, sanding between coats, 3-4 wet mils per coat
All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)
Total Film Build should be between 2.5 - 5.0 dry mils

Undercoater (Select one)

1C.800 45% Solids, White Precat Vinyl Undercoater
1E.410 43% Solids, White NC/Maleic Undercoater
1C.365 44% Solids, White NC/Maleic Undercoater
1S.750NF 65% Solids, White Conversion Undercoater

First Topcoat (Select desired product and sheen)

1M.80xNF Series 41% Solids, White Precat TC
1D.33x Series 27% Solids, Prem. Precat. Lac. (if glazing)
1D.35x.NF Series 32% Solids, HS Precat. Lac. (if glazing)

Final Topcoat (Select desired product and sheen)

1M.80xNF Series 41% Solids, White Precat TC
1D.33x Series 27% Solids, Prem. Precat. Lac. (if glazing)
1D.35x.NF Series 32% Solids, HS Precat. Lac. (if glazing)

Conversion Varnish Clear Finishes

Basic recommendation, 1 coat of sealer, 2 coats of topcoat (or self-seal), sanding between coats, 3-4 wet mils per coat

All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)

Total Film Build should be between 2.5 - 5.0 dry mils

Sealer (Select one)

1C.5300	38% Solids, Conversion Sealer
1C.3300	30% Solids, Conversion Sealer
1C.380	26% Solids, QD Precatalyzed Vinyl Sealer
1C.370	25% Solids, Precatalyzed Vinyl Sealer
1M.430x Series	40% Solids, Prem. Con. Varnish (self-sealed)

First Topcoat (Select desired product and sheen)

1M.430x Series	40% Solids, Prem. Con. Varnish
1M.630x Series	50% Solids, HS Conv. Varnish

Final Topcoat (Select desired product and sheen)

1M.430x Series	40% Solids, Prem. Con. Varnish
1M.630x Series	50% Solids, HS Conv. Varnish

Conversion Varnish Pigmented Finishes

Basic recommendation, 1 coat of undercoater, 2 coats of topcoat, sanding between coats, 3-4 wet mils per coat

All products may be tinted with approved colorant system (144 Prism colorants, 844-type colorants)

Total Film Build should be between 2.5 - 5.0 dry mils

Undercoater (Select one)

1S.750NF	65% Solids, White Conversion Undercoater
1C.800	45% Solids, White Precat Vinyl Undercoater
1E.410	43% Solids, White NC/Maleic Undercoater
1C.365	44% Solids, White NC/Maleic Undercoater

First Topcoat (Select desired product and sheen)

1S.75xNF Series	45% Solids, White Conv. Topcoat
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Final Topcoat (Select desired product and sheen)

1S.75xNF Series	45% Solids, White Conv. Topcoat
1M.430x Series	40% Solids, Prem. Con. Varnish (if glazing)

W/B Acrylic Clear Finishes

Basic recommendation, 1 coat of sealer (1-2 wet mils w/b; 3-4 wet mils solvent), 2 coats of topcoat (or self seal), sanding between coats, 3-4 wet mils per topcoat
All products may be tinted with approved colorant system (Universal Glycols, 99 line Prism colorants, Gennex Acrylic colorants)
Total Film Build should be between 2.0 - 4.0 dry mils

Sealer (Select one)

1WB.100 28% Solids, W/B Acrylic Sealer
1WB.10x Si 28% Solids, W/B Acrylic Finish (self-sealed)
1C.360 22% Solids, Vinyl Sealer
1C.370 25% Solids, Precatalyzed Vinyl Sealer
1C.380 26% Solids, QD Precatalyzed Vinyl Sealer

First Topcoat (Select desired product and sheen)

1WB.10x Series 28% Solids, W/B Acrylic Finish

Final Topcoat (Select desired product and sheen)

1WB.10x Series 28% Solids, W/B Acrylic Finish

W/B Acrylic Pigmented Finishes

Basic recommendation, 1 coat of undercoater, 2 coats of topcoat (or self seal), sanding between coats, 3-4 wet mils per coat
All products may be tinted with approved colorant system (Universal Glycols, 99 line Prism colorants, Gennex Acrylic colorants)
Total Film Build should be between 2.0 - 4.0 dry mils

Sealer (Select one)

1WB.200 44% Solids, W/B Acrylic White Undercoater
1WB.20x Si 44% Solids, W/B Acr. White T/C

First Topcoat (Select desired product and sheen)

1WB.20x Series 44% Solids, W/B Acr. White T/C

Final Topcoat (Select desired product and sheen)

1WB.20x Series 44% Solids, W/B Acr. White T/C

W/B Polyurethane Clear Finishes

Basic recommendation, self-seal 3 coats of topcoat, sanding between coats, 3-4 wet mils per coat
Total Film Build should be between 3.0 - 4.0 dry mils

Sealer (Select one)

1WB.50x Si 31% Solids, W/B Acrylic Finish (self-sealed)

First Topcoat (Select desired product and sheen)

1WB.50x Series 31% Solids, W/B Acrylic Finish

Final Topcoat (Select desired product and sheen)

1WB.50x Series 31% Solids, W/B Acrylic Finish

Transparent Stain/Color Applications can be summarized by the diagram below:

Basic Recommendations

Only one pigmented color coat per layer.

Dyes cannot be the only color coat - they must be used in conjunction with a pigmented coat

If glazing, then only one glaze step for any finish

If glazing, then the glaze application is the final color coat applied.

Advanced Color Applications

Color Coats Used in Finishing

