

The LAWRENCE-MCFADDEN CO.



Established 1875 - Incorporated 1899

INDUSTRIAL FINISHING PRODUCTS

7430 STATE ROAD

Philadelphia Pennsylvania, 19136

Finishing Schedule for Acoustic Guitars

- 1) Sand Guitar - 180 Grit
- 2) Spray washcoat (R-1613). Air dry 45-60 minutes. Scuff sand 280 grit.
- 3) Fill open pore wood with paste filler. Dry filler 24 hours.
See filler Technical Bulletin for filler reduction and application notes.
- 4) Clean/Scrap bindings.
- 5) Spray washcoat (R-1613). Air dry 45-60 minutes. Scuff sand 280 grit.
- 6) Apply 4 coats lacquer (L-3651). Allow 1 1/2 hour between coats.
- 7) Air dry 24-48 hours. Level sand.
- 8) Apply 4 coats lacquer (L-3651). Allow 1 1/2 hours between coats..
- 9) Dry 7-10 days before rubbing and polishing.

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R-1613

VINYL WASH COAT

R-1613, Vinyl Wash Coat, is an 11% solid coating which can be used as a washcoat or sealer. It has excellent adhesion to wood. It also has good inter-coat adhesion, moisture resistance and flexibility.

When using filler, we recommend to spray R-1613 under and over the filler to maintain good adhesion in the system.

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PASTE WOOD FILLER

Paste wood filler is an alkyd based filler designed to produce excellent filling properties to open pore wood species such as oak, mahogany, walnut and ash. We recommend using naphtha as a reducer whenever possible, because it produces the best filling results. For deep pore species such as oak and mahogany, we recommend applying our blister-free washcoat (R-1674) prior to filling. For other species, apply R-1613 prior to filler. For best adhesion to the subsequent coating, we recommend vinyl sealer R-1613 after wood filler. Allow the filler to flash before wiping in a circular motion. Rotate the rag or cloth and remove excess. Since the filler contains linseed oil and is combustible, soiled rags should be discarded properly. Allow filler to air dry thoroughly (8 hours or more) before proceeding with further operations.

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TECHNICAL BULLETIN

L-3651

GLOSS GUITAR LACQUER

L-3651 is a full gloss lacquer designed for use on acoustical or solid body guitars where multiple coats are required, and good rub and buff are desirable characteristics.

Physical Properties

Visc	20" #4 FC @ 77 degree F
Solids	22%
Sheen	Gloss

Film Properties

Cold Check	20 cycles (ASTM-D1211-60)
Adhesion	Excellent
Mar Resistance	Good
UV Stability	Good
Print Resistance	Good
Rub & Polish	Excellent

This lacquer has been formulated so that multiple coats can be used. We do not recommend more than 8 coats, applying 5 wet mils each coat. We recommend the use of a non-stearated sealer such as R-1613 vinyl sealer to promote good adhesion to the substrate (two coats of vinyl sealer can be used). When several coats of lacquer are applied we suggest allowing 7 days air dry with good air movement before rub and polish.

Please contact the Lawrence-McFadden Company for further information concerning this product.