

# TECHNICAL DATA SHEET

supersedes previous issue dated 08/02/01

**PU 317**
**CLEAR POLYESTER BASECOAT FOR BUFFING**

Area of use:	Briar car accessories	
Method of use:	Conventional or electrostatic two components spray gun	
Mixing procedure:	by weight	
Part A :	PU 317	100
Part B (accelerator) :	PH 888	1-2
Part C (catalyst) :	PH 999	2
Thinner :	DP 695	10-15

## Technical characteristics

Solids content (%):	98 ± 2	
Specific gravity (kg/l):	PU 317	1.030 ± 0.030
	PH 888	0.915 ± 0.030
	PH 999	1.160 ± 0.030
Viscosity (DIN 4 at 20°C):	110" ± 10"	
Pot-life at 20°C:	20' approx.	

## Substrate preparation

Use solvent based stains series XM7100/XX or XM8000/XX on surface protected with barrier (TU 565 hardened at 100% with TH 765 for briar; TR4027 hardened at 20% with XT4028 for resinous timbers).

## General characteristics

Recommended application weight (g/m <sup>2</sup> ):	130 ÷ 200	
Interval between coats (20°C):	Min. 30' - Max. 45'	
Number of coats:	Max. 6	
Maximum recommended thickness - dry film:	800 µm	
Drying time (1 coat 250 g/m <sup>2</sup> at 20°C):	Dust free	20'
	Touch dry	60'
UV curing system (if required):	Use RX7106 at 4% as photoinitiator. At the end of system, 60' after the last coat, 1 80 W per cm lamp at 1.5 m/min.	
Sanding and buffing:	Wait at least 72 hours at 20°C or 24 hours after UV curing.	
Shelf-life (months):	6	

PU 317 is a polyester with high build and excellent transparency and elasticity, to be buffed after hardening. It is particularly suitable for briar items for interiors and car steering wheels and is specifically designed to successfully overcome the severe tests imposed by the car manufacturing companies.

PU 317 can be fully cured with Redox or with UV lamps. In case of UV curing, RX7106 photoinitiator shall be used.

In case of Redox curing, we recommend the use of a two components spray gun with an interval between coats of approx. 30 minutes up to a maximum of 6 coats with a total maximum dry thickness of 800 µm.

Mixing ratio at 2% with PH 888 and PH 999 refers to winter.

During summer, we recommend to reduce ratio with PH 888 to 1% in order to avoid problems of stratification.

## Warning

- Polyester should be used at a temperature of no lower than 20°C.

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- PH 888 and PH 999 or an accelerator and a peroxide in direct contact can cause a violent chemical reaction which would constitute a hazard for the operator. For this reason, first mix the PH 888 thoroughly with PU 317 and only then add the PH 999.
- For application on bleached briar, use SC3873 barrier hardened at 100% with TH2550.