

TECHNICAL DATA SHEET

supersedes previous issue dated 08/06/04

PU 342
HIGHLY THIXOTROPIC CLEAR POLYESTER BASECOAT

Area of use:	General use.		
Method of use:	Manual and robot spray gun. Use a two-component gun.		
Mixing procedure:		by weight	by volume
Part A	PU 342	100	100
Part B (accelerator)	PH 888	2	2.2
Part C (catalyst)	PH 999	2	1.7
Thinner	DX 1131	5-20	5-20

Technical characteristics

Solids content (%):	92 ± 2
Specific gravity (kg/l):	1.000 ± 0.030
Viscosity (DIN 8 at 20°C):	23" ± 3"

Substrate preparation

Sand and clean thoroughly.

If staining is required, use XM 8000/XX stains.

Exotic timbers (rosewood, teak, Mansonia walnut, etc.) must be sealed with TR 4027/XT 4028 barrier.

For other types of non-exotic but particular porous timbers, an ideal undercoat is the barrier TU 565/TH 765.

With Erable or reconstituted veneers, use XT 4022 which does not alter the colours and wets the pores well.

General characteristics

Pot -life at 20°C:	about 15 min.
Recommended application weight (g/m ²):	max. 250 per coat
Interval between coats (min.):	min. 15' - max. 30'
Number of coats:	max. 3
Drying time (1 coat 250 g/m ² at 20°C):	dust free: 35'-40'
Stacking:	at least 4 hours
Forced air drying:	10' flash off 20' at 45°C 10' cooling
Sanding:	wait at least 12 hours
Overcoating:	wait at least 12 hours
Film colour:	light brown
Shelf-life (months):	6

PU 342 is a highly thixotropic wax -free polyester coating with excellent flow and build for both horizontal and vertical application. It ensures excellent transparency, good elasticity, absence of shrink and excellent sandability. The mixing proportions of 2% PH 888 and 2% PH 999 is to be used in winter.

During the summer to avoid problems of stratification is it advisable to reduce the percentage of PH 888 and PH 999 to as little as 1%.

During winter, increase the percentage of PH 888 even by 1%.

To increase pot -life to about 45 minutes, use PH 666 at a concentration of 4% instead of PH 999.

Drying time will be increased.

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To obtain a clear film we recommend using accelerator PH 777 at 2%. PH 777 slows down drying and reduces pot -life (to about 10 minutes).

Special instructions: accelerators and catalysts

- Polyester coatings should be used at temperatures not below 20°C.
- PH 888 and PH 999 or an accelerator and a peroxide in direct contact can give rise to a violent chemical reaction which can constitute a hazard for the user. For this reason take great care to mix PH 888 or PH 777 well first with PU 342 and only then add PH 999 or PH 666.
- To assure good adhesion of the topcoat to the PU 342 basecoat it is essential to apply the topcoat as soon as possible after sanding.

Special instructions: MDF

In view of the considerable differences in structure and binders used in MDF currently available on the market and of the need to perform subsequent work (machining, turning etc.), we recommend that substrate stability is always checked before coating.