

TECHNICAL DATA SHEET

supersedes previous issue dated 18/03/97

PU 377/00
CLEAR POLYESTER BASECOAT

Area of use:	Flat part and profiles		
Method of use:	Conventional and airless spray guns and curtain coater.		
Mixing procedure:		by weight	by volume
Part A :	PU 377/00	100	100
Part B (accelerator) :	PH 888	2	2.2
Part C (catalyst) :	PH 999	2	1.7
Thinner :	DX 931	5-15	5-20

Technical characteristics

Solids content (%):	89 ± 3
Specific gravity (kg/l):	1.036 ± 0.030
Viscosity (DIN 8 at 20°C):	18" ± 2"

General characteristics

Pot -life at 20°C:	about 15'	
Recommended application weight (g/m ²):	Max. 250	
Interval between coats (20°C):	Min. 40' - Max. 60'	
Number of coats:	Max. 4	
Drying time (1 coat 250 g/m ² at 20°C):	Dust free	20'
	Touch dry	60'
Stacking:	Minimum 8 hours	
Forced air drying:	Flash off	15'
	50°C	60'
	Cooling	15'
Sanding:	Wait at least 16 hours.	
Overcoating:	Wait at least 16 hours.	
Shelf-life (months):	PU 377	6
	PH 888	6
	PH 999	6

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 particularly porous woods, an ideal substrate is the barrier TU 565 / TH 765.

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

General characteristics

PU 377/00 is a wax -free polyester with high build and excellent flow, both horizontally and vertically. It exhibits excellent transparency, good elasticity, absence of shrinking and excellent sandability.

PU 377/00 can be applied both horizontally and vertically, preferably using two-component spray guns since pot -life with normal catalyst PH 999 is fairly short (about 12 minutes).

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When a longer pot -life is required (about 40 minutes), use 4% of catalyst PH 666, but bear in mind that this will slow down drying.

Once it has cured, PU 377/00 can be sanded either manually or automatically. In order to facilitate flow during the summer, it is advisable to thin with thinner DP 695. The specified mixing procedures refer to a temperature of 20°C. At lower temperatures the only, albeit partial, remedy to compensate for the reduction in reactivity is to increase the percentage of accelerator by 1%.

At higher temperatures the quantities of both accelerator and catalyst should be reduced in order to avoid problems of stratification between the various coats. During the summer it is also advisable to replace PH 999 with PH 666, which increases pot -life and makes it less sensitive to problems of stratification.

For application on pale-coloured woods we recommend using 2% of accelerator PH 777 instead of PH 888, as it keeps the film colour very clear.

Warning

- Polyester should be used at a temperature of no lower than 20°C.
- 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 the PU 377 and only then add the PH 999 or PH 666.
- In order to ensure good adhesion of the topcoat onto the basecoat PU 377, it is essential that the time between sanding and application of the topcoat does not exceed 24 hours.

Special instructions for coating 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 always recommend checking substrate stability before carrying out the coating system.