

# TECHNICAL DATA SHEET

supersedes previous issue dated 18/12/97

**PU 388/13**
**WHITE PIGMENTED POLYESTER BASECOAT**

|                                 |   |           |           |
|---------------------------------|---|-----------|-----------|
| Area of use:                    | Flat parts, turned parts, profiles.                 |           |           |
| Method of use:                  | Conventional, airless and electrostatic spray guns. |           |           |
| Mixing procedure:               |   | by weight | by volume |
| Part A                          | PU 388/13   | 100       | 100       |
| Part B (Accelerator)            | PH 222  | 2         | 3         |
| Part C (Catalyst)               | PH 666  | 4         | 6         |
| Thinner for normal spray        | DX 1131   | 10-20     | 10-20     |
| Thinner for electrostatic spray | DP 695  | 20-30     | 20-30     |

### Technical characteristics

|                            |               |
|----------------------------|---------------|
| Solids content (%):        | 92 ± 2        |
| Specific gravity (kg/l):   | 1.450 ± 0.030 |
| Viscosity (DIN 8 at 20°C): | 20" ± 2"      |

### Substrate preparation

Sand and clean thoroughly.

### General characteristics

|   |                              |         |
|---|------------------------------|---------|
| Pot-life at 20°C:                                   | 4 hours                      |         |
| Recommended application weight (g/m <sup>2</sup> ): | Min. 100 - Max. 300 per coat |         |
| Interval between coats:                             | Min. 45' - Max. 3 hours      |         |
| Number of coats:                                    | Max. 4                       |         |
| Drying time (300 g/m <sup>2</sup> ) at 20°C:        | Dust free                    | 30'     |
|   | Touch dry                    | 150'    |
|   | Stackable                    | 8 hours |
| Forced drying (300 g/m <sup>2</sup> ):              | Flash off                    | 20'     |
|   | 50°C                         | 80'     |
|   | Cooling                      | 20'     |
| Sanding:  | Wait at least 12 hours.      |         |
| Overcoating:  | Wait at least 16 hours.      |         |
| Shelf-life (months):                                | PU 388/13                    | 6       |
|   | PH 222                       | 6       |
|   | PH 666                       | 6       |

PU 388/13 is a polyester basecoat with excellent hiding power, long pot-life, elasticity, thixotropy, and excellent manual and mechanical sandability.

PU 388/13 has an extremely wide field of application, ranging from MDF to other extremely absorbent substrates, and from chairs to profiles of any kind. In particular it is the ideal basecoat on which to apply pigmented gloss topcoats since it does not exhibit lifting or absorption (we recommend waiting at least 48 hours before applying the pigmented topcoat). When sanding PU 388/13, use sandpaper and scotch-brite with a slightly coarser grain and specifically designed for polyester coatings. In order to avoid surface polishing problems, it is always advisable to use a coarse grain to break the surface layer and then a finer grain. If sanding is carried out appropriately, TZ 88\*\*/XX pigmented topcoats will show good adhesion even with an interval of a week between sanding and applying the topcoat. With gloss pigmented topcoat TL 335/XX it is possible to wait even longer.

If you wish to speed up drying, use 2% of PH 888 instead of PH 222 or increase the quantity of PH 222 to 4%. In either case, use 4% of PH 666 as catalyst. With these different methods of acceleration, pot-life is reduced to about 2 hours, stacking times are reduced to about 3 hours, and a harder film is obtained which is more difficult to sand, especially when aged.

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**PU 388/13****WHITE PIGMENTED POLYESTER BASECOAT****Warning: accelerators and catalysts**

If PH 222 and PH 666 come into direct contact they can cause a violent chemical reaction which can constitute a hazard for the operator. For this reason, first mix the PH 222 thoroughly with the PU 388/13 and only then mix with the PH 666.

**Special instructions: MDF**

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

It is equally important to avoid significant accumulation of product in grooves and channelling, since the solvent could remain trapped in the film and cause cracking.

**N.B.**

To reduce overspray towards operator and to increase conductivity, XT 4035 may be added to the product in a percentage of 0.5-1% max.