

# TECHNICAL DATA SHEET

supersedes previous issue dated 09/09/97

**TU 1**
**CLEAR POLYURETHANE BASECOAT**

Area of use:	Flat parts, fitted furniture, solid wooden parts, doors.		
Method of use:	Spray gun and curtain coater.		
Mixing procedure:		by weight (kg)	by volume (l)
	Part A	TU 1	100
	Part B (hardener)	TH 775	50
	Thinner	DT 450	20

**Technical characteristics:**

Solids content (%):	46 ± 1
Specific gravity (kg/l):	0.980 ± 0.030
Viscosity (DIN 4 at 20°C):	Part A: 60" ± 4" A + B: 20" ± 3"

**Substrate preparation**

Stain using waterborne stains (AC 600/XX) or solvent-based stains (XM 7100/XX, XM 8000/XX).

**General characteristics**

Pot-life at 20°C:	3 hours
Recommended application weight (g/m <sup>2</sup> ):	Max. 180 per coat
Interval between coats:	Min. 1 hour - Max. 3 hours
Number of coats:	Max. 3
Drying time (100 g/m <sup>2</sup> at 20°C):	Dust free 10' Touch dry 30' Stackable 6 hours
Forced drying (100 g/m <sup>2</sup> ):	Flash off 15' 50°C 60' Cooling 15'
Sanding:	Wait at least 16 hours.
Overcoating:	Wait at least 16 hours.
Shelf-life:	If the product is properly stored, shelf-life is unlimited. After long periods of storage, always check homogeneity and stir well before use to eliminate any possible sediment.

TU 1 is a general-purpose polyurethane basecoat.  
 It is extremely versatile and suitable for most applications.  
 In particular it has good sandability, good build and excellent lifting resistance.  
 TU 1 can be applied using airmix or airless spray guns or curtain coater.

**Alternative hardeners**

- TH 755 at 50% - hardener without St. Andrew's cross
- TH 805 at 50% - slightly lower build and longer drying times.

**Special instructions**

During the summer, or in tropical areas, it is preferable to use slow-drying thinner DT 446 at 30-50%.

For tinting TU 1, XC 1900/XX stains are recommended.