

Product Application Sheet



LUA43X Clear Acrylic Self-Seal Polyurethane Topcoat - Various Sheens

General Information - Clear Self-Seal Acrylic Polyurethane Topcoats

Milesi acrylic polyurethane systems are the best choice for light color woods or when an open pore close to the wood look is desired.

Milesi acrylic self-seal polyurethanes do not require a sealer.

Generally acrylic polyurethane topcoats use medium to slow reducers to insure good flow out and leveling.

Self-Seal acrylic systems normally only require 2 coats. The first acts as the sealer and the second as the topcoat.

General Information – Catalysts

Acrylic polyurethane sealers and topcoats, clear and pigmented use only 1 catalyst, the LNB99

General Information – Reducers

Milesi polyurethane reducers use virgin solvents and are designed specifically for Milesi products. If problems like lack of flow out or bubbles/pinholes occur it is usually a reduction problem. Either add more reducer or a slower reducer.

Most polyurethane clear and pigmented topcoats use medium to slow reducers to get optimal flow out and leveling. Typically these are the LZC1051, LZC8543 and LZC70. There are some exceptions.

For very warm temperatures up to 5% of LTC40 retarder can be added to these reducers instead of switching to a slower reducer.

RECOMMENDED APPLICATION: Clear Polyurethane sealers and Topcoats			
	Tip sizes	Atomization pressure	Product pressure
Conventional air spray	1.8 – 2.1 0.070-0.086	-	30-40 psi
Airless spray	0.009 – 0.011	-	1800 – 2100 psi
Air assisted spray	0.009 – 0.011	15 – 20 psi	600 – 900 psi

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White Wood Sanding

Sand bare wood with up to 150 grit Aluminum Oxide sandpaper. Best results when sand, stain and seal within 8 hours. Be sure to break all sharp edges.

Stain

Allow to dry 30 to 60 minutes depending on type of stain. Always make a sample when using these products for the first time over your current stains to insure compatibility

Self Seal Topcoat Application

- **LUA46X** Acrylic Polyurethane Topcoat - Various Sheens
- Catalyze 10% by weight with LNB99 Catalyst
- Reduce 20% by weight with LZC8643 Reducer
- Reducer is always measured as a percentage of the Part A resin only
- For very warm temperatures up to 5% of LTC40 retarder can be added to the LZC8643
- Adding retarder will increase dry time and potential for runs on vertical surfaces.
- Viscosity: 18 seconds #4 Ford cup.
- Potlife is 24 Hours – less at high temperatures
- Apply 5 -6 wet mils

Dry

Minimum 2 hours before sanding

- 4 hours is better
- The longer dry time allows the solvent to evaporate before applying further coats. This will help reduce shrinkage back into the pores over time and reduce the possibilities of the producing solvent pop in the topcoat.

1st Coat Sand

Sand 320 Silicon Carbide sandpaper

Recoat

Apply second coat after sanding, normally only 2 coats total are required.

If additional build is required:

- For wet on wet application: Wait 1 - 2 hours maximum. Apply next coat wet on wet – no sanding between coats.
- This is very important because it allows for a chemical burn in between the 2 coats.
 - If you miss this recoat window wait at least 6 hours and then sand well with 320 grit silicon carbide sandpaper and recoat following the above mixing and drying procedures.

Dry Time

Dry 24 hours before stacking

Clean Up

- Clean up equipment immediately after use with acetone
- Dispose of all cleaning materials and solvents in proper manner

Product Code	Milesi Catalyzation Chart	Catalyst	% Catalyst		Pot Life	% Reduction	
			By Vol	By Wt		By Vol	By Wt
LUA43X	Clear Acrylic Self-Seal Polyurethane Topcoat	LNB99	10	10	24 Hr	22	20

If using equipment for both solvent and water base products:

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- When switching from solvent to water, flush sprayguns with water before using.
- When switching from water to solvent, flush with denatured alcohol or acetone after cleaning with water. This will attract any water left in the system. Then flush with the appropriate solvent to temper the gun.

Health and Safety

Spray finishing produces mists and these can clog or irritate the lungs. Always wear personal protection.

- Always apply finishes in a properly ventilated spray booth.
- Use of a properly fitted respirator with a fresh organic vapor cartridge is recommended. A full face mask is best.
- Wear safety glasses or goggles if you don't have a full face mask.
- Wear a dust mask while sanding these finishes.

ADDITIONAL INFORMATION

- PU hardeners are moisture sensitive; always keep containers tightly closed
- Always be sure to use the recommended catalysts and PU thinners to reduce viscosity.
- Accurately measure resins and catalysts.
- Observe pot life times and recoat windows.
- Pot life decreases as temperatures rise.
- Product viscosity increases as pot life expires.
- Always keep catalyst and resin cans closed when not in use.
- Pot-life is stated at 68°F, we recommend to use the prepared quantitative before 1h, to obtain best results of sheen and flow out.
- Ammonia cleaners should not be used for cleaning the finished surface. This may cause discoloration.

For best results, the optimum conditions for application are:

- Ambient temperature between 18 and 22°C (64 - 72 °F)
- Ambient relative humidity between 65 and 70%
- Substrate moisture content between 8 and 14%

The conditions to be followed scrupulously are:

- Water base products should be stored indoors at temperatures not below 0 °C / 32°F or above 35 °C /95°F, in a properly ventilated place, not exposed to sunlight
- Always agitate well the products and other components such as catalysts, accelerators and thinners before and after blending
- Application must not take place at a temperature lower than 15 °C / 59°F or above 30°C / 86°F
- Drying should not take place at a temperature below 15 °C / 59°F
- Once the product has flashed off air movement will facilitate drying.
- Ambient relative humidity during drying should be between 50% and 70%

It is the user's responsibility:

- Adhere to the conditions indicated above
- Comply with the rules of hygiene and safety during product application, according to the descriptions given in the safety data sheets

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used

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