Finishing Procedure for Milesi
KKRXX Series White Polyurethane Topcoat - Various Sheens

General Information - White and Neutral Polyurethane Topcoats

Milesi white and neutral polyurethane topcoats can be tinted with the Milesi KMT colorants, though the neutral topcoat has a much higher tint load and is recommended for deep colors. The Milesi KMT colorants contain polyurethane resins that enables them to crosslink with the catalyst. This insured the most durable and highest performance coating

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

More than 1 coat of primer may be used, but most Milesi polyurethane systems require only 1 topcoat. The exception is gloss topcoats that are designed to be buffed. They should have 2 topcoats applied wet on wet.

General Information – Catalysts

While acrylic polyurethanes use only 1 catalyst, the standard polyurethanes can often use a variety of catalysts. This is to tailor performance characteristics of the product.

For standard polyurethanes:

- The LNB42 catalyst: faster drying and harder but is more brittle and more yellowing. Not recommended in systems that require more than 3 total coats.
- The LNB20 catalyst: slower drying, more flexible and resists yellowing.

General Information – Reducers

Milesi polyurethane reduces 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 LTZ40 retarder can be added to these reducers instead of switching to a slower reducer.

RECOMMENDED APPLICATION: Pigmented 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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Topcoat Application

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- Catalyze 50% by weight with LNB20 or LNB42 - depending on desired properties
- Reduce 30% by weight (minimum) with LZC1051 or LZC8643 reducer
- Reducer is always measured as a percentage of the Part A resin only
- Use the LZC1051 for mild temperatures and the LZC8643 for warm to hot temperatures.
- For very warm temperatures up to 5% of LTZ40 retarder can be added to the LZC8643
- Viscosity: 20 seconds #4 Ford cup.
- Potlife is 3 hours– less at high temperatures
- Apply 5 -6 wet mils

Available Sheens			
Product	**Sheen**	**Product**	**Sheen**
KKR00	**80**	KKR1	**20**
KKR01	50	KKR2	10

Recoat

Normally only 1 topcoat is required. Film build should be done with primers

If a second coat is needed:

- For wet on wet application: Wait 1 to 3 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 the recoat window is missed or if is necessary to sand because of dust entrapment then the first coat must be thoroughly dry and then sanded well with 320 grit silicon carbide sandpaper.*
- *After the last coat, if you wish, you can apply a clear coat wet on wet. Again, if the recoat window is missed or if is necessary so sand because of dust entrapment then the previous coat must be sanded with 320 grit before recoating. Sand up to 600 grit silicon carbide sandpaper for clear gloss topcoats.*

Dry Time

12 hours minimum to stack

Clean Up

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

ADDITIONAL INFORMATION

- PU hardeners are moisture sensitive; always keep containers tightly closed
- Always be sure to use the product with the appropriate and recommended hardener and with right percentage.
- Always be sure to use the recommended catalysts and PU thinners to reduce viscosity.
- 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:

- Solvent-based 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
- Ambient relative humidity during drying should be between 50% and 70%

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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