



Finishing Procedure for Milesi LBA45 Clear Polyurethane Sealer

General Information - Clear Polyurethane Sealers

Milesi polyurethane systems are the best choice for medium to dark color woods or when a higher film build on the wood is desired. These products have the potential to slight yellow over time. This is mainly influenced by the choice of catalyst.

Polyurethane sealers are designed with 2 important properties. The first is that they will easily let solvent evaporate out of them. This decreases dry times and reduces the possibilities of the producing solvent pop in the topcoat. Most often faster reducers are used in the polyurethane sealers.

The second is that they have great transparency, unlike acid cured products. This allows you to do all of your film building with sealers and not topcoats.

More than 1 coat of sealer 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 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 sealers and primers use fast reducers like the LZC1026. 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: 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

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. When in doubt use an Isolante before applying the sealer.

LBA45 Clear Polyurethane Sealer

Sealer Application

- **LBA45** Clear Polyurethane Sealer
- Catalyze 50% by weight with LNB20 or LNB42 - depending on desired properties
- Reduce 20% by weight (minimum) with LZC1026 reducer
- Reducer is always measured as a percentage of the Part A resin only
- Percent reduction is determined by the species of wood. Close grained woods can use a 20% reduction schedule. *Deep pore woods like mahogany reduction for the first coat should be about 30 to 40%. Additional coats can be reduced 20%. The additional reduction will reduce the coatings surface tension and allow it to flow into the pores.*
- Viscosity: 18 seconds #4 Ford cup.
- Potlife is 4 hours— less at high temperatures
- Apply 5-6 wet mils

Dry

Minimum 2 hours before sanding

- 4 hours is better.
- The long 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.

Sealer Sand

After through drying sand with 320 grit Silicon Carbide sandpaper

Recoat

If additional build is required recoat with the LBA45 sealer.

- 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 4 hours and then sand with a 320 grit silicon carbide sandpaper and recoat following the above mixing and drying procedures.

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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