***We recommend that you always use Milesi Isolante (LQA 24011) Barrier Coat Sealer underneath the Milesi (LRA 94) Polyester Sealer.**

Finishing Procedure for Milesi LRA94 Clear Polyester Sealer

General Information - Clear Polyester Sealers

Milesi polyester sealers are designed to provide exceptional fill and long term resistance to shrink-back. They are the best choice for gloss topcoats. Milesi polyester sealers must be applied over an isolante. Polyester sealers are designed to be applied wet on wet, with no sanding between coats. This results in a significant saving of time and labor.

Polyester sealers can be topcoated with any sheen product and these 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 - Polyester Catalysts and Accelerators

Accelerators

LOB841 Accelerator contains an anti-greening additive that will reduce the green cast in the polyester that sometimes appears when it is newly applied. The green does go away over time.

LOB828 Accelerator is more specific for curtain coater application. It is also best used in temperatures above 86°F

LOB818 Accelerator is used primarily used in clear glossy polyester topcoats and white primers. It contains a small quantity of an additive, chemically a silicon, that influences the surface tension of the product ready to use. This additive is not present in LOB828. With this modification, the product has a better distension and a higher ability to release air. This is very important for spray application. When you spray a product, it is mixed with air to get a perfect atomization, but sometimes the product is not able to release this air, and air remains trapped inside the film and it gives rise to bubbles or other defects (pinholes). With this small portion of silicon you don't have these problems and no other feature is modified. So the ratio remains 2% (can be modified if the temperature changes).

All of the above are normally used at 2% by weight of the polyester resin. Accelerators should always be thoroughly mixed into the resin before adding the catalyst.

For temperatures above 86º F use 1/2 the amount of accelerator and the normal amount of catalyst. This will help extend the normal potlife.

Catalysts

LOB810 is the normal catalyst used in polyester sealers and primers. It has a 15 minute potlife

LOB5 catalyst is best used in temperatures above 86°F or when a slightly longer 30 minute potlife is required

General Information - Reducers

Polyesters always use the LZC17982 acetone as a reducer

RECOMMENDED APPLICATION: Clear Polyester 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.

LRA94 Clear Polyester Sealer

NOTE: It is wise to make extra "Test" panels as you go through these processes. They will help you determine optimal dry times before moving on to the next step.

Apply Polyester Sealer

LRA94 Polyester Sealer

- First add 2% by weight of LOB828 accelerator
- Second catalyze 2% by weight with LOB5 Extended pot Life Catalyst
- Reduce 10 to 20% with LZC17982 Acetone. The LZC17982 Acetone is a pharmaceutical grade acetone and is 99,6% pure.
- Never use reclaimed Acetone as it may contain water or other chemicals that will prevent the drying of the polyester.
- For deep pore woods like mahogany, thinning the first coat or two by 30% or more and you can reduce the potential for pinholes caused by air trapped in the deep pores. Follow by additional coats thinned normally.
- Viscosity: 26 seconds #4 Ford cup.
- Potlife is 30 Minutes - less at high temperatures: 86°F and above.
- Apply 6-10 wet mils

NOTE: *the above is for a single mix. If mixing in bulk use 2 equal amounts of resin and add 4% catalyst to one and 4% accelerator to the other. When ready to spray – mix equal amounts of the resin mixtures together, reduce appropriately then spray.*

NOTE: If mixing a single batch of PE always add Accelerator first, stir well and then add Catalyst, again stirring well. Follow by reducing the mixture.

High Temperature Application

For temperatures above 86º F use 1/2 the amount of accelerator and the normal amount of catalyst. This will help extend the normal potlife.

NOTE: EXTREMELY IMPORTANT - Never let the Catalyst and the Accelerator come in direct contact with each other as they will spontaneously combust.

Recoat

Recoat – wet on wet with no sanding between coats.

- Typically an additional coat(s) can be applied in approximately 20-25 minutes. This is when touching the previous coat will leave a finger print but not pull up a "string" of finish.
- Apply 1 to 2 additional coats, as necessary to achieve a full filled pore.

Dry Time

Dry overnight as a minimum.

- *Longer is always better. This will further reduce the possibility of shrink back over time*

Clean Up

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

Sealer Sand

After through drying sand with 320 grit Silicon Carbide sandpaper

- *For glossy finishes the last sealer coat can have additional sanding up to 600 grit will help eliminate the possibility of sanding scratches from telegraphing through to the topcoat.*

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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