



TECHNICAL DATA SHEET

PRODUCT PE330 TRANSPARENT POLYESTER SANDING SEALER

DESCRIPTION PE330 Transparent Polyester sanding sealer is a two-part, high resin content sealer which gives excellent filling properties, adhesion to substrate and resistance to cold checking.
Other features are excellent vertical hold up, transparency and sanding properties.

USED FOR Furniture and any type of wood substrate where it is desirable to enhance the natural texture and grain.

PROPERTIES

| | |
|-----------------------------|---------------------------|
| COLOUR | Clear only |
| GLOSS LEVEL | Semi- gloss |
| SOLVENT RESISTANCE | Very Good |
| SANDABILITY | Excellent |
| BUILD | Excellent |
| SINKBACK | Minimal |
| WATER RESISTANCE | Very Good |
| VERTICAL HOLD UP | Good |
| HARDNESS | Excellent after full cure |
| LEVELLING & FLOW | Good |

TECHNICAL DATA

| | |
|----------------------------------|-----------------|
| 1. Viscosity Ford 4 Cup at 20°C. | 90 ± 5 seconds |
| 2. Solids content Part "A" | 83 ± 1% |
| 3. Pot Life at 20 °C | 60 - 90 minutes |
| 4. Dust Free at 20 °C | 40 - 45 minutes |
| 5. Touch dry at 20 °C | 3 hours |
| 6. Through cure 20 °C | 12 - 14 hours |
| 7. Flash Point (mixed) | > 21°C |
| 8. Specific Gravity | 1.04 |



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| COVERAGE | From 200 to 300 gm / m ² for each coat, depending on type of substrate. | | |
| THEORETICAL | 2.3 square metres / litre at 300 microns. | | |
| MIXING RATIO | PE330 Part "A" | 1 litre | 20 litres |
| | PE230/PE330 Hardener | 20 ml. | 400 ml. |
| | * May vary seasonally. Refer to manufacturer. | | |
| POT LIFE AT 25 °C | 60 - 90 minutes @ 25 °C | | |
| APPLICATION METHODS | Conventional spray / Pressure Pot. | | |
| MINIMUM FLASH OFF TIME | 5 minutes | | |
| SANDING AND TOP COATING | Allow 10 Hours before Top Coating MUST BE SANDED before top coating - remove sanding dust. If more than 24 hours between sanding and top coating, lightly abrade and remove sanding dust. | | |
| SHELF LIFE | At 20 ° C - 6 months (sealed in original pack) - Part A | | |
| | At 20 ° C - 12 months (sealed in original pack) - Part B | | |
| PACKAGING | Part A | 4 litre | 20 litre |
| | Part B | 100 ml. | 500 ml. |

SYSTEM RECOMMENDATIONS

| SUBSTRATE | PREPARATION | COATING SEQUENCE | FILM BUILD WET (DRY) |
|---|--------------------------|---|--|
| TIMBER M.D.F, PARTICLE BOARD | Sand and remove dust. | 1st Coat : Any suitable polyurethane isolation or barrier coat e.g. UT300/UT310 Sealer 2nd Coat : PE330 2-Pack Transparent Polyester Sanding Sealer Finish coat: UT900 2-Pack Fast Dry Clear Topcoat. or UT100 Series 2-Pack Acrylic Clear Topcoat. or Other suitable lacquer or polyester clear topcoats. | 80 microns 300 microns 80 microns 80 - 100 microns (36 - 45 microns) T.B.A. |

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SURFACE PREPARATION

TIMBER / M.D.F. OR PARTICLE BOARD

Surface should be dry, clean and free from large gaps or imperfections. An initial sand with 180 grit or Fre-cut paper is recommended prior to isolating. Remove by blow-off or vacuum all excess dust then apply isolation coat according to instructions. De-nib or abrade once dry and proceed to apply PE330 Sealer as recommended.

APPLICATION

MIXING

See MIXING RATIO on page 2.

THINNING

PE330 Sealer is designed as a ready for use system, but up to 5% thinners may be required. If thinning is necessary, PE100 Thinner is recommended. Use PE110 thinners for warm to hot conditions.

SPRAYING

SUCTION GUN - using 72 - 86 thou orifice
at 300 - 350 kPa (40 - 50 p.s.i.)

For PRESSURE POT applications use 40 - 50 thou orifice with a pressure pot air cap, air pressure of 350 kPa (50 p.s.i.) and a MAXIMUM pot pressure of 45 kPa (6 p.s.i.).

EQUIPMENT CLEANUP

All equipment should be thoroughly cleaned with PE100 Thinner.



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PRECAUTIONS

SAFETY Do NOT smoke.

This product is peroxide catalysed and the necessary precautions must be observed when handling this material.

GENERAL Freshly mixed material must not be added to material which has been in use for some time. Rate of cure is dependent upon temperature.

Do not apply this product at temperatures below 10°C or relative humidity above 85%.

Ensure maximum recoat interval is not exceeded otherwise surface must be lightly abraded and then dusted to ensure maximum inter-coat adhesion.

Shelf life is normally 6 months in original sealed container, but depends on storage conditions.

DANGEROUS GOODS

| | | |
|--------------------|---------|---------------------------------|
| Part A - Class 3 | UN 1263 | PAINT HFP |
| Part B - Class 5.2 | UN 3105 | ORGANIC PEROXIDE TYPE D, LIQUID |

This data sheet is based on information in BC Coatings possession at date of issue. BC Coatings supplies its products only on condition that the consumer is satisfied as to the performance of the product in meeting his particular requirements.