

TECHNICAL DATA SHEET

PRODUCT

PE340 CLEAR POLYESTER SEALER

DESCRIPTION

PE340 Clear Polyester Sealer is a two part high build sealer for use on very absorbent substrates.

Combined with its excellent sanding properties, it provides a smooth surface for top coating to matt and high gloss finishes.

USED FOR

Furniture, various wood substrates (M.D.F., chipboard) and fibreglass.

PROPERTIES

COLOUR

Clear

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"	94 ± 1%
3. Pot Life at 20 °C	60 - 90 minutes
4. Dust Free at 20 °C	1 hour
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	1.325

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COVERAGE	From 200 to 300 gms/m ² for each coat, depending on type of substrate.		
(THEORETICAL)	2.3 square metres / litre at 300 microns.		
MIXING RATIO	PE340 Part "A"	1 litre	20 litres
	PE230/PE330 Hardener	25 ml.	500 ml.
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

<u>SUBSTRATE</u>	<u>PREPARATION</u>	<u>COATING SEQUENCE</u>	<u>FILM BUILD</u> <u>WET (DRY)</u>
TIMBER M.D.F., PARTICLE BOARD	Sand and remove dust.	1 st Coat: PE340 2-Pack Clear Polyester sealer Finish coat: UT900 2-Pack Topcoat or UT100 Series 2-Pack Topcoat or Other suitable lacquer or 2-pack Topcoats.	300 microns 80 - 100 microns (36 - 45 microns) 100 - 120 microns (40 - 50 microns) T.B.A.
FIBREGLASS	Sand and remove dust.	1 st Coat: PE340 2-Pack Clear Polyester Sealer. 2 nd Coat : 2K Auto Primer Finish coat: UT100 Series 2-Pack Topcoat or other suitable 2-K Topcoat.	



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SURFACE PREPARATION

TIMBER / M.D.F. 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 sealing.

PARTICLE BOARD Remove by blow-off or vacuum all excess dust then apply
PE340 Clear Sealer according to instructions.

FIBREGLASS Surface should be dry, clean and free from large gaps or imperfections.
An initial sand with 180 grit or Fre-cut paper followed by wiping with
PE100 Thinner is recommended to remove moulding agents & etc.

APPLICATION

MIXING See MIXING RATIO on page 2.

THINNING PE340 Clear 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.

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

Provide adequate ventilation during use.

Airflow should be adequate to ensure a comfortable working atmosphere.

When spray painting, users should comply with the provisions of the State Spray Painting Regulations.

Where this is not possible, operators must use an air supplied respirator complying with Australian Standards AS1715 and AS1716.

This product is flammable and all sources of ignition (flame, pilot lights, furnaces, spark producing switches & etc.) must be eliminated in, or near, the application area.

Do **NOT** smoke.

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

Avoid contact with skin and eyes.

Wear protective goggles and gloves when handling the material.

In the case of skin contact, remove contaminated clothing and wash skin thoroughly with clean water.

Seek medical attention if eyes are affected by splashes or fumes.

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 12 months but depends on storage conditions.

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.