AXON PRODUCTS

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WOOD TECHNICAL DATA

PSP-934
UV VERTICAL SPRAY SEALER

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This clear, sprayable, polyester sealer provides excellent build and filling properties. It is characterized by its high thixotropic index, which provides excellent hang for vertical spray applications. It is also provides excellent sandability.

GENERAL RULES:

1. This product should be stored no longer than 6 months from date of manufacture. It should be kept in its original container in a dark, cool, dry place away from a source of heat and at a temperature below 86°F.

2. For best performance the temperature of the product and the room should be 69 - 79°F and the relative humidity 35 - 75%.

3. The substrate needs to be well sanded with 180 - 220 grit paper, and must be free from dust and grease. The moisture content of the substrate should vary from 8 - 12%.

4. An **ISC/ISB** Series insulator must be applied before coating with polyester on woods such as Teak, Rosewood, and other exotic woods with a high content of tannin. It also must be applied after staining.

MIXING INSTRUCTIONS:

The **PSP-934** UV Vertical Spray Sealer does not require the user to add both promoter and catalyst just prior to use, but it is recommended for better through cure. The standard additions are as follows:

A) Promoter: Add 1-2% by volume of **PSC-507** Polyester Promoter. This mixture will be stable approximately 12 hours without a noticeable rise in viscosity.

B) Catalyst: Add 2% or 4% by volume. There are two catalysts offered. Which one to use depends on the spray equipment to be used? They are as follows:

1. Use 2% of **PCC-901** when two-component pumps are available. This catalyst provides minimal dry times and becomes dust free in approximately 20 - 30 minutes. Once catalyzed, however, the usable pot life is approximately 15 minutes (temperature dependant). Therefore it is necessary to use two-component equipment or to spray only an amount that can be consumed in this time frame.

2. Use 4% of **PSC-904** when a pressure pot or cup gun is to be used. This catalyst will be two times the pot life of PCC-901. The dust free time, however, is extended to 1½ hour.

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ATTENTION: DO NOT MIX CONCENTRATED PSC-507 PROMOTER AND PCC-901 CATALYST TOGETHER. THIS MIXTURE CAN RESULT IN A VIOLENT CHEMICAL REACTION!

		5 Gallon Mix	1 Gallon Mix	1-Quart Mix
PSP-934	UV Vertical Spray Sealer	20,000 ml	4,000 ml	1,000 ml
PSC-507	Polyester Promoter Use a 1.0% mix	200 ml	40 ml	8 ml
PCC-901 PSC-904	Polyester Catalyst 2.0% **or** Polyester Catalyst L.P. Always use a 4.0% mix		16 ml	

REDUCTION - VISCOSITY:

Usually a reduction of approximately 5% by volume will provide a satisfactory spray viscosity. If ambient temperature is below 80°F (27°C), reduce with **RED-912** Solvent / Reducer. During very warm summer months when ambient temperatures exceed 80°F, reduce with **RED-937** Solvent / Reducer. We do not recommend spraying polyesters when ambient conditions are over 95°F (35°C) or the relative humidity above 75%, because the dry time and gel time become too fast which can cause "solvent pop" and other surface problems.

SPRAYING:

Most spray equipment can be used*. It is important that the sealer be applied as "wet" as possible without sagging (approximately 6 - 8 mils gives best results). Keep air pressure low, i.e. 30 - 45 psi at the gun. Avoid dry spraying. Unlike lacquers, polyesters do not have enough solvent to completely re-wet dry spray.

If two or more coats are desired, wait approximately 15 minutes or until "tacky" before spraying the second coat. If subsequent coats are desired after the polyester is dry, the part should be well sanded with 320-grit sandpaper to prevent intercoat adhesion problems.

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*** Recommended Spray Equipment:**

Graco 700N	Conventional spray gun 2.5 mm #3 tip and needle, #3 air cap
DeVilbis JGHV530	HVLP spray gun (pressure feed) FF tip and needle, #705 air cap

DRY TIME:

A) With **PCC-901** Polyester Catalyst:

Dust Free	30 - 45 minutes
Print Free	60 - 75 minutes
Dry Hard	3 - 4 hours
Full Cure	5 - 7 days

B) With **PSC-904** Polyester Catalyst L.P.:

Dust Free	80 - 100 minutes
Print Free	1½ - 2 hours
Dry Hard	6 - 8 hours
Full Cure	5 - 7 days

The product may be UV cured at 1600-1800 mJ after a 20- 40-minute flash period, depending on ambient temperature.

Note: Ambient temperature has a significant impact on dry times. For example, subjecting the part to 15 minutes of warm moving air after 15 minutes of flash time at 100°F will reduce the print free time by 50 - 75%. Conversely, it is important to note that the chemical reaction during curing will stop at temperatures below 68°F (20°C) or a relative humidity below 35%. Parts permitted to dry overnight must be subjected to a temperature above 68°F.