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WOOD TECHNICAL DATA

PST-902 **CLEAR POLYESTER TOPCOAT - BUFFABLE**

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This clear, sprayable, polyester topcoat provides maximum gloss and depth. It also has excellent mar and scratch resistance properties. It is characterized by its surface properties, which allow easy buffing. It can be used when the part will be completely buffed and polished or as a direct-gloss

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 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.
5. A **PSP Series** sealer should be used next, if a thick build is desired and then sanded with 280 - 320 grit paper.

MIXING INSTRUCTIONS:

The **PST-902** Clear Polyester Topcoat - Buffable requires the user to add both promoter and catalyst just prior to use. The standard additions are as follows:

- A) Promoter: Add 1% 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 2.0% of **PCC-901 Polyester Catalyst** 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 4.0% of **PSC-904 Polyester Catalyst L.P.** when a pressure pot or cup gun is to be used. This catalyst will have two times the pot life of PCC-9C01. 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!
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		<u>5 Gallon Mix</u>	<u>1 Gallon Mix</u>	<u>1-Quart Mix</u>
PST-902	Clear Polyester Topcoat - Buffable	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:

The PST-902 polyester topcoat is intentionally shipped at a higher than normal spray viscosity. This is done to allow the user to compensate for temperature conditions, sprayer preferences, and varying spray equipment. Shipping viscosity is 18 - 20 seconds on a #2 "Signature" Zahn. We recommend a typical spray viscosity of 16 - 17 seconds on a #2 "Signature" Zahn. 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.

Because we cannot anticipate or control the many different conditions which this information and our products may be used, we do not guarantee the applicability or the accuracy of this information of the suitability or our products in any given situation. Users of our products should make their own tests to determine the suitability of each such product for their particular purposes. The products discussed are sold without such warranty, either express or implied. Also, statements concerning the possible use of our products are not intended as recommendations to use our products in the infringement of any patent. All chemicals may present unknown health hazards and should be used with caution. Although certain hazards are described in this publication, we cannot guarantee that these are the only hazards which exist. Users of any chemical should satisfy themselves by independent investigation of current scientific and medical knowledge that the material can be used safely.

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SPRAYING:

Most spray equipment can be used*. It is important that the topcoat be applied as "wet" as possible without sagging (approximately 4 - 6 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.

Usually, one coat of topcoat is recommended and satisfactory. If two 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.

*** Recommended Spray Equipment:**

Graco 700N	Conventional spray gun 1.8 mm #2N tip and needle, #21 air cap
DeVilbiss JGHV530	HVLP spray gun (pressure feed) FX tip and needle, #705 air cap

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.