

COATING SCHEDULE

COMBI POLYESTER - PU BLACK HIGH GLOSS



Substrate	HMR board
Product Item	Furniture
Positioning	Interior
Finishing System	Combi Polyester-PU System
Gloss Level	High Gloss

Finishing Condition Recommended	
MC wood	8 - 12 %
Room humidity	Max 70 %
Room temp.	28 - 32° C

No	Application Step & Product Name	Mixing Ratio	Application Viscosity	CA [gr/m2]	Application Method	Drying Time Recommended
	SUBSTRATE SANDING				Sand Paper Grade # 180 – 240	
1	SEALER PUS-51107 PUH-21 LY FD THPU-71 FD	100 100 50	11-12 sec NK-2	70-80	Manual Spray	2 hours
	Sanding				Sand Paper Grade # 240	
2	BASE COAT 1 PEP-82100 HF BLACK PEA-83100 PEK-83202 THINNER POLYESTER	100 4 4 10	20-25 sec NK-2	400	Manual Spray	4 hours
	Sanding				Sand Paper Grade # 240	
3	BASE COAT 2 PEP-82100 HF BLACK PEA-83100 PEK-83202 THINNER POLYESTER	100 4 4 10	20-25 sec NK-2	400	Manual Spray	4 hours
	Sanding				Sand Paper Grade # 400	
4	TOP COAT 1 PUC-931 AC BLACK 90 PUH-21 LY FD THINNER POLYURETHANE	100 100 50	9-10 sec NK-2	100-120	Manual Spray	24 hours
	Sanding				Sand Paper Grade # 800	
5	TOP COAT 2 PUC-931 AC BLACK 90 PUH-21 LY FD THINNER POLYURETHANE	100 100 50	9-10 sec NK-2	100-120	Manual Spray	72 hours
5	BUFFING PROCESS					

Main Features:

High Build

Good scratch resistance

Easy for Buffing Process

Surface Specification	Method	Result	Notes
Adhesion Test	ASTM D3359	Point 5B	Perfect
Blocking Resistance 2 psi	ASTM D2793-93A	Pass	Non Visible Mark
Hot and Cold Check	ASTM D1211	Pass	10 cycles