

COATING SCHEDULE

POLYESTER CLEAR HIGH GLOSS



Substrate	Solid Wood or Veneer
Product Item	Furniture
Positioning	Interior
Finishing System	Polyester 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	POLYESTER 1 PEL-81200 NF 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	POLYESTER 2 PEL-81200 NF 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,#400	
4	POLYESTER 3 PEL-81200 NF PEA-83100 PEK-83202 THINNER POLYESTER	100 4 4 10	20-25 sec NK-2	300	Manual Spray	24 hours
5	BUFFING PROCESS					

Main Features:

High Build

Good scratch resistance

Good surface hardness

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