

Methodology	Weight g/m <sup>2</sup>	Mix (Volumetric)	Thinner	Drying (20°C)
1. Board prep, sanding 180/240 grit				
2. 1 x DG 4750	120 - 160	1:5 DR 4034	50% DV 4935	30min Intermediate Drying
3. 1 x DG 4750	120 - 160	1:5 DR 4034	50% DV 4935	30min Intermediate Drying
4. 1 x DG 4750	120 - 160	1:5 DR 4034	50% DV 4935	16hr
5. Sand 320/400 grit				
6. 1 x DG 4750	150 - 200	1:5 DR 4034	20 - 25% DV 4935	30min Intermediate Drying
7. 1 x DG 4750	150 - 200	1:5 DR 4034	20 - 25% DV 4935	30min Intermediate Drying
8. 1 x DG 4750	150 - 200	1:5 DR 4034	20 - 25% DV 4935	16hr
9. Sand 320/400 grit				
10. Repeat steps 6 through 8 (This can be repeated up to 3 times)				2d
11. Sand 600 - 800 grit in preparation for top coat				
12. 1 x DU 45229	100 - 150	2:1 DR 4005	15 - 20% DV 4935	30min Intermediate Drying
13. 1 x DU 45229	100 - 150	2:1 DR 4005	15 - 20% DV 4935	Polishable after 48hrs

**Processing Tips**

- **Pre-Coating:** Make sure the substrate is clean and free from contaminants such as grease, oil and glue.
- **Sanding:** Intermediate sanding should reflect the needs of the surface. If the surface is flat and free of inclusions only a light sand is required to provide a key for subsequent coats.
- **Post Sanding:** dust removal is best achieved using compressed air in combination with a lint free cloth. Tak Rags may be used, but are not encouraged due to their nature of leaving residue on the surface when used heavy handedly.

**General Information**

- **Temperature and Humidity:** PU lacquers should not be used and dried at product and room temperatures below 18 °C and below 40 % RH, ideal values: 20 -25 °C, 50 - 65 % RH. Deviations lead to problems with drying or, as may apply, hardening.
- **Adhesion:** In order to avoid adhesion problems, please sand the PU lacquered surfaces before applying fresh lacquer and apply lacquer to the sanded surfaces as soon as possible. If left sitting for a significant amount of time the surface will begin to oxidize and harden beyond the level required for proper adhesion.
- **Mix Flexibility:** Mixed residues may be refreshed at the limit of the products pot life to extend use. A mix that has passed significantly beyond this point must only be used as a 10 - 20 % aggregate in a fresh lacquer/hardener mixture. Old lacquer/hardener mixtures impair the surface quality (adhesion/stability).
- **Final Hardening:** If stored correctly at room temperature complete hardening of the coating is achieved after seven days. Please apply a test coat under real conditions!

Methodology	Weight g/m <sup>2</sup>	Mix (Volumetric)	Thinner	Drying (20°C)
1. Board prep, sanding 180/240 grit				
2. Apply DG 4720-0001	120 - 160	2:1 DR 4040	10% DV 4935	30min Intermediate Drying
3. Apply DG 4720-0001	120 - 160	2:1 DR 4040	10% DV 4935	2hr
4. Sand 320/400 grit (light sanding)				
5. Apply DG 4750	150 - 200	1:5 DR 4034	25 - 35% DV 4935	30min Intermediate Drying
6. Apply DG 4750	150 - 200	1:5 DR 4034	25 - 35% DV 4935	30min Intermediate Drying
7. Apply DG 4750	150 - 200	1:5 DR 4034	25 - 35% DV 4935	16hr
8. Sand 320/400 grit				
9. Repeat steps 5 through 7 (This can be repeated up to 4 times)				2d
10. Sand 600 - 800 grit in preparation for top coat				
11. Apply DU 45229	100 - 150	2:1 DR 4005	15 - 20% DV 4935	30min Intermediate Drying
12. Apply DU 45229	100 - 150	2:1 DR 4005	15 - 20% DV 4935	Polishable after 48hrs

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