



5% Gloss Closed Pore

Methodology	Weight g/л (Micron μ)	Mix (Volumetric)	Thinner	Drying (20°C)
1. Sand board in preparation for first coat 180 - 240 grit				
2. Apply DG 4717-0001	130 - 180 (135 - 185μ)	5:1 DR 4070 (+4% ZD 9501)	15 - 25% DV 4994	30min Intermediate Drying
3. Apply DG 4717-0001	130 - 180 (135 - 185μ)	5:1 DR 4070 (+4% ZD 9501)	15 - 25% DV 4994	30min Intermediate Drying
4. Apply DG 4717-0001	130 - 180 (135 - 185μ)	5:1 DR 4070 (+4% ZD 9501)	15 - 25% DV 4994	16h
5. Intermediate sanding 320 grit				
6. Repeat steps 2 through 4				16h
7. Intermediate sanding 400 grit				
8. If further filling is required repeat steps 2 through 4				16h
9. Intermediate sanding 400 grit				
10. Apply one coat of DE 42591	100 - 150 (110 - 160μ)	10:1 DR 4070 (+ 4% ZD 9501)	10 - 15% DV 4994	Packable after 16h

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 (3 days) 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!