



product information | **LUTHIERTHANE**
6759-CLE20902
 ACRYLIC URETHANE SEALER FILLER
 BASECOAT FINE MUSICAL INSTRUMENTS

Cardinal's Cardinal's 6759-CLE20902 is a two component acrylic polyurethane designed not only seal the substrate, but offer filling properties to reduce the need to pore use pore filler. This product is characterized by quick dry, sealing, filling of pores and adhesion to various wood substrates.

TYPICAL USES:

- Fine musical instruments

BENEFITS:

- Adhesion
- Sealing
- Filling
- Fast dry

CURED FILM PROPERTIES:

Testing was conducted on a variety of different wood types which had been sealer with 6759-CLE20902 and then top coated with 6779-CLE19661. The coating was air dried for seven days before testing.

TEST	METHOD	PARAMETERS	RESULT
Adhesion	ASTM D3359	Cross-hatch tape	0% failure
Cold Checking	NA	10 cycles from 25°C to -5°C with 8 hr. intervals	No effect

APPLICATION:

SPRAY

1. Sand the wood to desired finish using 180-320 grit sandpaper.
2. Blow any dust or debris from surface.
3. Clean all grease, oil, and contaminants with acetone or naphtha like solvent.
4. Mix the coatings according to the mixing instructions.
5. Apply finish with a fine finish spray gun setup using the necessary amount of atomizing air pressure to form a fine spray.
6. Recommended spray gun settings would be 6" fan approximately 9"-12" from the substrate.
7. Apply the finish with an overlapping spray technique. Avoid getting the gun too close to substrate to prevent air entrapment (bubbles)
8. Apply approximately 1.0-2.0 dry mils (5-10 wet mils) each coat.
9. Apply two coat at the specified thickness to achieve maximum filling and sealing.
10. Ensure a wet coat to achieve desired adhesion.

Sanding, Filling and Recoating

1. Sand the finish with a 320 or higher grit size after 120 minutes.
2. When filling with 4760 pore filler reapply a sealer before topcoat.
3. Finish can be top coated after sanding.

Note:

These recommendations are only a suggestion and do not imply that other products and techniques currently being used won't work. All procedures and materials used must be tested and approved by the applicator.

Woods Tested:

Mahogany, Rosewood, Spruce, Maple and Koa.

TYPE: Acrylic Urethane Sealer Filler Basecoat

COMPONENTS: Two.

COLORS: Clear

GLOSS: SEMI GLOSS

MIX RATIO: 5 parts 6759-CLE20902 to 1 part 67HP-CLE20902

COVERAGE: At 1.0 mil DFT, 65% transfer efficiency(TE) is 250 ft²/gal.

Calculation: 1604 ft²/gal x % volume solids x TE = DFT

VOC MIXED: 670 grams/liter = 5.6 lbs/gal minimum.

SOLIDS:

Weight 30%
 Volume 24%

FLASH POINT: 24°F TCC

SHELF LIFE: 1 year from date of manufacture in factory sealed container.

VISCOSITY: 25 seconds in Zahn 3

SPRAY-able Pot Life: 3 hours

RECOMMENDED DFT: 2.0 – 4.0 mils
 (depending on required finish)

CURE: Air Dry

Tack free 15 min.
 Time to handle 30 min.
 Time to sand 2 hours.
 Time to recoat 2 hours.
 (At 1.0 mils dry film thickness, 78° F, 50% RH)

**This coating must be used
 only in a well ventilated area!**

**Keep this coating away from
 any and all sources of
 ignition!**

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NO WARRANTY EXPRESSED OR IMPLIED, ACCEPTABILITY TO BE DETERMINED BY USER. SPECIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE

SURFACE PREPARATION AND SEALING: The most important steps in a successful coating process are cleaning and sealing. The wood surface should be free of any dust or dirt before application of sealer. If a pore filler is being used the wood should be sealed before and after being filled.

Cleaning the substrate: The surface of wood should be cleaned with either acetone or Mineral spirits to remove any oils, grease or other contaminants. The surface must be thoroughly dry before painting. Air quality regulations have limited the allowable emissions from cleaning operations.

Plastic — Any vinyl or other plastic products that might be coated over with this finish should have the adhesion verified before use.

TOPCOAT SELECTION:

PRODUCT NO.	DESCRIPTION	FUNCTION
6779-CLE19661	Acrylic Urethane	Gloss clear for final instrument finish
6S00 SERIES	Acrylic Urethanes	Color coats

RELATED PRODUCTS:

PRODUCT NO.	DESCRIPTION
4760- Filler	Pore filler. Available in a variety of different wood tone colors
1600-02	Medium Urethane reducer
1600-03	Slow Urethane reducer

TROUBLE SHOOTING:

PROBLEM	CAUSE	REMEDY
Blisters, pin holes or solvent pop	Water contamination. Entrapped air. Entrapped solvent	Eliminate water – Check airlines. Increase atomization, decrease film build. Pull gun further away from substrate
Craters	Contaminated ambient air, e.g., silicone mist, dust.	Locate and eliminate source of contamination.
Fish-eyes	Substrate contamination.	Clean and prepare substrate.
Blushing	Humid conditions.	Use Cardinal's 1200-11 lacquer thinner or add anti blushing additive.
Poor adhesion	Improper surface preparation.	See surface preparation section.
Gloss variation	Variation in application, cure schedule and humidity.	Consistent gloss depends upon consistent process.

APPLICATION EQUIPMENT: Most air quality regulations require the paint application transfer efficiency to be 65% or better. This generally means using electrostatic or high volume low pressure (HVLP) spray guns. Otherwise, conventional pressure feed, airless or air assisted airless spray equipment can be used. Air supply lines need water and oil traps.

EQUIPMENT CLEAN-UP: Clean up should be done as soon as possible keeping in mind the pot life of the mixed paint. Air quality regulations have limited the allowable emissions from cleaning operations.

PRODUCT LIMITATIONS:

- This 6756-CLE20902 was design for fine musical instrument and the normal environmental condition that they would be exposed. All precautions should be taken to avoid extreme conditions such as: excessive heat, extended cold temperatures, chemicals which would damage coating or excessive abrading with guitars strap and other abrasive objects.

SAFETY: Refer to the product's Material Safety Data Sheet (MSDS) for complete safety information. Contains organic solvents. Use with adequate ventilation. Do not breathe vapors or spray mists. If component TLVs are exceeded, a NIOSH approved air supplied respirator is advised. See MSDS for TLV information.

Contents are FLAMMABLE. Keep from heat, sparks or open flame.

Allergic reactions are possible. Avoid use by persons with respiratory problems.

Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

FIRST AID:

Eye contact: flush immediately with plenty of water for at least 15 min. and get medical attention.

Skin contact: wash thoroughly with soap and water for 5 minutes.

If swallowed, do not induce vomiting and get medical attention immediately.

PRODUCT IDENTIFICATION

6759 - CLE20902 (example)

Color number
Gloss: 90°+ = high gloss
Special: e.g., 8 = sealer
Product type

D12TL

IMPORTANT: Warranty and Disclaimer — The performance characteristics of these products vary according to product application, operating conditions, materials applied to or with and use. Since these factors can affect results, we strongly recommend that you make your own test to determine to your satisfaction whether the product is of acceptable quality, has not been affected by storage or transport and is suitable for your particular purpose under your own operation conditions prior to using any product in full scale production. Seller warrants the products to be free from defects in materials and workmanship. SUCH WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OF FITNESS FOR A PARTICULAR PURPOSE. No representative of ours has authority to waive or change this provision, which applies to all sales of these products.

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