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 sealed with 6759-CLE20902 and then top coated with 6779-CLE19661. The coating was air dried for seven days before testing.

<table>
<thead>
<tr>
<th>Test</th>
<th>Method</th>
<th>Parameters</th>
</tr>
</thead>
<tbody>
<tr>
<td>Adhesion</td>
<td>ASTM D3359</td>
<td>Cross-hatch tape  0% failure</td>
</tr>
<tr>
<td>Cold Checking</td>
<td>NA</td>
<td>10 cycles from 25°C to -5°C with 8 hr. intervals</td>
</tr>
</tbody>
</table>

**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 to close to substrate to prevent 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
- 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

**Sprayable 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, 72°F, 50% RH)

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

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

(Continued on page 2)
SURFACE PREPARATION AND SEALING: The most important steps in a successful coating process are cleaning and sealing. The woods 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:

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>DESCRIPTION</th>
<th>FUNCTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>6779-CLE19661</td>
<td>Acrylic Urethane</td>
<td>Gloss clear for final instrument finish</td>
</tr>
<tr>
<td>6500 SERIES</td>
<td>Acrylic Urethanes</td>
<td>Color coats</td>
</tr>
</tbody>
</table>

RELATED PRODUCTS:

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>4760-</td>
<td>Pore filler. Available in a variety of different wood tone colors</td>
</tr>
<tr>
<td>Filler</td>
<td></td>
</tr>
<tr>
<td>1600-02</td>
<td>Medium Urethane reducer</td>
</tr>
<tr>
<td>1600-03</td>
<td>Slow Urethane reducer</td>
</tr>
</tbody>
</table>

TROUBLE SHOOTING:

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

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 designed for fine musical instrument and the normal environmental condition that it would be exposed. All precautions should be taken to avoid extreme conditions such as: excessive heart, 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 min. If swallowed, do not induce vomiting and get medical attention immediately.