



Poly-Tone II™ MI02 Series Polyester Hi-Gloss Coating

Clear	MI02-CSD01	White	MI02-WSD03
Black	MI02-BSD02	Sealer	MI02-CSD04
Catalyst	CT02-CSD05		

PRODUCT DESCRIPTION

Poly Tone II Polyester Coating is a two component Musical Instrument Sealer and Topcoat providing high gloss, excellent durability and resistance properties.

FEATURES

Gloss:	Full	Drying (77°F, 50% RH)	
Viscosity: Brookfield Viscometer Model RVF, Spindle #2 at 20 rpm	450 cps (Clear) 500-700 cps (Pigmented)	To Touch:	10-15 Minutes
Gel time:	15-17 min. (Clear) 18-20 min. (Pigmented)	To Handle:	15-30 Minutes
Time to Peak Exotherm:	20-25 min.	Initial Scuff Sand:	1 Hour
Peak Exotherm:	260°F, 128°C	Trapped solvents to escape:	Overnight
Weight Per Gallon:	8.40 lb. (Clear) 8.5 – 10.5 lb. (Pigmented)	Recoat::	Overnight
Recommended Film Thickness:	Mils Wet (multiple wet coats totaling) 10-15 mils (270-375 microns)		
Spreading Rate:	110-115 sq ft/gal @ 10 mil thickness 10.2 – 10.7 m2 @ 250 micron thickness		
		Mixing Ratio, Sealer:	
		2% with mekP	Catalyst: CT02-CSD05
Flash Point:	20°F		
Package Life:	6 months, Unopened	Pot Life:	15-18 min.
Air Quality Data:	Photo-chemically reactive.		
Material VOC: 150 g/L	Volatile Organic Compounds (VOC) catalyzed: 150 g/l.		
Coatings VOC: 150 g/L	An Air Quality Data Sheet is available from your local	Tewksbury Technical Coatings	facility.

BENEFITS

- Excellent for Musical Instrument finishing.
- Excellent stability – clarity (Clear), color and light stability.
- Easy to apply – builds quickly.
- Superior Finish – hard chemical resistant finish.
- High Gloss – Sand and polishes to a non-wax, tack free high gloss finish.
- VOC compliant at 150 g/l.
- Available in Custom Colors (volume colors)
- Excellent moisture resistance
- Excellent cold check resistance
- Free of lead and chromate hazards
- Versatile – may be applied by Plural Component / Conventional Systems, Air Aspirated, Airless, Air-Assisted Airless.

FINISHING SYSTEM

General: Substrate should be free of grease, oil, dirt, fingerprints, wax and other contaminants. Ambient temperatures should be in excess of 60°F, 16°C to ensure rapid and complete cure. Time calculations are based on temperatures of 77°F, 25°C. Consult TTC Wood Preparation Brochure for additional details.

Surface and Product Preparation: If surface has been primed and / or color coated, it must be sanded to a 180-grit finish to ensure proper mechanical adhesion. Wipe with a clean cloth. **Do not use a tack rag.** Thoroughly stir Poly-Tone II Polyester in a can prior to catalyzing. Due to rapid gel time, mix only the amount that can be applied within 15-17 minutes. (Higher temperatures yield a shorter pot life and gel time, while lower temperatures yield a longer pot life and gel time.) Catalyze at 2 percent with full strength mekP catalyst (20 cc per quart.) Thin 5-15 percent if necessary to a desired spray viscosity with TTC Thinner or mek solvent after catalyzation.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.

APPLICATION PROCEDURES:

Note: Spray pressures should be 35-50psi. If a pressure pot is used, provide 10-15psi pot pressure.

Spray the topcoat with a mist coat and allow to set for 2-5 minutes. Follow with multiple wet coats up to a total thickness of 10-15 mils, 250-375 microns. After curing, dry sand with 400-grit sandpaper, then allow to cure overnight prior to further sanding, compounding and polishing.

For best results sand to 1000 to 1200- grit finish prior to compounding and polishing. Compound with "TTC Poly-Tone II Fast-Cut Buff MI02-CWD06" and polish with "TTC Poly-Tone II MI02-CWD07" Compound / Polish.

Plural Component Systems

General Information:

- For optimum performance modify the pump by changing to an 11:1 pump ratio (vs. 20:1) or lower and lowering line pressure.
- High-Volume / Low Pressure (HVLP) spray guns normally spray Poly-Tone II products with more orange peel than non-HVLP spray guns.

Orifice Recommendations for Plural Component Systems

Use .015 to .018 orifices when spraying Poly-Tone II Hi-Gloss Polyester Coating.

Note: Contact your TTC Market Manager for recommendations on Orifice Size, Fluid Nozzle, Air Cap, Needle, and Pressure Requirements as set up specifications are dependent on Gun Model and Application System.

PRODUCT LIMITATIONS

- Short pot life / rapid gel time.
- Shorter pot life at higher temperatures.

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Tewksbury Technical Coatings facility. Please direct any questions or comments to your local Tewksbury Technical Coatings facility or call 1-888-TEWKSBURY.

LABEL CAUTIONS

Contents are **FLAMMABLE**. Vapors may cause flash fires. Keep away from heat, sparks, and open flame. During use and until all vapors are gone: Keep area ventilated – Do not smoke – Extinguish all flames, pilot lights, and heaters – Turn off stoves, electric tools and appliances, and any other sources of ignition. SEE CONTENTS STATEMENT ON LABEL. **VAPOR HARMFUL**. Avoid breathing vapor and spray mist. Use only with adequate ventilation. Before initial use, consult OSHA's Standard for Occupational Exposure. A properly fitted full face respirator effective for particulates, organic solvent or an air supplied respirator must be worn, unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage.

FIRST AID: If **INHALED:** If affected, removed from exposure. Restore breathing. Keep warm and quiet. If on **SKIN:** wash affected area thoroughly with soap and water. Remove contaminated clothing. If in **EYES:** Flush eyes with large amounts of water for 15 minutes. Get medical attention. If **SWALLOWED:** Get medical attention immediately.

SPILL AND WASTE: Remove all sources of ignition. Ventilate and remove with inert absorbent. Incinerate in approved facility. Do not incinerate closed container. Dispose of in accordance with Federal, State, and Local regulation regarding pollution.

DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE. Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

Warning: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN. FOR INDUSTRIAL USE ONLY. SEE MATERIAL SAFETY DATA SHEET.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application, which are not known, or under our control, Tewksbury Technical Coatings cannot make any warranties as to the end result.