TECHNICAL DATA SHEET

FP 800

POLYESTER SEALER

DESCRIPTION

FP 800 is three-component high performance polyester sealer for interior wood finishing. This sealer has great vertical hang and excellent sanding characteristics. When topcoated with LORCHEM polyurethane or polyester topcoat, this durable finishing system exceeds KCMA test requirements. Providing a finishing system that has excellent chemical and moisture resistance with optimal built and scratch resistance.

Formaldehyde free

PRODUCT DATA

Color	Clear	**VOC less exempts**	445.62 g/L	3.72 lb/gal
Solids % by Vol	44% ± 2%	**VOC actual**	453.50 g/L	3.78 lb/gal
Solids %by Wt	62% ± 2%	**Photochemical reactive**	No	
Density	1.08	**Flash Point (PM/CC)**	N/A	
Viscosity 23°C/73°F #4 Ford	N/A	**Shelf life**	6 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	Flat	**Theo-coverage @1 mil dry**	710-715 Sq.Ft/gal	17-18 m^2/L

PREPARATION/APPLICATION

Working Temp
>18°C/65°F surface, coating and air

Catalyzation
- **Hot potting:** 100:2:2 (100 parts FP 800 : 2 part Catalyst: 2 part accelerator)
- **Plural component equipment:** Side I (100 part FP800 : 4 part accelerator). Side II (100 part FP800 :4 part catalyst)

Pot life
Hot potting: 25 minutes. (23°C/74°F)
Plural component equipment: Side I 5 days (23°C/74°F) , Side II 36 hours (23°C/74°F).

Reducer
Reduce 10-15% by volume with DEDE 900 Thinner.

Film thickness
Min 4 mil wet –Max 5 mil wet.

Suggested Topcoat
OK 75, OK865, PDL 900

Application
- Apply 1 coat of catalyzed sealer at 4.0 - 5.0 mils wet. Allow to dry for sanding. A second coat of sealer may be applied after sanding if needed for additional filling. Sand again before topcoating.
- Sand with 320-grit paper and remove all sanding dust. If a wet look is desired, sand final primer coat with 500-600 grit paper. Topcoat within 8 hours of sanding
- Topcoat with recommended topcoat
- Do not exceed 7.0 mils DFT for the total system.

Surface Preparation
Wood surface must be clean, dry, free of grease and oil and finish sanded with 180 grit sandpaper to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.

Use Directions
Hot potting: Always mix FP800 with the accelerator A 800 at 2% first. Mix well. Then add catalyst portion C 800 at 2% to the mix and mix well. Working pot-life or gel time is 30-50 minutes.
Plural component equipment*:* When using 1:1 plural component spray equipment, split the FP 800 quantity into equal parts. Mix one side with accelerator at 4%. The shelf-life of this side of the mix is 5 days @ 77°F. Mix the other side with the catalyst at 4%. The shelf-life on this side of the mix is 36 hours @ 77°F
Mixing: WARNING: Do not allow the cobalt accelerator products A 800 to come in direct contact with the catalyst C 800 .This causes a violent chemical reaction which can constitute a hazard for the operator.

App equip.
HVLP Siphon Feed

Tinting
Can be tinted up to 5% maximum with universal colorants 850.

Cleanup
Clean tools/equipment immediately after use with T750 LORCHEM cleaner gun or a quality lacquer thinner or acetone. Always follow manufacturer's safety recommendations when using any solvent.

Standards
This product meets KCMA and CKCA test requirements when used under recommended LORCHEM Topcoat.

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DRYING TIMES

Method	Drying temperature.	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	**Dust free time**	5-8 minutes	**Dry to sand**	6-8 hours
		Dry to touch	15-25 minutes	**Dry to recoat**	6-8 hours
		Dry to Handle	6 hours	**Dry to stack**	Overnight
Force dry	45to 60°C/110-140°F	Minutes			

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Minimum curing temperatures of 23°C/74°F must be maintained throughout curing cycle to achieve the film integrity as stated in product features.

APPLICATION RECOMMENDATIONS

APPLICATION EQUIPMENT SETTINGS

Method of Application	Air Pressure (PSI)	Fluid Pressure (PSI)	TIP size (mm / inch)	Application Viscosity (#FORD 4)	Thickness Film (Mils)
HVPL	45-55	25-35	1.2-1,8/0,047-0,055	18-21	3-5

Note: All measurements and application equipment settings are based on application at a temperature of 23°C/74°F. Viscosity will vary depending on the temperature of the liquid. The above-mentioned application equipment recommendations are guidelines only. The noted settings are starting point recommendations and that adjustment to the settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

SPECIFICATIONS

- For interior use only.
- Accelerators for polyester like A 800 are heavy metal salts and could give place to spontaneous combustion. For this reason, they have to be handled with care and they should not to be mixed directly with peroxides (like A 800) in order to avoid strong exothermic and explosive reaction. Accelerator must be mixed immediately after added to polyester to avoid backlogs of accelerator. It is important to clean mixing tools and clean after work for the same reasons
- Over catalyzing or using incorrect catalyst may result in blooming, cracking and poor adhesion.
- This product should be thoroughly sanded within 4 hours of being applied. If the sealer is not topcoated the same day, it should be resanded immediately before topcoating to insure optimum intercoat adhesion.
- Can be used under recommended LORCHEM Topcoat. Please contact your LORCHEM representative for system recommendations.
- Total film thickness of systems must not exceed 7.0 mils dry film because heavier films may show cracking and checking tendencies.
- To achieve maximum performance properties, a minimum of 3 mils DFT for the total system is required.

CAUTIONS

TESTING

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

THESE PRODUCT ARE DESIGNED FOR INDUSTRIAL SHOP APPLICATION AND PROFESSIONAL USE ONLY

Thoroughly review Safety Data Sheet (SDS) for safety information and cautions prior to using this product. Please direct any questions or comments to your local representative.

PDS

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. 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 ,preparation and application which are not known or under our control, LORCHEM cannot make any warranties related to the product or the performance of the product. Moreover, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is not caused by the quality of the product.

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