

**PL4331**  
Clear Polyester Basecoat

**DESCRIPTION & USES** Extremely versatile **clear** polyester basecoat built to out perform its rivals with option for extra long pot life and very high build. This polyester product exhibits excellent transparency, good elasticity, absence of shrinking and excellent sandability.

**Recommended Application:**

For use as a **basecoat** under clear polyurethane topcoats (**suggest isolator be applied before**) Flat and profiled components, furniture, joinery, shop-fitting, kitchen doors.

**WET PROPERTIES**

**Solid content:** 92% (approx)  
**Viscosity in drum:** 20 seconds DIN 8 @ 20°C (approx)  
**Specific gravity:** 1.066 kg/L (approx)  
**Shelf life:** 12 months in sealed containers

**APPLICATION**

**Method:** Spraying conventional, airless  
**Mixing Ratio:** Step 1) Open can of PL4331 and stir thoroughly  
 Step 2) Mix in Accelerator as per ratio below and stir thoroughly

**Warning:** Direct contact between Accelerator & Catalyst can cause a hazardous chemical reaction/explosion – always store separately (refer MSDS) & mix as described here.

Step 3) Mix in Catalyst as per ratio below and stir thoroughly  
 Step 4) Mix in Thinner

Product	Accelerator	Thinner	Catalyst		
			Choose Fast, Medium or Slow		
<b>PL4331</b>	PZ0353 or	Acetone or	<b>Fast</b>	<b>Medium</b>	<b>Slow</b>
Part A	PZ4330 (low greening)	THIN-PE-SLOW	PV3000	PV2280	PV2240
100 Parts	6 Parts	10-20 parts	2 parts	6 parts	6 parts

**Coats:** Up to 4 coats of mixed PL4331 may be applied, waiting 45 mins to 3 hrs between each coat.

<b>Drying time (250g/m2):</b>	Dust free:	30 mins at 20°C
	Touch dry:	3 hours at 20°C
	Sanding:	24 hours at 20°C (minimum)
	Overcoating:	24 hours at 20°C (minimum)
	Stacking:	16 hours at 20°C (minimum)

**Pot Life:** Approx 40 mins to 1 hour at 20°C (approx) depending on mixing ratio

**Application weight:** 100-250 g/m2 per coat

**Procedure:** see over page

**FOR INDUSTRIAL USE ONLY** Data shown are mean values and cannot be construed as product specifications. Users are advised to make their own tests to determine the suitability of products for their own purposes.

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# PL4331

## Clear Polyester Basecoat

**Procedure:**

1) Apply 80-100g/m<sup>2</sup> of **TL4570 Isolator** (mixed - refer TDS) to sanded substrate.

Allow to dry 1-2hrs at 20°C.

*No sanding required if apply polyester PL4331 within 4hrs of applying isolator TL4570. If longer - must lightly sand with 320/400grit first. If sand through must re-apply isolator.*

2) Apply up to 4 coats of mixed PL4331 (refer to TDS for mixing and other drying times), waiting 45 mins to 3 hrs between each coat.

3) Allow to dry 24 hrs at 20°C before sanding and top-coating with polyurethane (i.e. TM4060).

**NOTES**

Ensure adequate sanding (not polishing) and cleaning of the coated substrate is carried out before overcoating.

**PL4331 must be overcoated within 24hours to ensure adhesion.**

Low greening is obtained with PZ4330 Accelerator (same ratios)

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