



## ORCA AIR DRY HIGH GLOSS ADDITIVE AND CLEAR COAT

### PRODUCT APPLICATIONS-

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- EXOTIC WOOD COATING
- GEL COAT ADDITIVE FOR AIR CURE APPLICATION
- MUSICAL INSTRUMENT WOOD COATING
- TOP COAT OVER CLEAR PRIMERS
- TOP COAT OVER PIGMENTED COLORS FOR CLEAR DEPTH
- AUTOMOTIVE INTERIOR COMPOSITE PARTS CLEAR COATING
- ARCHITECTURAL WOOD CRAFTS

### -PRODUCT FEATURES-

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- SUPER CLEAR—GLASS LIKE APPEARANCE
- SCRATCH RESISTANT
- BUFFS TO A SUPER HI-GLOSS FINISH
- REFINISHES TO ORIGINAL HI-GLOSS
- PRACTICALLY A WALK-A-WAY GLOSS FINISH

### -SURFACE PREPARATION-

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- PREPARE SURFACE BY SANDING WITH 220g PAPER (ALWAYS NON-STEARATED)
- CLEAN SURFACE WITH IPA (ACETONE IS NOT SUITABLE)

### -PRODUCT APPLICATION SUGGESTIONS-

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- CATALYZE AT 2% W / MEKP INITIATOR (.5-OZ PER QUART)
- UTILIZATION OF HVLP SPRAY GUN OPTIMIZES FINISH
- AIR PRESSURE 25-40 PSI
- MAINTAIN 12-18" DISTANCE BETWEEN GUN AND SURFACE
- OPTIMUM TEMPERATURE OF 77°F
- START WITH FLASH COAT (2mils) WAIT 2 MINUTES THEN START  
BUILD COATS OF (4mils) PER PASS WAITING APPROX. 5 MINUTES

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BETWEEN COATS. DURING COOLER TEMPERATURES WAIT 20 MINUTES BETWEEN COATS. IF YOU EXCEED 90 MINUTES, YOU MUST LET CURE, SAND, AND THEN RESUME BUILD COATS.

- OPTIMUM BUILD OF 16 MILS
- ALLOW FULL CURE (24 HOURS) PRIOR TO SANDING AND POLISHING

**GEL TIME:**

16-20 min

**VISCOSITY:**

400 cps

**CURE TIME:**

2 HOURS

**COVERAGE (16-MILS):**

100 sf / gallon

**VOC:**

250gr / liter

**THIX INDEX:**

2.0

**WEIGHT PER GALLON:**

8.7 lbs.

**FLASH POINT:**

98° F

**VOCs:**

1.02 lbs. / gal.

**MONOMER CONTENT:**

25%

**SHELF LIFE:**

6 months @ 68° F

**DUST FREE TIME:**

60 min @ 77° F

## Handling & Storage

As with all polyester resin, rate and degree of cure are a function of initiator concentration and of temperature. Resin and work area should be between 70°F and 95°F to ensure satisfactory results. Initiator levels should be within a range of 1.0-3.0% based on weight of resin. The use of initiator levels outside of this range may result in an inadequate cure, with laminates exhibiting moderate to severe post cure after de-molding.

Orca V/E Primer is available in 55-Gallon metal drums.

To ensure maximum stability and maintain optimum resin properties, resins should be stored in closed containers at temperatures below 75°F and away from heat sources and sunlight. All storage areas and containers should conform to local fire and building codes. Drum stock should be stored away from all sources of flame or combustion. Inventory levels should be kept to a reasonable min with first-in, first-out stock rotation.

### Safety

#### **Read and understand the Material Safety Data Sheet before working with this product**

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