

TECHNICAL DATA

PRODUCT CODE/NAME	LPA 127 – HIPOFOND
DESCRIPTION	CLEAR POLYESTER SEALER
ACCELERATOR	LKO005, LKO009 or LKO 007 at 2%
CATALYST	LKO 004 at 2% or approved equivalent
THINNER(S)	LZD 009 (pure acetone) or LZD 446 for dilution ratio, see <i>PREPARATION OF THE PRODUCT</i>

MAIN FIELD OF USE:

Furniture and fittings, tables, doors, coffins and various object. In general, for substrates that need to be prepared with high covering, full fill finishes, and fast drying basecoat and for painting cycles that require a brilliant varnish application, particularly for wet look, glossy finishes.

PROPERTIES:

Very good transparency and flowing; Excellent filling power, verticality and good sandability.

CHEMICAL-PHYSICAL PROPERTIES:

Specific Weight (at 20°C/68°F)	8,768 lb/USgal ± 0.100	VOCs (%)	38.2 ÷ 40.2
Specific Weight (at 20°C/68°F)	1050 g/l ± 10	VOCs (lb./USgal)	3.47 ÷ 3.64
Viscosity DIN Ø 4 (at 20°C/68°F)	110” ± 5”	VOCs (g / l)	416 ÷ 436
Solid Content % by Volume	55.57%	Not considering curable the reactive monomer	
(Average theoretical value according with ISO 3233-3:2015)			
Solid Content % by Weight	61% ÷ 63%	Not considering curable the reactive monomer	
Solid Content % by Weight	92% ÷ 94%	Considering 100% curable the reactive monomer	

PREPARATION OF THE PRODUCT:

	by volume		by weight	
LPA 127	100 parts		100 parts	
Accelerator LKO 007	2 parts	Stirr	2 parts	Stirr
Thinner LZD 009	10-30 parts	Stirr	10-30 parts	Stirr
Catalyst LKO 004	2 parts	Stirr	2 parts	Stirr

Once prepared with accelerator, catalyst and 10-20% of LZD 009, the product has around 30 min. of pot-life at 20°C/68°F. It must be used within this time.

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APPLICATION:	AIRMIX SPRAY	AIRLESS SPRAY
QUANTITIES (<u>ready to use</u>):		
1st coat (wet mils)	6 ÷ 8	6 ÷ 8
2nd coat (wet mils)	6 ÷ 8	6 ÷ 8
3rd coat/eventually (wet mils)	6 ÷ 8	6 ÷ 8
Maximum amount to apply	25 wet mils	25 wet mils
DILUTION:	10-30%	10-20%

SUGGESTED CYCLES:

a) Substrate:	MDF or various woods	
Stain:	LAM xxx SERIE - MAKOLOR	
Isolator:	LDA 020 – Clear Isolator, or LDA 001 – Clear isolator for exotic woods	1-2 layers
Sealer:	LPA 127 – HIPOFOND Clear PE	2-3 layers
Sanding:	280-320-400 grain paper	
Topcoat:	LGA 209 – SIVOGLOSS Clear Glossy PU or LRA 309 – REFLET Clear Glossy PE (direct gloss)	1 layer

DRYING-TIME (at 20°C/68°F)

Gel time	30-40 min.
Dry to touch	80-90 min.
Dry to sand	8 hrs.
Thoroughly dry	12 hrs.

REMARKS:

The second and the third coats must be applied after gel time of the product. In The cycles in most layers, to avoid stratification problems, verify before the subsequent application that the previous coat is gelled but still sticky enough on the surface. Gel time, pot-life and drying time are according to the environment temperature.

In case of application of top coats on pieces treated with LPA 127 already sanded from several days, it is recommended, for better adhesion and to avoid delamination, to come back with 320-400 grain paper again before to apply the final coat.

On wooden substrates with large pore as oak, mahogany and hard wood in general, before applying the polyester sealer, we recommend to apply a PU isolator as LDA 020 or LDA 001.

On MDF to improve adhesion and control the absorption, we recommend to apply the isolator for MDF LBP 541

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Other important remarks:

- This product is not suitable for substrates that must be exposed.
- The humidity of the substrate must be not higher than 14-16%.
- Any isolator does not insulate from the humidity.
- Check the compatibility with any stains used. To avoid any inconvenient, in case of stained surfaces, we suggest to apply the isolator to be sure of the result.
- Avoid to apply the polyester in hard environment condition ($T < 10^{\circ}\text{C}/50^{\circ}\text{F}$ or $> 30^{\circ}\text{C}/86^{\circ}\text{F}$).
- Do not apply thickly if not necessary and never apply more than quantity suggested.
- LZD 046 indicate in this TDS contents reactive monomer. Do not use more than 10%

STORAGE: Keep in a fresh and well-ventilated place; preferably not exceed $30^{\circ}\text{C}/86^{\circ}\text{F}$.
In this condition the product has 6months of shelf-life

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IMPORTANT: The information contained in this technical data sheet are based on the average results obtained in our laboratories and is the best experience we have acquired in the most rigorous manner, thorough tests and checks.

Nuova S.I.V.A.M. guarantees the consistency of the chemical/physical characteristics of its products within the tolerances indicated above.

The final result is the full responsibility of the user who, before using the product, must check that it meets his requirements in terms of safety, application equipment, support material to paint, and environmental conditions.

The information given herein is based on a temperature of $20^{\circ}\text{C}/68^{\circ}\text{F}$ and 70% of relative humidity.

Nuova S.I.V.A.M. technical and commercial network is at your complete disposal to deal with any questions regarding how to correctly apply and use our products.