



Technical Data Sheet

PRODUCT

LRA 94

TECHNICAL DEFINITION

Transparent polyester sanding sealer.

High filling power, good anti-sag properties, very good transparency and limited tendency to turn-green.

MAIN FIELDS OF APPLICATION

Assembled furniture parts, furniture articles particularly useful when high transparency is requested, coupled with high transparency is requested, coupled with anti-sag properties, good sandability, and low turn-green effect.

PRODUCT USE

Specific gravity	1,074 ± 0,01 gr/ml
Solid content I component	89% ± 2%
Viscosity (CF4)	65" ± 3"

CHEMICAL-PHYSICAL PROPERTIES

	<i>In weight</i>	<i>In volume</i>
Catalysis (code)	2% LOB 810	
Accelerator (code)	2% LOB 828 or 2% LOB 840	
Dilution (code)	LZC 1000 - LZC 944	

FEATURES OF READY TO USE PRODUCT

Pot life	15 min
Viscosity (REGULATION)	
Gloss level	
Pot life – accelerated product	3 days
Pot life – catalyzed product	8 h

APPLICATION

QUANTITIES

DILUTION

Spray	150-200 gr/m2	5-10%
Curtain		

PRODUCT PROPERTIES AFTER APPLICATION

Drying schedule at room temperature

Hot air drying

Time between layers – gel time 15-35 min

Dust free 15-35 min

Touch dry 90-120 min

Hard dry 12 h

Sandable after (time) 12 h

IVM Chemicals srl – International Wood Coating Division - 27020 Parona (PV), V.le della Stazione 3
- tel. +39 0384 25 44.1 - fax +39 0384 252 054

Sede sociale: 20123 Milano, Via Tasso 10 - capitale sociale i.v. € 10.000.000
codice fiscale, registro imprese C.C.I.A.A n. 02170230342 - REA n. 1657837- Partita IVA 13472030157
milesi@ivmchemicals.com - www.milesi.com



Technical Data Sheet

REMARKS

RACCOMANDED COATING SCHEDULES

a)	- SUBSTRATE	Style furniture parts, medium density, veneer
	- STAIN	CIT 1-9 series - staining by roller coater
	- INSULATOR	LQA 836/837 Polyurethane coating
	- SANDING SEALER	LRA 94 - transparent polyester sanding sealer - 2 coats
	- TOP COAT	LGA Polyurethane satin finishes or LDA Polyurethane gloss finishes
B)	- SUBSTRATE	Ramin wood profiles
	- STAIN	CIT 1-9 series - staining by roller coater
	- SANDING SEALER	LRA 94 transparent polyester sanding sealer
	- TOP COAT	LGA Polyurethane satin finishes or LDA Polyurethane gloss finishes

IVM Chemicals srl – International Wood Coating Division - 27020 Parona (PV), V.le della Stazione 3
- tel. +39 0384 25 44.1 - fax +39 0384 252 054

Sede sociale: 20123 Milano, Via Tasso 10 - capitale sociale i.v. € 10.000.000
codice fiscale, registro imprese C.C.I.A.A n. 02170230342 - REA n. 1657837- Partita IVA 13472030157
milesi@ivmchemicals.com - www.milesi.com



Technical Data Sheet

OBSERVATIONS

- The informations given in this technical data sheet, has been obtained at a temperature of 20°C., and a relative humidity of 70%.
- At the moment of application, pot-life, gel time, drying times and sandability, depend greatly on the room temperature.
- Where a faster cure is desired (normally in winter and on local temperatures between 10°C. to 15°C.) we suggest the following variation s.:
 - a) an increase of LOB 810 to 3% on coating.
 - b) an increase of LOB 810 to 3% plus 3% LOB 828 on coating.
- These increase in both catalyst and promoter will also shorten the pot-life of the coating. For this reason it is advisable to use a two component type of spray equipment.
- If instead, it is necessary to increase the pot-life of the coating (usually in summer with local temperatures between 25° C to 35° C) we advise to reduce the percentage of promoter (LOB 828) to 1,5% or even 1,0% in total coating.
- When LRA 94 is to be applied on exotic woods such as rosewood, teak, mansonia or on fine line veneer, it is necessary to apply one or more coats of out polyurethane insulator: LQA 836/LNB 837.
- On normal air spray applications, we advise to use an orifice of 2,5 to 3,0 mm.
- When employing the two component spray equipment of the 1/1 type, the promoted half of the coating receives the double amount of LOB 810. In this way the mixed coating receives the correct amounts of promoter and catalyst, as in the curtain coater method.
- The best sanding results are obtained by using sandpaper of 220 grain for the initial operation and paper of 360-400 grain for finishing operations.
- For further suggestions and information on the use of polyester coatings, read our special technical bulletin entitled "Paraffinate, Unsaturated Polyester Pastes".
- LRA 94 polyester sealer can be pigmented, (if desired) with 4% of our white polyester paste (LMT-GMT series), or with 2% of the other types of pigmented polyester pastes.
- Polyfond LRA 94 does not have the same ultra-high transparency of the paraffinated "LPA" types of polyester coatings.
- When it becomes necessary to match furniture parts coated with both types of products (LRA and LPA coatings) we advise to pre-determine experimentally the correct amounts or weights per square meter that will allow a close match between these two different polyester types.
- In case of very light woods such as maple or ash, it is preferable to use our special promoter LOB 840 at 2% instead of LOB 828. This variation will reduce the tendency of cobalt to turn green.
- To increase pot-life of the mixture till 50'-60', use LOB 5 (2%) instead LOB 810, LOB 828 (2%) and LZC 1000 (10-15%).

SHELF LIFE

- Please refer to the safety data sheet

Storage indications

- Store in a tightly closed container and at room temperature 18-25°C, 64-75°F and protect from moisture and foreign material.

IVM Chemicals srl – International Wood Coating Division - 27020 Parona (PV), V.le della Stazione 3
- tel. +39 0384 25 44.1 - fax +39 0384 252 054

Sede sociale: 20123 Milano, Via Tasso 10 - capitale sociale i.v. € 10.000.000
codice fiscale, registro imprese C.C.I.A.A n. 02170230342 - REA n. 1657837- Partita IVA 13472030157
milesi@ivmchemicals.com - www.milesi.com



Technical Data Sheet

Emission date: LRA 94 - May 2011 - II°

IMPORTANT: Since every single panel or any other substrate, even if of the same chemical nature, can be theoretically different then the previous one and posses chemical and physical properties which can greatly influence the end-results of the applied coating, and considering that the mixing, catalysis and diluting operations are not under our strict control, nor are temperatures, air humidity and technical features of the various installations, which can also effect the end-results, subject to our personal decision at the time of application, it is impossible for our Company to assume any responsibility whatsoever in regard to the results obtained with the use of our products.

Furthermore we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is definitely not caused by the quality of the products employed.

The technological information contained in the present technical data sheet are based on the average results obtained with the tests effects in our laboratories, and as such represents the most complete informant and technological experience available in the wood coating field.

Our company instead gives the maximum assurance as to the constancy of the chemical and physical properties of our products within the tolerance limits indicated on our technical data sheet. Our Company is also always ready to substitute any of our products, whenever the properties do not correspond to the information given in our technical bulletins.

Nevertheless, the end-results obtained are under the complete responsibility of the end-user, who has the obligation to verify if the properties of the specific products in use correspond to his particular requirements, and if the ambient conditions, application, installation and substrates might eventually indicate substantial modifications of the products involved.

All the information in our technical data sheet has been obtained at a temperature of 20°Centigrade and at a relative humidity of 70%.

At the bottom of our technical data sheet, You will find a date and a progressive number. We request You have your own personnel to control the edition in your possession as all technical information is always susceptible to eventual modification with the passage of time.

IVM Chemicals srl – International Wood Coating Division - 27020 Parona (PV), V.le della Stazione 3
- tel. +39 0384 25 44.1 - fax +39 0384 252 054

Sede sociale: 20123 Milano, Via Tasso 10 - capitale sociale i.v. € 10.000.000
codice fiscale, registro imprese C.C.I.A.A n. 02170230342 - REA n. 1657837- Partita IVA 13472030157
milesi@ivmchemicals.com - www.milesi.com