

APPLICATION BROCHURE



JK Cement LTD.

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ABOUT JK Cement Ltd.

JK Cement Ltd. is one of the leading cement manufacturers in India that has partnered the Nation's multi-sectoral infrastructure needs on the strength of its product excellence, customer orientation and technology leadership.

The Company has over four decades of experience in cement manufacturing.

JK White Cement, a division of JK Cement Ltd., enjoys a pan India presence and the Company is the leading producer of Wall Putty in the Country.

A pioneer in the White Cement industry, the Company is the leading producer of wall putty in the Country and one of the largest white cement manufacturers in the world.

We are steadily enhancing our capacity, diversifying our range of products, ushering in advanced technology and quality assurance, and above all, expanding our presence nationally and internationally. Our brands continue to enjoy the trust of millions of consumers for the high quality and innovation benchmarks that we have attained.

Superior products and a strong Brand name, an extensive marketing and distribution network and the technical know-how represent JK Cement's abiding strengths.

ABOUT JKC Wood Amore

JK Cement Ltd., one of India's leading building material solutions company, proudly presents a premium range of Italian wood finishes. Presenting JKC Wood Amore; a range of Polyurethane (PU) products that ensures outstanding finish, appealing aesthetics and higher durability for wood surfaces that is best suited for interiors.

Finishes from JKC Wood Amore

Wood finishes from JKC Wood Amore brings in the unique combination of both art and science. The Polyurethane clear and white solutions hold the capability to enhance the beauty and increase the life of the wooden surface. Give a new life to the wooden surfaces by not just painting the wood but by giving them coloured finishes— in wide range of metallic and solid options.

You can give the touch of masterpiece to your wooden surfaces on your own and breathe in a new life into them with the wide variety of finishes at your fingertips.

JKC Wood Amore Colour Galleria

JKC Wood Amore offers a wide spectrum of colours, accounting to more than 2000 colour options under the RAL and NCS category.

- The colour finishes are available in both Polyurethane matt and gloss finish
- Select the colour from the catalogue to choose a finish for your wooden surfaces
- The visualisation tools like fandecks and colour panels, help in making colour representation and selections much easier

Support from JKC Wood Amore

- JKC Wood Amore aims at providing the right knowledge about the products and related tools for the benefit of its influencers and consumers
- Bringing art to science and exploring every artistic possibility available, JKC Wood Amore aims at redefining the approach towards wood finishes
- JKC Wood Amore is committed to provide complete support to its consumers with the help of Guide kit that includes shade visualizer, fandecks and colour panels



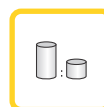
JKC Wood Amore PU Clear Sealer

JKC Wood Amore PU Clear Sealer is a premium Polyurethane transparent coating, suitable for all wood and veneer substrates. It can be used for interior wooden surfaces.

Key Features:

- Sealer provides excellent wetting & filling of wood with high transparency.
- No cracking or whiteness at high thickness
- Easy to sand providing even and smooth base finish for topcoats
- Quick drying for high productivity
- Good mechanical and chemical resistance properties with very high durability
- Provides extra coverage

PRODUCT INFORMATION :



Hardener : JKC Wood Amore PU Clear Sealer/Matt TC / Single Coat Sealer - CSMH1071

Resin : Hardener : 2:1 (by volume)



Thinner : JKC Wood Amore Medium PU Thinner - TH11113

Resin to Thinner percentage : 30%-35% (by volume)



No of Coats+ : 2 coats

Dust Free* : 10-15 mins



Sandable Dry* : 2-3 Hrs

DFT+ : 50-60 microns per coat



Flash off Time* : 5-10 mins

Coverage : 6.8-8 Sqm/liter



Gun Nozzle : 1.6-1.8 mm

Gun Pressure : 40-45psi for conventional gun & 25-30psi for HVLP gun

+ 1 coat is defined as 2 passes with flash off time as recommended above * 30°C and RH-60-70% (varies as per prevailing conditions)



Application Process:



STEP 1:

Sanding - Use sand paper P120 and P220 depending upon the wood condition



STEP 2:

Apply JKC Wood Amore wood stain as per the desired colour. Allow it to dry for 30 minutes



STEP 3:

Apply JKC Wood Amore Insulator in one or two passes. Allow it to dry for 30 minutes



STEP 4:

1st Base Coat Application - Apply JKC Wood Amore PU Clear Sealer in two passes with 5-10 minutes of flash off in between. Allow it to dry for 3-4 hours



STEP 5:

Sanding - Use sand paper P320 for sanding after the sealer application



STEP 6:

2nd Base Coat Application - Apply JKC Wood Amore PU Clear Sealer in two passes with 5-10 minutes of flash off in between. Allow it to dry for 3-4 hours



STEP 7:

Sanding - Use sand paper P320 to P400 for sanding evenly



Next Application Process:

After sanding apply JKC Wood Amore PU Clear High Gloss/ JKC Wood Amore PU Clear Matt (20%G) as per the finish desired



Pack Size : 1.5 Kg Combi, 4 Kg Resin+2 L Hardener, 20 Kg Resin+10 L Hardener



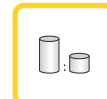
JKC Wood Amore PU Clear High Gloss

JKC Wood Amore PU Clear High Gloss is a Premium Polyurethane clear with high durability suitable for wood and veneer. It can be used for interior wooden surfaces.

Key Features:

- Provide excellent durability, stain and chemical resistance for protection of wood in interior applications
- Very good application with excellent flow and levelling
- Product provides excellent gloss and is very easy to polish
- Non-yellowing product
- No shrinkage

PRODUCT INFORMATION :



Hardener : JKC Wood Amore PU Clear /White High Gloss Hardener - cwgh1074

Resin : Hardener : 1:1 (by volume)



Thinner : JKC Wood Amore PU Thinner High Glossy - TH11079

Resin to Thinner percentage : 30%-35% (by volume)



No of Coats+ : 2 single coats

Dust Free : 15-20 mins



Handlable Dry* : 4-5 Hrs

DFT+ : 45-50 microns for 1 coat application at 30°C



Flash off Time* : 5 to 10 mins

Coverage : 7.7-8.5 Sqm/liter



Gun Nozzle : 1.4 mm

Gun Pressure : 40-45psi for conventional gun & 25-30psi for HVLP gun

+ 1 coat is defined as 2 passes with flash off time as recommended above * 30°C and RH-60-70% (varies as per prevailing conditions)



Application Process:



STEP 1:

Sanding - Use sand paper P400 on JKC Wood Amore PU Clear Sealer surface



STEP 2:

1st Top Coat Application - Apply JKC Wood Amore PU Clear High Gloss in two passes with 5-10 minutes of flash off in between. Allow it to dry for overnight. If required, 2nd coat can be applied as per above process



STEP 3:

Sanding - Use sand paper P400 to P600 for sanding evenly



STEP 4:

2nd Top Coat Application - Apply JKC Wood Amore PU Clear High Gloss in two passes with 5-10 minutes of flash off in between. Allow it to dry for overnight



Next Application Process:

For best finish, use abrasives and paint finishing compounds



Pack Size : 2 L Combi, 4 L Resin+4 L Hardener, 20 L Resin+20 L Hardener (10 L+10 L)









JKC Wood Amore PU Clear Matt (20%G)

JKC Wood Amore PU Clear Matt (20%G) is Polyurethane clear suitable for wood and veneer. It can be used for interior wooden surfaces.

Key Features:

- Very good durability for protection of wood and veneer
- Uniform matting
- Excellent transparency and smoothness
- Product provides excellent mechanical and chemical resistance properties

PRODUCT INFORMATION :

	Hardener : JKC Wood Amore PU Clear Sealer/Matt TC /Single Coat Sealer - CSMH1071 Resin to Thinner percentage : 2:1 (by volume)
	Thinner : JKC Wood Amore Medium PU Thinner - THI1113 Resin : Thinner : 30%-35% (by volume)
	No of Coats+ : 2 single coats Dust Free* : 10-15 mins
	Sandable Dry* : 2-3 Hrs DFT+ : 40-45 microns for 1 coat application at 30°C
	Flash off Time* : 5-10 mins Coverage : 7.6-8.6 Sqm/liter
	Gun Nozzle : 1.4 mm Gun Pressure : 40-45psi for conventional gun & 25-30psi for HVLP gun

+1 coat is defined as 2 passes with flash off time as recommended above * 30°C and RH-60-70% (varies as per prevailing conditions)

Application Process:



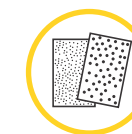
STEP 1:

Sanding - Use sand paper P400 on JKC Wood Amore PU Clear Sealer surface



STEP 2:

1st Top Coat Application - Apply JKC Wood Amore PU Clear Matt (20%G) in two passes with 5-10 minutes of flash off in between. Allow it to dry for overnight. If required, 2nd coat can be applied as per above process



STEP 3:

Sanding - Use sand paper P400 to P600 for sanding evenly



STEP 4:

2nd Top Coat Application - JKC Wood Amore PU Clear Matt (20%G) in two passes with 5-10 minutes of flash off in between. Allow it to dry for overnight



Pack Size : 1.5 L Combi, Resin 4 L+Hardener 2 L
& Resin 20 L+Hardener 10 L



JKC Wood Amore White Filler

JKC Wood Amore White Filler is a high solid Polyurethane white filler with suitability on wood, MDF & and other wooden products for interior use.

Key Features:

- Very good hiding and filling power
- Quick drying with easy and clog free sanding
- Easy application, good flow and levelling

PRODUCT INFORMATION :

	Hardener : JKC Wood Amore PU White Filler Hardener - WFH1071 RESIN : Hardener : 3:1 (by volume)
	Thinner : JKC Wood Amore Medium PU Thinner - THI1113 Resin to Thinner percentage : 30-35% (by volume)
	No of Coats+ : 2 single coats Dust Free* : 10-15 mins
	Sandable Dry* : 2-3 Hrs DFT+ : 50-60 microns for 1 coats application at 30°C
	Flash off Time* : 5-10 mins Coverage : 7.6-9 Sqm/liter
	Gun Nozzle : 1.6-1.8 mm Gun Pressure : 40-45psi for conventional gun & 25-30psi for HVLP gun

+1 coat is defined as 2 passes with flash off time as recommended above * 30°C and RH-60-70% (varies as per prevailing conditions)

Application Process:



STEP 1:

Sanding - Use sand paper P120 and P220 depending upon the wood condition



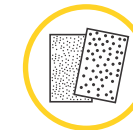
STEP 2:

Apply JKC Wood Amore Insulator in one or two passes. Allow it to dry for 30 minutes



STEP 3:

1st Base Coat Application- Apply JKC Wood Amore PU White Filler in two passes with 5-10 minutes of flash off in between. Allow it to dry for 3-4 hours



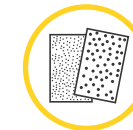
STEP 4:

Sanding - Use sand paper P320 for sanding after the sealer application



STEP 5:

2nd Base Coat Application- Apply JKC Wood Amore PU White Filler in two passes with 5-10 minutes of flash off in between. Allow it to dry for 3-4 hours



STEP 6:

Sanding - Use sand paper P320 to P400 for sanding evenly



Next Application Process:

After sanding, apply JKC Wood Amore PU White High Glossy / JKC Wood Amore PU White Matt (10%G) as per the finish desired



Pack Size : 2 Kg Combi, Resin 4 Kg+Hardener 1.2 L & Resin 20 Kg+Hardener 6 L



JKC Wood Amore White High Gloss

JKC Wood Amore White High Gloss is a high quality Polyurethane with suitability on wood, MDF & and other wooden products for interior use.

Key Features:

- Very good hiding and whiteness
- Very high gloss
- Easy application, good flow and levelling
- Easy polishability
- Non-yellowing

PRODUCT INFORMATION :

	Hardener : JKC Wood Amore PU Clear / White High Gloss Hardener - CWGH1074 Resin to Thinner percentage : 1:1 (by volume)
	Thinner : JKC Wood Amore PU Thinner High Glossy - TH11079 Resin : Thinner : 30%-35% (by volume)
	No of Coats+ : One Coats Dust Free* : 15-20 mins
	Sandable Dry* : 4-5 Hrs DFT+ : 45-50 microns for 1 coats application at 30°C
	Flash off Time* : 5-10 mins Coverage : 8.5-9.5 Sqm/liter
	Gun Nozzle : 1.4 mm Gun Pressure : 40-45psi for conventional gun & 25-30psi for HVLP gun

+1 coat is defined as 2 passes with flash off time as recommended above * 30°C and RH-60-70% (varies as per prevailing conditions)



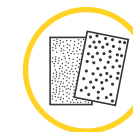
Application Process:



STEP 1:
Sanding - Use sand paper P320 to P400 on JKC Wood Amore White Filler surface



STEP 2:
1st Top Coat Application- Apply JKC Wood Amore White High Gloss in two passes with 5-10 minutes of flash off in between. Allow it to dry for overnight. If required, 2nd coat can be applied as per above process



STEP 3:
Sanding - Use sand paper P400 to P600 for sanding evenly



STEP 4:
2nd Top Coat Application - Apply JKC Wood Amore White High Gloss in two passes with 5-10 minutes of flash off in between. Allow it to dry for overnight



Next Application Process:
For best results, use abrasives and paint finishing compounds



Pack Size : 2 Kg Combi, Resin 4 Kg+Hardener 4 L
& Resin 20 Kg+Hardener 20 L (10 L+10 L)



JKC Wood Amore White Matt (10%G)

JKC Wood Amore White Matt (10%G) is high quality matt topcoat with suitability on wood, MDF & and other wooden products for interior use.

Key Features:

- Very good hiding and whiteness
- Even matting
- Easy application, good flow and levelling
- Excellent hardness & smooth finish
- Non-yellowing

PRODUCT INFORMATION :

	Hardener : JKC Wood Amore PU Whitematt 10 Hardener - WMH1077 Resin : Hardener : 2:1 (by volume)
	Thinner : JKC Wood Amore Medium PU Thinner - THI1113 Resin to Thinner percentage : 30-35% (by volume)
	No of Coats+ : One coat Dust Free* : 10-15 mins
	Handlable Dry* : 1.5-2 Hrs DFT+ : 40- 45 microns for 1 coat application at 30°C
	Flash off Time* : 5-10 mins Coverage : 7-8 Sqm/liter
	Gun Nozzle : 1.4 mm Gun Pressure : 40-45psi for conventional gun & 25-30psi for HVLP gun

+1 coat is defined as 2 passes with flash off time as recommended above * 30°C and RH-60-70% (varies as per prevailing conditions)

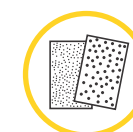
Application Process:



STEP 1:
Sanding - Use sand paper P400 on JKC Wood Amore PU Clear Sealer surface



STEP 2:
1st Top Coat Application - Apply JKC Wood Amore PU White Matt (10%G) in two passes with 5-10 minutes of flash off in between. Allow it to dry for overnight. If required, 2nd coat can be applied as per above process



STEP 3:
Sanding - Use sand paper P500, P400 to P600 for sanding evenly



STEP 4:
1st Top Coat Application - JKC Wood Amore PU White Matt (10%G) in two passes with 5-10 minutes of flash off in between. Allow it to dry for overnight



Pack Size : 1.5 Kg Combi, Resin 4 Kg+Hardener 2 L
& Resin 20 Kg+Hardener 10 L



JKC Wood Amore Wood Stains

JKC Wood Amore Wood Stains are solvent based dyes, which offer excellent transparent shades, better durability and uniform finish. It can be easily applied with a spray gun or muslin cloth and are use for interior wooden surfaces.

Key Features:

- High transparency
- Excellent color strength
- Fast drying

PRODUCT INFORMATION :



Colours : Black, Teak, Walnut, Rose Wood, Oak Yellow, Wenge, Mahogany



No of Coats+: 1-2 passes



Flash off Time* : 5 to 10 mins
Coverage* : 8-10 Sqm/liter for spray gun



Gun Nozzle: 1.4-1.8 mm
Gun Pressure: 40-45psi for conventional gun & 25-30psi for HVLP gun

* 14 - 18 Sqm/liter for wipe

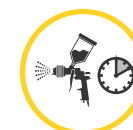
Application Process:



STEP 1:
Sanding - Use sand paper P120 and P220 depending upon the wood condition



STEP 2:
Apply JKC Wood Amore Wood Stain as per the desired colour. Allow it to dry for 30 minutes



Next Application process:
Apply JKC Wood Amore Insulator in one or two passes. Allow it to dry for 30 minutes



JKC Wood Amore PU Insulator

JKC Wood Amore PU Insulator provides a strong protecting film to the wood by penetrating inside it and sealing the porosity of the wooden surface. It helps to enhance actual colour of the wood and can be used for interior wooden surfaces.

Key Features:

- Excellent pore penetration and good insulating power
- Seals the wood & wooden products porosity
- Good wett ability for transparent coating
- Use for Clear & Opaque colour wood finish
- Over coatable without sanding within 4 hrs

PRODUCT INFORMATION :



Hardener : JKC Wood Amore PU Insulator Hardener - IH1101
Resin : Hardener : 1:1 (by volume)



Thinner : JKC Wood Amore Medium PU Thinner - TH1113
Resin : Thinner : 0% - 5% (by volume)



No of Coats+ : 2 Passes
Dust Free* : 10-15 mins



Next Coat Application Time*: 30 mins
DFT+ : 55-65 microns per coat



Flash off Time* : 2-5 mins
Coverage : 14 - 18 Sqm/liter



Gun Nozzle : 1.4-1.8 mm
Gun Pressure : 40-45psi for conventional gun & 25-30psi for HVLP gun

+1 coat is defined as 2 passes with flash off time as recommended above * 30°C and RH-60-70%
(varies as per prevailing conditions)



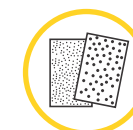
Application Process:



STEP 1:
Sanding – Use sand paper P120 and P220 depending upon the wood condition



STEP 2:
Apply JKC Wood Amore wood stain as per the desired colour. Allow it to dry for 30 minutes. Skip this step 2 for the color opaque finish



STEP 3:
Apply JKC Wood Amore PU Insulator in one or two passes. Allow it to dry for 30 minutes



Next Application Process:
After application of PU Insulator apply JKC Wood Amore PU Clear Sealer/ JKC Wood Amore Clear Single Coat Sealer/ JKC Wood Amore PU White Filler



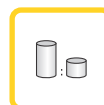
JKC Wood Amore PU Clear Single Coat Sealer

JKC Wood Amore PU Single Coat Sealer is a premium Polyurethane transparent coating, suitable for all wood and veneer substrates.

Key Features:

- Extra high solids
- Sealer provides excellent wetting & filling of wood with high transparency
- No cracking or whiteness at high thickness
- Easy to sand providing even and smooth base finish for topcoats
- Quick drying for high productivity
- Good mechanical and chemical resistance properties with very high durability
- Provides extra coverage

PRODUCT INFORMATION :



Hardener : JKC Wood Amore PU Clear Sealer/Matt TC / Single Coat Sealer - CSMH1071

Resin: Hardener : 2:1 (by volume)



Thinner : JKC Wood Amore Medium PU Thinner - THI1113

Resin : Thinner : 30%-35% (by volume)



No of Coats+ : 2 coats

Dust Free* : 10-15 mins



Sandable Dry* : 2-3 Hrs

DFT+ : 55-65 microns per coat



Flash off Time* : 5 to 10 mins

Coverage : 6.8-8 Sqm/liter

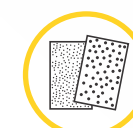


Gun Nozzle : 1.6-1.8 mm

Gun Pressure : 40-45psi for conventional gun & 25-30psi for HVLP gun

+ 1 coat is defined as 2 passes with flash off time as recommended above * 30°C and RH-60-70% (varies as per prevailing conditions)

Application Process:



STEP 1:

Sanding - Use sand paper P120 and P220 depending upon the wood condition



STEP 2:

Apply JKC Wood Amore wood stain as per the desired colour. Allow it to dry for 30 minutes



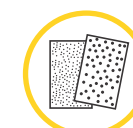
STEP 3:

Apply JKC Wood Amore Insulator in one or two passes. Allow it to dry for 30 minutes



STEP 4:

1st Base Coat Application- Apply JKC Wood Amore PU clear single coat sealer in two passes with 5-10 minutes of flash off in between. Allow it to dry for 3-4 hours



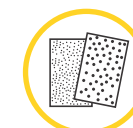
STEP 5:

Sanding - Use sand paper P320 for sanding after the sealer application



STEP 6:

2nd Base Coat Application- Apply JKC Wood Amore PU clear single coat sealer in two passes with 5-10 minutes of flash off in between. Allow it to dry for 3-4 hours. (Only if need be)



STEP 7:

Sanding - Use sand paper P320 to P400 for sanding evenly



Next Application Process:

After sanding apply JKC Wood Amore PU Clear High Glossy / JKC Wood Amore PU Clear Matt (20%G) as per the finish desired

Paint Defects & REMEDIES

Sagging



Causes:

- Wrong spraying viscosity and spraying technique, thickness of coating, slow evaporation time of coatings
- Defective spraying tools and settings
- Low temperature of paint, substrate or spray booth
- Wrong choice of hardeners or thinners

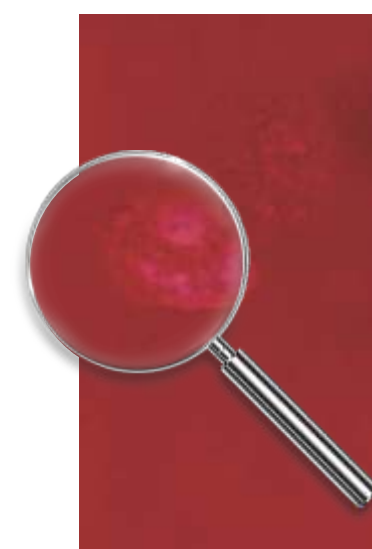
Prevention:

- Correct application procedure
- Good working condition of tools
- Surface and materials upto room temperature of 20° Celsius
- Correct choice and combination of hardeners and thinners

Remedy:

- Sand the surface and repaint

Water Spotting



Causes:

- Short drying time
- Topcoat not cured properly
- Wrong choice of thinner and hardener
- Incorrect mixing ratio of hardener and thinner
- Moisture contamination

Prevention:

- Follow the instructions mentioned on the technical data sheet

Remedy:

- Remove marks after thorough drying
- Once the top coat dries off properly, sand and repaint the surface

Clouding



Causes:

- Wrong spraying viscosity and spraying technique, thickness of coating, slow evaporation time of coatings
- Wrong thinner
- Defective spraying tools and settings

Prevention:

- Adjust the material and tools' position before use
- Select the correct tools' setting
- Use correct thinner and hardener
- Ensure sufficient flash-off

Remedy:

- Sand the surface once the paint has dried off thoroughly.
- While using water-based base coat, apply a uniform layer on wet base coat as mentioned in the technical data sheet

Orange Peel



Causes:

- Wrong spraying pressure, technique or application temperature
- Incorrect combination or poor quality of solvent
- Insufficient sanding of substrate
- Wrong setting on spray gun
- Excessive temperature

Prevention:

- Follow the instructions on the technical data sheets
- Prepare and sand substrate
- Use correct setting on tools
- Avoid application at very high temperatures

Remedy:

- Sand and repaint

Solvent Popping



Causes:

- Insufficient drying of filler on the corners, edges and other decorative sides
- Resurfacing of air bubbles and solvents trapped in the film
- Wrong choice of thinner and hardener
- Incorrect technique of spraying
- Proper flash off

Prevention:

- Keep a check on the oven temperature
- Keep the thickness of the film normal
- Follow the instructions on the data sheets

Remedy:

- After thorough drying, repaint the surface without sanding within 24 hours
- While using water-based base coat, apply a uniform layer on wet base coat as mentioned in the data sheet

Sanding Scratches



Causes:

- Use of coarse sanding paper
- Insufficient sanded Polyurethane and isolation of the stopper before application of topcoat

Prevention:

- Use graded sanding paper
- Leave repaired areas with 2K filler
- Let the filler dry thoroughly

Remedy:

- Thoroughly dry and sand, prime and repaint the surface

Dirt and Dust in Clear Coat



- Causes:**
 - Dirt gets trapped in the wet film
 - Seen as specks, lightness depends upon the colour of the surface
- Prevention:**
 - The spray booth must be clean at all times
 - Blow out crevices to remove dust
 - Sand to remove dirt and refinish with base coat and clear coat, if required
- Remedy:**
 - Sand & repaint

Poor Opacity



- Causes:**
 - Less uniformity of the surface
 - Low build of topcoat
 - Thinned coating
- Prevention:**
 - Spray uniform substrate
 - Obtain opacity on the topcoat
 - Optimum amount of thinner
- Remedy:**
 - Sand and repaint

Dirt and Dust in Base Coat



- Causes:**
 - Dirt in the wet film
- Prevention:**
 - Keep the spray booth clean at all times
 - Dust must be removed at every stage of preparation
 - Paint strainer/filler must be used
- Remedy:**
 - Denib and reapply base coat to affected areas as required

Adhesion Problems Between Base and Clear Coats



- Causes:**
 - Excessive thickness of base coat
 - Less final and intermediate flash-off time for the base coat
 - Wrong mixing ratio of material
 - Wrong combination of hardener and thinner
- Prevention:**
 - Follow the thickness and flash-off timings mentioned on the technical data sheet
- Remedy:**
 - Sand and repaint the surface

Lifting & Wrinkling



- Causes:**
 - Chemical reaction between two incompatible substrates
 - High film builds
 - Insufficient curing and over coating
 - Wet-on-wet system on wrong hardener/thinner
- Prevention:**
 - Work on optimum film thickness
 - Products must be a part of a refinishes system
 - Flash-off and drying must be done according to the technical data sheet
 - Use correct hardener and thinner
- Remedy:**
 - Sand the area, remove the coating and refinish with metal stage

Matting / Gloss



- Causes:**
 - More thickness and humidity
 - Substrate sensitive to solvent
 - Wrong mixing
 - Use of wrong thinner/hardener
 - Insufficient air flow and baking
 - Incorrect polish applied too soon
- Prevention:**
 - Follow the application instructions as per the technical data sheet
 - Hardener lids must be closed tightly
 - Temperature control must be under check
 - No interruption in the baking cycle
- Remedy:**
 - Sand and polish

Moisture Blisters



- Causes:**
 - Residue of sanding water
 - Poor air supply
 - Less isolation of polyurethane
 - High air humidity
 - Dried salt residues
 - Moisture contamination
- Prevention:**
 - Remove trim
 - Dry carefully with air
 - Keep air supply in check
 - Clean the surface according to the instructions

Colour Fade / Change



- Causes:**
 - UV light effect on certain paint pigments on surface
 - Little or no use of UV blocker
- Prevention:**
 - Wax polishing can provide protection
- Remedy:**
 - Machine polishing can remove in parts
 - No over polishing. Keep a check using film thickness gauge
 - Refinish, if needed

NOTES :

Pin Hole



Causes:

- Substrate insufficiently dried
- Substrate not isolated with Insulator, pores not deeply sanded and filled with Sealer
- Moisture and oil contamination

Prevention:

- Allow prepared material to dry thoroughly
- Deeply sand the pores of the substrate and re-apply the Clear & Opaque Sealers
- Mix Hardener and Resin thoroughly, avoid air bubbles
- Proper cleaning & degreasing

Remedy:

- Sand damaged area and repaint
- Fill pinholes with Wood Filler

