

Below are some **general application** guidelines for UV Cure Coatings on oily wood with heavy grain but want a flat finished surface.

- Ensure wood is sanded with 220 grit
- Apply Oil based stains if desired and let sit until fully dry.
- Insulator for oily wood dampen lint free rag and simply wipe on.
- Let air dry (est. 15 min in normal 75 degree facility) but will be cured simultaneously with the next coating applied when exposed to a UV light source of 365nm @ 1W/cm2 intensity.
- UV gel filler should be applied directly over the dried insulator to fill in grain in the wood. The curing of both materials takes place simultaneously.
- Assuming UV Gel Filler was applied over the insulator (same steps even without the insulator) wipe on the UV Gel Filler with a lint free rag. After UV Gel is rubbed in, wipe off excess material with a lint free rag taking care to not leave any excess (this will decrease the sanding needed before any subsequent coatings are applied) and expose to a UV light source of 365nm @ 1W/cm2 intensity. Hold PowerShot UV Curing System, level 2"-3" above the surface and move at 2" per second.
- After curing a 220 light scuff will be needed prior to applying the subsequent coats of UV Gel
 or UV Topcoat to enhance mechanical bonding. Take care to scuff until no visible shine is left.
 Then wipe off dust particles with a lint free rag. (A light alcohol wipe with a lint-free rag may be
 used to fully remove all dust particles only if needed and then wait until fully dried before
 applying next coating.)
- Topcoat/Finish Coat can be brushed, rolled or sprayed with Self Regulated, Gravity-Fed HVLP Spray Gun.
- 10-30 PSI recommended air pressure
- 2.0 5.0 CFM Average Air Consumption
- A 1.2 to a .8 mm nozzle and apply up to 3 mil material thickness
- It can be applied up to a 3 mil thickness per coating. Let sit up to 2 minutes to allow UV Topcoat to flow out (can allow flow-out of 15 minutes, but this may increase contamination from particles in the air). Then expose to a UV light source of 365nm @ 1W/cm2 intensity. Hold PowerShot UV Curing System, level 2"-3" above the surface and move at 2" per second.

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 Topcoat to enhance mechanical bonding. Take care to scuff until no visible shine is left. Then
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 to fully remove all dust particles only if needed and then wait until fully dried before applying
 next coating.)
- Clean-up of supplies: simply use alcohol 70%
- If needed, can buff out to desired finish with an extra fine solid wax composite using a wool/cloth pad (do not use a liquid finish. We have not had any luck with foam pads due to the durability of the topcoat but everyone has their own special finishing techniques).

Note: Situations such as break through and buffing are different with 100% UV formulations. In spite of the much higher scratch resistance buffing seems to take less steps and effort to accomplish a very satisfying finish. Break through is much more difficult to do with UV formulations due to material hardness when cured correctly.

Always wear approved safety eye and skin protection during use of UV sources.

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