



Melamine Finish

Product composition: Berger Melamine is a 2 pack system specifically meant to be applied on wood. The mixing ratio of the base and catalyst is 9:1 specifically meant for interiors.

It has the following variants – Sealer, Matt and Gloss

USP:

Sealer	Sealer with excellent filling property and sandability, that makes the base perfect and is ideal for top coat application.
Top coat	Excellent finish and flow
	Gloss top coat provides an excellent gloss finish

Usage area: Normally applied upon wood, veneer, plywood and MDF.

DIRECTIONS FOR USE

Sanding: Sand off the substrate with water paper No. 80 in case the surface is too rough. If the surface is smooth, use water paper No. 120 to sand the surface and then wipe it clean with a cloth.

Mixing of Sealer: Make the sealer mixture by mixing the sealer base and catalyst in the ratio of 9:1. Add 30% Berger Melamine Thinner. NC thinner will also be compatible with Melamine. Allow the mixture to mature for 2-3 minutes.

Application: Transfer the mixture into a spray gun to apply the first coat. The spray gun pressure must be in between 45-55 psi. After 1.5 hours sand off the first coat of the sealer and apply the second coat. After another 1.5 hours, sand off the second coat of the sealer. Care should be taken while preparing a matt top coat by using water paper No. 220 to sand off the sealer. For a gloss top coat, use either water paper No. 320 or 400 to sand off the sealer.

Mixing of top coat: Make the matt mixture by mixing the base and catalyst in the ratio of 9:1. Also add 30% Melamine thinner to the mixture. Allow the mixture to mature for 2-3 minutes.

For a gloss finish, the mixture needs to be prepared by mixing the base and catalyst in the ratio of 9:1 and adding 30% Melamine thinner. Allow this mixture to mature for 2-3 minutes.

Application of top coats: Transfer the top coat mixture into a spray gun and spray under pressure 45 - 55 psi to apply the top coat. If there is the need for a second top coat, the applied top coat must first be sanded off after 3 hrs using water paper No. 400 for a matt top coat. For a gloss top coat, the applied top coat must be sanded off using water paper No. 600 after which the top coat can be applied. In each case the intercoat interval is 3 hours.

Precaution:

• Care should be taken that no water is there in the system. • The wood must be moisture and oil free • The mixing ratio must be maintained • NC thinner will go with Melamine, but for better results Berger Melamine Thinner is apt • Use the product within its pot life period i.e 3 hours

TECHNICAL DATA

In can Appearance	Sealer	Slightly yellowish translucent liquid
	Matt	
	Gloss	Slightly dark transparent liquid
Spray Viscosity	Sealer	20-25 s by Ford cup C4 at 30 degrees
	Matt	
	Gloss	
Coverage	Sealer	45-50 sq ft/ltr/coat
	Matt	40-45 sq ft/ltr/coat
	Gloss	45-50 sq ft/ltr/coat
Drying Time	Sealer	1.5 hrs
	Matt	2.5 hrs
	Gloss	3.5 hrs

PRODUCT INFORMATION

1	Shelf Life	1 year	3	Health & Safety Precautions	1) Avoid eye contact 2) Use mask during application as the product is solvent based 3) Contains free monomer, so the usage of mask is mandatory owing to the smell
	Storage	Store in cool & dry place			

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