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***BluSky Armor<sup>®</sup>***  
***Aerospace Clear Seal/Top Coat***  
***1007 Matte/Satin***

**Product Description**

A single stage, cross-linked UV curable thermoset polymer top coat. For use as a sealer and top coat for wood and synthetic substrates. Upon exposure to UV, the coating cures tack-free within 120 seconds. The cured coating has excellent adhesion, is harder, more abrasion and solvent resistant than other polyurethane or polyester thermoplastic coatings. The formulation is 100% solids containing zero solvents or HAPs (100% VOC free). The product exhibits no off-gassing, resulting in no “orange-peel” to be sanded off between applications. The product does not need any catalyst or reducer and is ready to use as is.

**Storage**

Store product at ambient temperature (< 70 °F). Storing at cooler temperatures will increase product lifetime. Storing at higher temperatures will decrease product lifetime. Product is warranted to be free from defects in performance and design for a period of 6 months from the date of manufacture if stored at < 70 °F without opening. Any tampering, misuse or negligence in handling or use of the product renders the warranty void. Further, the warranty is void if, at any time customer stores the product in a manner inconsistent with the recommended conditions.

**Method of Use**

Product is stable under typical ambient room lighting for 10 – 30 minutes.  
Stability can be extended to several hours by using UV Protective Films on lights and windows in the area where the product is being used.  
Product may not be mixed with other clear top coat products.  
Product may be reduced with isopropyl alcohol (IPA).  
Do not use the product in areas exposed to direct or indirect sunlight (i.e. through windows).  
Product is unstable and will cure upon exposure to sunlight.

**Surface Preparation**

Clean the surface area to remove any contamination. Use only dry air or alcohol (such as IPA) to clean the surface. Do not use any solvent based cleaner, degreaser, or tack cloths. Use sand paper or Scotch Brite. Remove dust using compressed air. The product can be applied over completely cured stains, sealers, or primers. Make sure surface is completely dry before application.

For applications on wood, BluSky Armor<sup>®</sup> 1007-U Sealer should be used to seal the material. For use over sealers and primers, the substrate requires sanding with non-steared sandpaper before applying product.

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## **Application**

Apply in a well-ventilated area, use appropriate PPE and a respirator for spray coating (refer to SDS). Brush, roll or spray onto substrate at room temperature (>70 °F). Depending on spray equipment, product may need to be reduced to spray viscosity with isopropyl alcohol. Substrate temperature should be >60 °F. Any spray equipment may be used. The recommended tip size is 1.0 – 2.0 mm. Follow the manufacturers best practices protocol. After use, unused resin should be stored in an opaque container and may be reused as long as the viscosity has not increased. Unused resin should not be returned to the original container. The spray equipment should be cleaned with isopropyl alcohol.

First coat (seal coat) should be applied as per the Application Process below, depending on if the surface is unstained, stained or has a sealer or primer coat.

Apply subsequent build coatings at thicknesses of 2 - 8 mils.

## **Application Process on Wood and Wood Veneer**

### ***1. SEAL COAT***

#### ***a UNSTAINED WOOD or VENEER***

- i. If the wood has not been stained, sand the wood out with non-stearated sandpaper before applying any finish. Use shop air with the grain. Lightly wipe the surface with a lint-free damp cloth using 91% isopropyl alcohol. **DO NOT USE** any solvent-based cleaner, degreaser, or tack cloth.
- ii. Spray a very light mist coat of BluSky Armor® 1007-U over the entire surface. Allow to soak for at least five minutes. Do not cure this application.
- iii. Apply a second mist coat of BluSky Armor® 1007-U and allow it to soak into the veneer for a minimum of five minutes.
- iv. Cure this application with MSI UV LED lights for 120 seconds.
- v. Sand the coating with 400 grit non-stearated sandpaper to deburr, flatten, and thoroughly degloss the surface.
- vi. Repeat steps ii. through v.

#### ***b STAINED WOOD or VENEER***

- i. Spray a very light mist coat of BluSky Armor® 1007-U over the entire surface. Allow to soak for at least five minutes. Do not cure this application.
- ii. Apply a second mist coat of BluSky Armor® 1007-U and allow it to soak into the veneer for a minimum of five minutes.
- iii. Cure the finish by exposing the panel to MSI UV-500 curing for 120 seconds, or until this finish is cured completely tack-free.
- iv. After curing, sand the coating with 400 grit non-stearated sandpaper to deburr, flatten, and thoroughly de-gloss.
- v. Repeat steps i. through iv.

**c. SEALED and/or PRIMED WOOD or VENEER**

- i. All sealers and primers must be completely cured using the Manufacturer's protocol.
- ii. Sand the surface with non-stearated sandpaper to achieve a mechanical bond.
- iii. Follow the same steps as stated in Step 2. *BUILD COATS* application below.

**ci. BUILD COATS**

- a. Build coating to desired thickness using BluSky Armor® 1027-U or 1057-U per the instructions from the appropriate BluSky Armor® 1027-U or 1057-U TDS.

**cii. FINAL Matte/Satin LAYER**

- a. Apply a 12 - 8 mil layer ayer of BluSky Armor® 1007 or 1027 Matte or Satin. Allow a minimum of five-minute dwell time to allow the wet clear coat to self-level.
- b. Cure the finish by exposing the panel to MSI UV-500 curing light for 120 seconds, or until the finish is cured completely tack-free.
- c. Sanding or polishing is not recommended after application of the final top coat of 1007-M/S.

**Clean-up**

Use isopropyl alcohol to clean tools and equipment. For skin contact wash with soap and water.

**Some key “Do’s and Don’ts”:**

1. Do **not** use a degreaser or petroleum or wax tack cloth to prepare the surface of the panel. Use 91% isopropyl alcohol (IPA) to prep before application of the seal coat and between coats.
2. Use a spray nozzle tip size of 1.2 – 1.6 to spray 1007-M/S; 1.0 – 1.4 to spray 1027-U; or a tip size of 1.6 – 1.8 to spray 1057-U.
3. Use low pressure on the spray gun, approximately 20 PSI. Adjust pressure to keep spray pattern compact and to minimize introduction of air bubbles into the clear coating.
4. Make sure that the can or the cup liner in the sprayer is opaque to block any light from activating the clear coat in the sprayer. 3m's PPS cup liner system, p/n 50730, is an ideal solution.
5. Avoid over-working the intermediate surface with coarse grit paper. Keep moving up in grit fineness.
6. Sand, cut and buff within 18 hours of applying final top coat. The finish hardens as it cures.
7. If saving leftover clear coat, store it in an opaque bottle separate from any unused BluSky Armor® clear coat in its original container.
8. Clean up the spray equipment with isopropyl alcohol.

**Physical Properties**

Pencil hardness	ASTM D3363	6H
Adhesion to Wood Veneer	ASTM D3359-09	5B
MEK Double Rubs Alcohol (IPA) Diet Coke Red Wine	ASTM D5402-93	200+ 200+ 200+ 200+
Tensile Modulus Strength Elongation	ASTM D638-10	112,000 psi 4,200 psi 5%
Shore D Hardness	ASTM D2240-15	81
Density		1.1 kg/L 9.2 lb./gal

**Additional information**

Solids content	100%
Volatile Organic Content	0%
Coverage @ 4 mil @ 10 mil	400 sq. ft./gal 160 sq. ft./gal

**Product Hazards and Safety information**

See SDS for complete information.

Although the product is VOC free it should be used in a well-ventilated area.

If skin contact occurs immediately wash with soap and water.

Harmful if swallowed.

Causes skin and eye irritation and may cause an allergic skin reaction.

Harmful to aquatic life with long lasting effects.

**Limitation of Liability:** The technical data and suggestions for use contained herein are correct to the best of our knowledge and offered in good faith. The statements of this literature do not constitute a warranty, whether expressed, or implied as to the product performance and merchantability for a particular purpose. MSI Coatings may guarantee this product to conform to our standards of quality, and our liability, if any, shall be limited to replacement of defective materials. Any and all technical information is subject to change without notice and it is the responsibility of the end user to verify that they have the most current available technical and safety information.

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