

Supplementary Instruction Sheet

WOOD KOTE PRODUCTS INC

PolyFlat 450 Flattening Formulas

Objective:

The following table has been prepared as a guide to flattening certain Wood Kote polyurethanes to achieve factory gloss levels.

Materials Required:

Wood Kote Ultra Flagship UV 450
Wood Kote PolyFlat 450 flattening agent
Wood Kote MacroTint or MiniTint measuring device
Wood Kote PolySolvent Mineral Spirits
Metal spoon
Cleanup cloths

Process:

1. **IMPORTANT:** Before adding flattening agent it is necessary to remove an amount of Ultra Flagship UV 450 from the factory container equal to the amount of flattening agent to be added.
2. In the left column of the table below, find the row with the appropriate polyurethane product and gloss level.
3. Look across the column headings to find the desired gloss level.
4. The amount of PolyFlat 450 to be added will be listed in the cell where the above selected column and row intersect.
5. Hold the MacroTint or MiniTint device upright with the measurement numbers facing toward the operator.
6. Grasp the piston at the bottom and turn until the calibration bar is aligned over the measurement numbers.
7. Pull the piston until the point at the end of the calibration bar reaches the desired increment, and then turn the piston $\frac{1}{4}$ of a turn to "lock" the piston in place.
8. Place the device on a flat level surface. Using a metal spoon fill the cylinder space with the appropriate liquid up to the top rim. Immediately pour the liquid into the proper receptacle while turning the piston to align the calibration bar over the measurement numbers.
9. Discharge the measured PolyFlat 450 into the polyurethane.
10. Then push the piston to the top of the cylinder. Liquid remaining on the piston head should be removed with a metal scraper.
11. Repeat the measuring process if required amount of PolyFlat 450 exceeds the capacity of the measuring device.
12. Clean the measuring device with PolySolvent (mineral spirits) and wipe with a cloth.
13. PolyFlat 450 should be thoroughly dispersed into the polyurethane product using an electric mixer or mechanical agitation for no less than 2 minutes.
14. **PLEASE NOTE:** These formulas are presented as a guide only. It is the responsibility of the applicator to adjust the final gloss to the appropriate levels.

Flattening Table for 1 Gallon

ORIGINAL PRODUCT	AMOUNT (fl oz) OF PolyFlat 450 TO ACHIEVE DESIRED GLOSS LEVEL	
	SATIN	MATTE
1 GALLON CONTAINER		
Ultra Flagship UV 450 – Gloss	22	31
Ultra Flagship UV 450 – Satin	N/A	9

Visit our web site at <http://www.woodkote.com>
for additional product information and application tips.