



# Chemical Coatings

## CC-F57 SHER-WOOD® Hi-Bild PreCat Lacquer

Gloss .....	T77C55
Bright Rubbed Effect .....	T77F56
Medium Rubbed Effect .....	T77F57
Dull Rubbed Effect .....	T77F58
Catalyst .....	V66V3

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>																												
<p><b>Sher-Wood® Hi-Bild PreCat Lacquer</b> is a fast drying, high performance, clear, conversion lacquer designed for the Kitchen and Bath Cabinetry and General Wood Finishing markets. After catalyization it provides a 4 month pot life.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• 20% higher volume solids than traditional PreCat lacquers.</li> <li>• Meets (KCMA) specifications as a self sealed system or over Sher-Wood Vinyl Sealers, T67F3, T67F5 or T67F6.</li> <li>• HAPS FREE as packaged (as defined by the National Standards for Hazardous Air Pollutants [HAPS] Emissions for Wood Furniture Manufacturing Operations 40 CFR 63, Subpart JJ)</li> <li>• Precatalyzed lacquer with 4 months working potlife.</li> <li>• Fast dry to sanding and packing.</li> <li>• Contains UV absorber to significantly reduce the discoloration of natural wood from exposure to sunlight.</li> <li>• Ready to spray, no reduction needed.</li> <li>• Good resistance to household chemicals.</li> <li>• Good flexibility – passes 20 KCMA cold check cycles.</li> <li>• Versatile application – may be applied by conventional, airless, air-assisted airless spray.</li> <li>• Pale water white color.</li> <li>• Ideal for kitchen cabinets, vanities, chairs, office furniture, household furniture</li> </ul> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility.</p>	<p><b>Gloss (measured on black glass):</b></p> <table> <tr> <td>Gloss</td> <td>85+ units</td> </tr> <tr> <td>BRE</td> <td>55-59 units</td> </tr> <tr> <td>MRE</td> <td>30-34 units</td> </tr> <tr> <td>DRE</td> <td>17-21 units</td> </tr> </table> <p><b>Volume Solids:</b> 25 ± 2%  <b>Weight Solids:</b> 33 ± 2%</p> <p><b>Viscosity:</b>    25-30 seconds #2 Zahn Cup</p> <p><b>Recommended film thickness:</b></p> <table> <tr> <td>Mils Wet</td> <td>3.0 - 5.0</td> </tr> <tr> <td>Mils Dry</td> <td>0.75 - 1.25</td> </tr> </table> <p>Maximum dry film thickness of the total system should not exceed 4.0 mils</p> <p><b>Spreading Rate</b> (no application loss)    295-577 sq ft/gal @ 0.75-1.25 mil DFT</p> <p><b>Drying</b> (77°F, 50% RH):</p> <table> <tr> <td>To Touch:</td> <td>10 - 15 minutes</td> </tr> <tr> <td>To Handle:</td> <td>15 - 20 minutes</td> </tr> <tr> <td>To Sand:</td> <td>30 - 45 minutes</td> </tr> <tr> <td>To Recoat/Topcoat:</td> <td>30 - 45 minutes</td> </tr> <tr> <td>To Pack:</td> <td>8 hour minimum</td> </tr> <tr> <td>Force Dry:</td> <td>5 - 10 minutes at 110 - 140°F, then air dry 1 hour minimum to pack</td> </tr> </table> <p><b>Flash Point:</b> 4°F Pensky-Martens Closed Cup</p> <p><b>Mixing Ratio:</b></p> <table> <tr> <td>1 gallon</td> <td>Lacquer</td> </tr> <tr> <td>3.0 ounces</td> <td>Catalyst V66V3</td> </tr> </table> <p><b>Pot Life:</b> 4 months  <b>Package Life:</b>    Uncatalyzed 2 years, unopened    Catalyzed 4 months</p> <p><b>Air Quality Data:</b>    Non-photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum    5.42 lb/gal, 649 g/L,    2.38 lbs VOC/lb solids    Hazardous Air Pollutants (HAPS) as packaged, No Reportable HAPS</p>	Gloss	85+ units	BRE	55-59 units	MRE	30-34 units	DRE	17-21 units	Mils Wet	3.0 - 5.0	Mils Dry	0.75 - 1.25	To Touch:	10 - 15 minutes	To Handle:	15 - 20 minutes	To Sand:	30 - 45 minutes	To Recoat/Topcoat:	30 - 45 minutes	To Pack:	8 hour minimum	Force Dry:	5 - 10 minutes at 110 - 140°F, then air dry 1 hour minimum to pack	1 gallon	Lacquer	3.0 ounces	Catalyst V66V3	<p><b>Wood</b> (interior only): Must be clean, dry, and finish sanded. Substrate should be free of grease, oil, dirt, fingerprints, and any contamination to ensure optimum adhesion and coating performance properties. Moisture content of wood should be 6 to 8%.</p> <p><b>Testing:</b> Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.</p> <p><b>Wood Finishing System:</b>  <b>THIS PRODUCT MUST BE CATALYZED.</b></p> <ol style="list-style-type: none"> <li>1. Color Wood - Stain or tone as desired and dry thoroughly.</li> <li>2. Seal - Apply Sher-Wood Hi-Bild PreCat Lacquer as a sealer or Sher-Wood Vinyl Sealers, T67F3, T67F5 or T67F6. (Consult corresponding data page for details). Spray a full wet coat. Air Dry 30 - 45 minutes.</li> <li>3. Sand - Sand with 240 grit or equivalent. Remove sanding dust.</li> <li>4. Topcoat - Spray a full wet coat of Sher-Wood Hi-Bild PreCat Lacquer at 3.0 - 5.0 mils wet.</li> <li>5. For more depth or build, apply an additional coat. Do not exceed 4.0 mils DFT for the total system.</li> </ol>
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## APPLICATION

### Typical Setups

THIS PRODUCT MUST BE CATALYZED DETERMINE IF IT HAS BEEN CATALYZED. If not catalyzed, add 2.3% (3.0 oz/gal) Sher-Wood Hi-Bild PreCat Catalyst, V66V3. Potlife after catalyzation is 4 months. Record the catalyzation date on the container.

Reduction: Product is normally applied without reduction. If reduction is needed to optimize application, use 5 - 10% HAPS Compliant Lacquer Thinner, R7K320, R7K305 or Acetone. Lacquer Thinner K120 or K22 may also be used, but are not HAPS compliant. Product can be retarded with MAK, EEP or Butyl Cellosolve.

### Conventional Spray:

Air Pressure ..... 35 - 60 psi  
Fluid Pressure ..... 6 - 10 psi  
Cap/Tip ..... 797

### Airless Spray:

Pressure ..... 1500 - 1800 psi  
Tip ..... .011 - .013"

### Air Assisted Airless:

Air Pressure ..... 20 - 30 psi  
Fluid Pressure ..... 500 - 900 psi  
Cap/Tip ..... .011 - .013

### HVLP:

Gun ..... Binks Mach 1  
Atomizing Air Pressure at the cap 9 psi  
Fluid Pressure ..... 12 psi  
Cap/Tip ..... 97AP Blue Max/94

### Cleanup:

Clean tools/equipment immediately after use with HAPS complying Lacquer Thinner, R7K320 or R7K322. Lacquer Thinner K120 or K22 may also be used, but are not HAPS compliant.

Follow manufacturer's safety recommendations when using any solvent.

### Performance Tests:

#### Household Chemicals Test

Using ANSI-KCMAA161.2000 test procedures, panels were cured by air drying and allowed to age 10 days at ambient conditions before testing. Tests were conducted on self-sealed (2 coat) finished panels at 2.0 mils total DFT. Materials were washed off with clear water after 24 hours and allowed to recover for 10 days then the finish was examined and the following results noted:

Vinegar .....	no effect
Lemon Juice .....	no effect
Orange Juice .....	no effect
Grape Juice .....	no effect
Tomato Catsup .....	no effect
Coffee @ 115° F .....	no effect
Olive Oil .....	no effect
100 Proof Alcohol .....	no effect
Water & Detergent .....	no effect
Mustard .....	no effect
Cold Checks 20 cycles .....	Pass
Edge Soak .....	Pass

## SPECIFICATIONS

### Product Limitations:

- This product **must** be catalyzed with Sher-Wood Hi-Bild PreCat Catalyst, V66V3, before use at a level of 2.3% (3.0 oz/gal). Complete cross-linking and film properties will not be attained without catalyzation. Product will typically be catalyzed before delivery to the customer.
- Catalyst must be added by the user or by the Sherwin-Williams outlet.
- This product should be used within 4 months after being catalyzed to obtain optimum properties. The catalyst causes a chemical reaction in the package and dissipates after 4 months and performance properties are downgraded. **Adding additional catalyst does not restore film properties.**
- Store at room temperature (under 80° F) after catalyzation. Higher temperatures will reduce the storage life.
- Self-seal or apply over Sher-Wood Vinyl Sealers, T67F3, T67F5 or T67F6 to meet KCMA requirements.
- To achieve maximum performance properties a minimum of 2 mils DFT is required.
- Total film thickness of systems must not exceed 4 mils DFT because heavier films may show cracking and checking tendencies.
- For interior use only.
- Sher-Wood Hi-Bild PreCat Catalyst, V66V3 is an acid. To prevent acid corrosion and pitting, all equipment should be made of stainless steel. Containers should be stainless steel or plastic.
- Do not catalyze with other acid catalysts because of fast reactivity and pot life issues.
- Maximum cure and chemical resistance is attained after 10 days air drying.
- Natural wood will change color by itself and clear wood finishes will not keep this from occurring.
- To maintain HAPS compliance, only reduce with HAPS compliant reducers.
- Sher-Wood Hi-Bild PreCat Lacquer will yellow over time. With wood tone stains, this yellowing actually makes a warmer, softer appearance. Where white stains, pickled finishes, or white basecoats are used, nitrocellulose lacquer should not be used because of the yellowing of the sealer and topcoat may be considered objectionable. For these applications, Sher-Wood Acrylic Conversion Coating is recommended.

## CAUTIONS

### FOR INDUSTRIAL SHOP APPLICATION

Thoroughly review product label and Material Safety Data Sheet (MSDS) for safety and cautions prior to using this product.

A Material Safety Data Sheet is available from your local Sherwin-Williams facility.

Please direct any questions or comments to your local Sherwin-Williams facility.

**Note:** Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.