



Industrial Wood Coatings

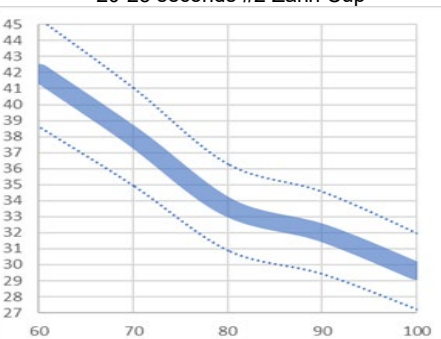
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SHER-WOOD® KEMVAR® Plus Surfacers

White..... E63W50
White..... E63W50S**

Clear..... E63C56
Clear..... E63C56S**

See Mixing Ratio for Catalyst Options

DESCRIPTION	CHARACTERISTICS	CHARACTERISTICS (cont)
<p>SHER-WOOD® KEMVAR® Surfacers is an acid catalyzed surfacer formulated to be used as a primer or sealer under Sher-Wood® KEMVAR® Plus Conversion Varnish or Sher-Wood® Water White Conversion Varnish.</p> <p>Advantages:</p> <ul style="list-style-type: none"> Meets the Federal HAPS rule for wood finishes as packaged** Easy sanding and fast drying Excellent holdout and build Excellent adhesion to a wide range of bare wood surfaces Versatile - may be applied using conventional, airless, air assisted airless or HVLP spray methods Very good edge filling on M/F which presealed with vinyl wash coat Meets KCMA performance properties when topcoated with Sher-Wood KemVar Plus or Sher-Wood Water White Conversion Varnish Available in a broad range of colors <p>VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.</p> <p>Air Quality Data (Theoretical):</p> <ul style="list-style-type: none"> Photochemically reactive Volatile Organic Compounds (VOC) as packager, maximum 3.7 lb/gal, 443 g/L Catalyzed 4.7% with V66V21 then reduced 35% with R7K310, maximum 4.49 lb/gal 540 g/L Volatile Hazardous Air Pollutants (VHAPS)* as packaged, maximum less than 0.8 lbs per pound of solids <p>*National Standards for Hazardous Air Pollutants (HAPS) Emissions for Wood Furniture Manufacturing Operations CFR40, Part 63, Subpart JJ</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility, or at www.paintdocs.com.</p> <p>**122 oz fill</p>	<p>Gloss: Flat Volume Solids: 49 ± 2% Package Viscosity: 20-25 seconds #2 Zahn Cup</p>  <p>The above chart is for information only and should not be used as product specifications.</p> <p>Recommended Film Thickness Mils Wet 3.0 - 6.0 Mils Dry 1.1 - 2.1</p> <p>Maximum DFT for Sher-Wood KemVar Plus Surfacers is 4.0 mils. Maximum DFT for Sher-Wood KemVar Plus Surfacers finished with Sher-Wood KemVar Plus White is 7.0 mils</p> <p>Spreading Rate (no application loss) catalyzed and reduced 270-515 sq ft/gal @ 1.1-2.1 mils DFT</p> <p>Drying (1.5 mils, 77°F, 50% RH): To Touch: 20-30 minutes To Handle: 20-30 minutes To Sand: 30-45 minutes To Recoat: 30 minutes Force Dry: 15 minutes at 120° F or 10 minutes at 150° F, to sand</p> <p>Flash Point: 20°F PMCC (continued in next column)</p> <p>Mixing Ratio: Catalyze 1 part Conversion Varnish 4.7% (6 oz/gal) V66V21 (by volume) Or 16% (20.5 oz/gal) V66V101 V66V102 V66V103 (by volume) Or 16% (20.5 oz/gal) V66V20005 V66V20006 V66V20007 (by volume)</p>	<p>Pot Life: 24 hours Package Life: 1 year, unopened</p> <p>SPECIFICATIONS</p> <p>Surface preparation</p> <p>Wood - New Work (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>Previously finished wood (interior only): Strip old finishes completely and remove all contaminants from the surface. Make sure surface is dry. Finish as new work</p> <p>Finishing System:</p> <ol style="list-style-type: none"> Apply 1 coat of catalyzed Surfacers at 3.0 - 6.0 mils wet. Allow to dry for sanding. A second coat of Surfacers may be applied after sanding if needed for additional filling. Sand again before topcoating. Sand with 220-280 grit paper and remove all sanding dust. If a wet look is desired, sand final primer coat with 500-600 grit paper. Topcoat with Sher-Wood KemVar Plus or Sher-Wood Water White Conversion Varnish. <p>Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.</p>

APPLICATION

Typical Setups

May be applied using:

Conventional Spray
Airless Spray
Air Assisted Airless
HVL

Reduction:

Reduce 25-50% with R7K310 Sher-Wood KEMVAR Solvent. Reduction with 35% R7K310 provides a ready to spray surfacer with these listed characteristics:

Weight Solids: 53.5%
Volume Solids: 35.3%
Viscosity #2 Zahn: 20-25 sec.
VOC per gal: 4.49 lb/gal = 540 gm/l

Cleanup:

Clean tools/equipment immediately after use with HAPS Compliant Lacquer Thinner R7K320. Lacquer Thinner R7K120 or R7K22 may also be used, but are not HAPS compliant.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS(cont)

Product Limitations Continued:

- Do not use Sher-Wood Catalyst V66V26. It will give much slower drying and cure.
- Do not exceed 2.0 mils dry film per coat because heavy films will result in slower drying and sanding times.
- Maximum DFT for Sher-Wood KemVar Plus Surfacers is 4.0 mils. Maximum DFT for Sher-Wood KemVar Plus Surfacers finished with Sher-Wood KemVar Plus Conversion Varnish is 7.0 mils.
- Do not use in recirculating systems such as flocoaters or curtain coaters because of accelerated cure due to aeration. Recirculating paint lines are acceptable.
- Working pot life is 24 hours maximum at 77°F. While catalyzed surfacer remains a low viscosity liquid beyond 24 hours, it should not be used beyond pot life because a chemical reaction is taking place. The resultant film may have inferior cure and cross-linking and a tendency for long-term cracking. At higher temperatures, working pot life is much shorter.
- To extend the pot life at the end of the day, add 300-400% of uncatalyzed material. Add catalyst based only on the uncatalyzed portion when ready to use the next day. Refrigeration also extends the working pot life.
- Sand within 4 hours of topcoating to ensure optimum intercoat adhesion properties. Routed MPF must be pre-sealed with Vinyl Sealer reduced 50-100% prior to using KemVar Plus Surfacers.
- **The Clear Surfacers are a Blending Clear intended for custom color intermixing. It is not recommended to be used as a standalone clear basecoat.**
- To maintain HAPS compliance only reduce with HAPS compliant reducers.
- For interior use only.
- Maximum colorant level is 6 ounces per gallon with Phoenix®, OptiColor® XP or GIS colorants.

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CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

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

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.paintdocs.com.

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

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SPECIFICATIONS

Product Limitations:

- Sher-Wood KemVar Plus Surfacers must be catalyzed as shown for cure.
- Paint temperature and air temperature must be above 70°F during application and cure to ensure acceptable coating properties.
- Do not over-catalyze, it may cause cracking, retard drying and shorten working pot life.
- Apply directly to bare, finish sanded wood surfaces only.
- The catalysts used with this product are acids. To prevent acid corrosion and pitting, all equipment should be made of stainless steel or plastic.

(continued in next column)