



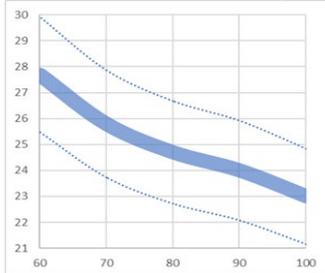
**SHERWIN  
WILLIAMS.**

## SHER-WOOD® Precat Primer Surfacer

White.....E63W30

Catalyst.....V66V3

Custom Blend.....E63PX Series

<b><u>DESCRIPTION</u></b>	<b><u>CHARACTERISTICS</u></b>	<b><u>SPECIFICATIONS</u></b>
<p><b>SHER-WOOD® Precat Primer Surfacer</b> is a fast drying, high performance conversion primer surfacer for the general wood finishing market. After catalyzation, it provides a 3 month pot life as a white pre-cat primer surfacer.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• Meets KCMA performance properties when top-coated with Sher-Wood White Hi-Bild Precat Lacquer or Sher-Wood Pigmented Conversion Varnish.</li> <li>• HAPS compliant as packaged*</li> <li>• White Precat primer surfacer with 3 months working pot life</li> <li>• Very fast dry to sand and pack</li> <li>• Ready to spray. No reduction needed</li> <li>• Excellent filling properties suitable for filling MDF</li> <li>• Good flexibility - passes 20 cold check cycles</li> <li>• Versatile application - may be applied by conventional, airless, air-assisted airless and HVLP spray methods</li> <li>• Ideal for kitchen cabinets, vanities, chairs, office furniture, household furniture, novelties, and a wide range of interior wood products</li> </ul> <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 <a href="http://www.paintdocs.com">www.paintdocs.com</a>.</p>	<p><b>Volume Solids:</b> 26 ± 1%</p> <p><b>Weight Solids:</b> 44.5 ± 1%</p> <p><b>Viscosity:</b> 23-27 sec #4 Ford cup</p>  <p><i>The above chart is for information only and should not be used as product specifications</i></p> <p><b>Recommended film thickness:</b> Mils Wet 3.0 - 5.0 Mils Dry 0.8 - 1.3</p> <p><b>Spreading Rate</b> (no application loss) 305-535 sq ft/gal @ 0.8-1.3 mils DFT</p> <p><b>Drying</b> (77°F, 50% RH): To Touch: 10 minutes To Handle: 20 minutes To Sand: 20-30 minutes To Recoat: no critical recoat To Pack: Overnight Force Dry: 5 minutes at 110- 140°F</p> <p><b>Flash Point:</b> 4°F Pensky-Martens Closed Cup</p> <p><b>Mixing Ratio:</b> 1 gallon Primer Surfacer 4.0 oz Catalyst, V66V3</p> <p><b>Pot Life:</b> 3 months <b>Package Life:</b> 2 years, unopened</p> <p><b>Air Quality Data:</b></p> <ul style="list-style-type: none"> <li>• Non-photochemically reactive</li> <li>• Volatile Organic Compounds (VOC) theoretical as packaged, maximum less exempt solvents: 5.17 lb/gal, 620 g/L</li> <li>• Hazardous Air Pollutants (HAPS) as packaged maximum: 0.0 lb/lb of solids</li> </ul>	<p><b>Surface preparation:</b></p> <p><b>Wood - New Work</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>Previously finished wood</b> (interior only): Strip old finishes completely and remove all contaminants from the surface. Make sure surface is dry. Finish as new work.</p> <p><b>Testing:</b> 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, compatability and performance prior to full scale application.</p>

## **APPLICATION**

### Typical Setups

#### **May be applied by:**

Conventional Spray  
Airless Spray  
Air Assisted Airless  
HVLP

**Reduce** as needed for application up to 20% with R6K18 (Butyl Acetate) or R7K320 (HAPS Compliant Lacquer Thinner)

**Retard** as needed for application with R6K30 (MAK) or R6K35 (EEP) up to 5%

#### **Typical Setups**

##### **Conventional Spray:**

Air Pressure .....40 – 50 psi  
Fluid Pressure..... 8 – 12 psi

##### **Airless Spray:**

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

##### **Air Assisted Airless:**

Air Assist Pressure..... 15 - 25 psi  
Fluid Pressure..... 500 - 900 psi  
Tip..... 011" - .013"

##### **HVLP**

Gun.....Binks Mach 1  
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 R7K320 HAPS Compliant Lacquer Thinner

Follow manufacturer's safety recommendations when using any solvent.

## **ADDITIONAL INFORMATION**

- This product **must** be catalyzed with Sher-Wood® Precat Catalyst V66V3 before use at a level of 3% (4.0 ounces per gallon). Product will typically be catalyzed before delivery to the customer. Complete cross-linking and film properties will not be attained without catalyzation. Catalyst must be added by the user or by the Sherwin-Williams outlet.
- This product should be used within 3 months after being catalyzed to obtain optimum properties. The catalyst causes a chemical reaction in the package and dissipates after 3 months, performance properties are downgraded. **Adding additional catalyst does not restore film properties.**
- Store at room temperature (under 80F) after catalyzation. Higher temperatures will reduce the pot life.
- To achieve maximum performance properties a minimum of 2 mils DFT is required.
- Total film thickness of systems must not exceed 4.0 mils dry film because heavier films may show cracking and checking tendencies.
- For interior use only.
- Sher-Wood® 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 problems.
- Maximum cure and chemical resistance is attained after 10 days air-drying.
- To maintain HAPS compliance, only reduce with HAPS compliant reducers.
- Can be tinted with OptiColor® XP colorants up to 6 ounces per gallon. or GIS colorants up to 4 oz per gallon

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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](http://www.paintdocs.com).

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

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