



# SHER-WOOD® F3 Precat Primer Surfacer

White ..... E63W330  
 Custom Blend..... E63GX Series  
 Catalyst ..... V66V22

DESCRIPTION	CHARACTERISTICS	SPECIFICATIONS
<p><b>SHER-WOOD® F3 Precat Primer Surfacer</b> is an advanced formaldehyde free primer surfacer developed for coating wood furniture and other interior wood products. After catalyzation, it provides a four month pot life.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>Formaldehyde free coating both during and following application</li> <li>Very fast dry to sanding and packing like nitrocellulose lacquer</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> <li>UL GREENGUARD Gold Certified for low chemical emissions</li> </ul> <div data-bbox="272 1266 479 1535"> </div> <p><b>Air Quality Data:</b></p> <ul style="list-style-type: none"> <li>Non-Photochemically Reactive</li> <li>Volatile Organic Compounds (VOC) theoretical, maximum, less exempt solvents as packaged: 4.98 lb/gal, 596 g/l Catalyzed and reduced (R6K18 at 20%): 5.36 lb/gal, 642 g/L</li> <li>Volatile Hazardous Air Pollutants (VHAPS) as packaged: No reportable VHAPS</li> </ul> <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> 26.5 ± 1%</p> <p><b>Weight Solids:</b> 44.5 ± 1%</p> <p><b>Viscosity:</b> 23 – 27 Sec #2 Zahn Cup</p> <div data-bbox="613 793 1052 1123"> </div> <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></p> <p>Mils Wet 3.0 – 5.0    Mils Dry 0.8 – 1.3    Maximum dry film thickness for total system is 3.5 to 4.0 dry mils.</p> <p><b>Spreading Rate</b> (No Application Loss)    330-530 sq ft/gal @ 0.8 – 1.3 mils DFT</p> <p><b>Drying</b> (77°F, 50% RH):</p> <p>To Touch: 10 min.    To Handle: 30 min.    To Sand: 30 - 40 min.    To Recoat: No Critical Recoat    To Pack: Overnight    Force Dry: 10 minutes @ 110 - 140°F.</p> <p><b>Flash Point:</b> 24°F PMCC</p> <p><b>Mixing Ratio:</b>    1 gallon Primer Surfacer    0.8% by volume (1 oz. / gal) Catalyst, V66V22</p> <p><b>Pot Life:</b> 4 months</p> <p><b>Package Life:</b> 2 years, Unopened</p>	<p><b>Surface preparation</b></p> <p><b>Wood - New Work</b> (interior only):</p> <p>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):</p> <p>Strip old finishes completely and remove all contaminants from the surface. Make sure surface is dry. Finish as new work</p> <p><b>Wood Finishing System:</b>  <b>THIS PRODUCT MUST BE CATALYZED</b></p> <ol style="list-style-type: none"> <li>Prime - Spray a full coat (3-5 wet mils) of Sher-Wood F3 Precat Primer Surfacer E63W330. Air dry for at least 30 minutes.</li> <li>Sand - Sand primer coat with 240-320 grit sand paper or equivalent. Remove sanding dust.</li> <li>Topcoat - Spray a full wet coat (3-5 wet mils) of Sher-Wood F3 Hi-Bild Precat White Lacquer. Air dry 40-50 minutes.</li> <li>For more depth and better appearance, apply a second coat of Sher-Wood F3 Hi-Bild Precat White Lacquer.</li> </ol> <p><b>Do not exceed 4.0 mils DFT for the total system.</b></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, compatibility and performance prior to full scale application.</p>

## **APPLICATION**

### Typical Setups

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

Conventional Spray  
Airless Spray  
Air Assisted Airless  
HVLV

#### **Reduction:**

As needed for application up to 20% with Methyl Acetate to maintain VOC levels. Butyl Acetate (R6K18) or HAPS Compliant Lacquer Thinner (R7K320) may be used but will increase VOC emissions.

#### **Retard:**

As needed with MAK (R6K30) 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"

##### **HVLV:**

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

#### **Cleanup:**

Clean tools/equipment immediately after use with MEK (R6K10) or HAPS Compliant Lacquer Thinner (R7K320).

Follow manufacturer's safety recommendations when using any solvent.

#### **Performance Tests**

**Cold Check Resistance** .....20 cycles

#### **Print Resistance:**

No print 2.0 mils DFT, 16 hours air dry, at 2 psi at 77° F., in direct contact with 8 oz. duck cloth.

## **ADDITIONAL INFORMATION**

- This product must be catalyzed with Sher-Wood® Precat Catalyst V66V22 before use at a level of 0.8% by volume, (1.0 ounces per gallon). Product will typically be catalyzed before delivery to the customer. Complete crosslinking and film properties will not be obtained without catalyzation. Catalyst must be added by the user or by the Sherwin-Williams facility.
- 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 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 V66V22 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.
- May be tinted with OptiColor® XP or GIS colorants up to 4 oz/gal. **Do not exceed 4 oz/gal of colorants.** Colorant must be added under agitation and thoroughly mixed before evaluating color. **Do not use any other colorants.** The use of other colorant systems may result in incompatibility and color float.

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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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