



SHER-WOOD® F3 KEMVAR® Plus Surfacer

White.....E63W350
Clear.....E63C356
Custom Blend.....E63FX Series
Catalyst.....V66V26

DESCRIPTION

SHER-WOOD® F3 KEMVAR® Plus Surfacer is a formaldehyde free pigmented surfacer designed for coating interior woodworking. This acid cure surfacer is suitable for hardwood, softwood, particle board, MDF and veneer surfaces.

Advantages:

- Formaldehyde free coating at application and on cured parts
- Five day pot life - Less material handling and cleanup
- Full range of colors achievable by adding Opti-Color® XP or GIS colorants up to 6 ounces per gallon.
- Ready to apply following catalyzation, no reduction required
- Meets KCMA test requirements for finishes when used under F3 KEMVAR Plus Conversion Varnish
- High solids and build
- Excellent and mar resistance
- Good resistance to moisture and household chemicals
- Ideal for kitchen cabinets, vanities, office furniture, household furniture, and a wide range of interior wood products
- UL GREENGUARD Gold Certified for low chemical emissions

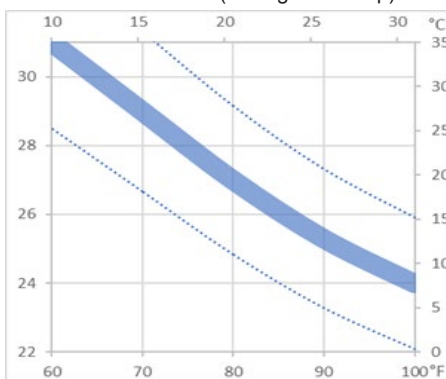


CHARACTERISTICS

Gloss: 0-5 units

Volume Solids: 33.0 ± 2% may vary by color

Package Viscosity:
24-29 seconds(#2 sig Zahn Cup)



The above chart is for information only and should not be used as product specifications

Catalyzed / Reduced Viscosity Target:
19-23 (#2 Sig Zahn Cup)

Recommended film thickness:
Mils Wet 3.0 - 4.0
Mils Dry 1.2 - 2.0

Spreading Rate (no application loss) Catalyzed
249-468 sq ft/gal @ 1.2-2.0 mils DFT

Drying (1.5 mils dft, 77°F, 50% RH):
To Touch: 15-20 minutes
To Handle: 20-30 minutes
To Sand: 45-60 minutes
To Recoat: 45-60 minutes
Force Dry: 30 minutes at 120°F or 10 minutes at 150°F

Flash Point: 20° F PMCC

Mixing Ratio:
1 part KEMVAR Plus Surfacer 5.0% (by volume) Catalyst V66V26

Pot Life: 120 hours/5 days

Package Life: 1 year, unopened

CHARACTERISTICS (cont)

Air Quality Data:

- Non-photochemically reactive
- Volatile Organic Compounds (VOC) Theoretical as packaged, maximum less exempt solvents: 4.91 lb/gal, 589g/L
- Volatile Hazardous Air Pollutants (VHAPS) as packaged: <0.80 lb/lb of solids

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com.

SPECIFICATIONS

Surface preparation

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%.

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

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.

APPLICATION

Typical Setups

Conventional Spray:

Air Pressure40-50 psi
Fluid Pressure 6-8 psi

Airless Spray:

Pressure 1200-1800 psi
Tip011-.015"

Air Assisted Airless:

Assist Air Pressure..... 10-25 psi
Fluid Pressure 400-800 psi
Cap/Tip011-.015"

HVLP:

Air Pressure 9 psi
Fluid Pressure 5-10 psi
Tip047

Cleanup:

Clean tools/equipment immediately after use with Butyl Acetate (R6K18) or MAK (R6K30).

Follow manufacturer's safety recommendations when using any solvent.

KCMA Test Performance:

Cold Check Resistance:

Passes 20 cycles (KCMA spec is 5 cycles)

Moisture Resistance (KCMA test when topcoated with Sher-Wood F3 KEMVAR Plus Conversion Varnish):

Pass 24 hours edge immersion in water/detergent solution at room temperature.

Print Resistance No print
Pigmented Varnish was air dried for 24 hours at room temperature (77°F) on maple at 3.0 mils dry film. Tested for 18 hours at 77°F at 1 psi in direct contact with 8 ounce duck cloth.

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ADDITIONAL INFORMATION

- Sher-Wood® F3 KEMVAR Plus Surfacer must be catalyzed 5.0% (by volume) with Catalyst V66V26 for cure. Do not over-catalyze. Higher catalyst levels may cause cracking over time. Higher catalyst levels affect crosslinking rates and film properties.
- When using F3 products, all equipment must be "tank clean" free of all other formaldehyde containing materials to maintain its formaldehyde free properties.
- Temperatures must be above 70°F during application and cure to ensure acceptable coating properties. Coatings cured at lower temperatures are prone to cracking, checking, and brittleness.
- Do not apply over nitrocellulose lacquer sealers as they may cause wrinkling or long-term checking or cracking.
- Catalyst V66V26 is an acid. To prevent acid corrosion and pitting, all equipment should be made of stainless steel. Containers and piping should be stainless steel or plastic. Acid reacting with iron or steel will cause a discoloration of conversion varnish.
- Maximum film thickness of the total system (including topcoat) must not exceed 4 mils dry film because heavier films may cause cracking.
- Do not use in recirculating systems such as flowcoaters or curtain coaters because of accelerated cure due to aeration. Recirculating paint lines are okay.
- Working pot life is 120 hours (5 days), maximum at 77°F. While F3 KEMVAR Plus Surfacer remains a low viscosity liquid beyond 120 hours, it should not be used beyond pot life because a chemical reaction is taking place. The resultant film may have inferior cure and crosslinking and a tendency for long term cold checking. At higher temperatures working pot life is much shorter.
- To maintain HAPS compliance only reduce with HAPS compliant reducers.
- To extend the pot life at the end of the 5 days, add 100% of uncatalyzed material. Add catalyst based only on the uncatalyzed portion when ready to use the next day.
- Do not blend Sher-Wood F3 KemVar Plus Surfacer with other surfacer qualities because it will no longer be formaldehyde free.
- Maximum colorant level is 6 ounces per gallon with OptiColor XP or GIS colorants.

ADDITIONAL INFORMATION

- Retard 1-3% with 2-Butoxyethanol (R6K25) as required.
- Reduce 3-5% to adjust drying or build with butyl acetate, or MAK.
- Do not exceed 2.0 mils dry film per coat because heavy wet films may cause film surface imperfections and slow dry time.
- For full sharp gloss appearance, sand intermediate coats with very fine (400- 600) grit paper to prevent telegraphing of sand marks.
- For interior use only.

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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