



Industrial Wood Coatings

CC-F35

**SHERWIN
WILLIAMS.**

SHER-WOOD® Vinyl Basecoat System Monochromatic Intermix System

Black..... P63B1	Blue P63L4	Quinacridone Red ... P63R7	Brite Yellow.....P63Y10
Orange..... P63E2	Burnt Umber..... P63N5	Red Oxide P63R8	Ferrite Yellow.....P63Y11
Green..... P63G3		White P63W9	

DESCRIPTION

SHER-WOOD® Vinyl Basecoat System is a HAPS* compliant monochromatic intermix system designed for the custom blending of spray stains, ground coats, basecoats, toners, shading stains, and edging lacquers. They are extremely versatile and can be top-coated with all Sher-Wood solvent-based wood finishing clears.

Advantages:

- Meets the federal HAPS* rule for wood finishes
- High strength concentrates for full color and opacity range from transparent stains to full hiding basecoats
- Clean colors attain rich wood tones
- Excellent clarity to highlight wood grain
- Excellent light fastness and non-bleeding
- Fast drying
- Vinyl resin based for best film properties
- Can be top-coated with all Sher-Wood solvent-based wood finishing clears
- May be blended with Sher-Wood Vinyl Sealers T67F3, T67F5 and P63W2
- Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303.

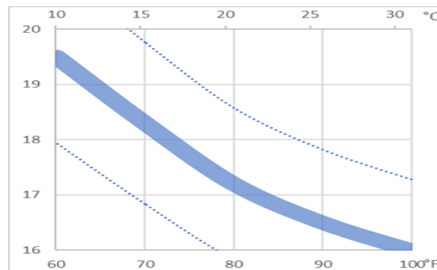
*National Standards for Hazardous Air Pollutants (HAPS) Emissions for Wood Furniture Manufacturing Operations CFR40, Part 63, Subpart JJ

CHARACTERISTICS

Gloss: Low Gloss

Volume Solids: 8 - 17± 1%

Viscosity:
18-41 seconds #2 Zahn Cup
10-34 seconds #4 Ford Cup



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

Drying (77°F, 50% RH):
as a spray stain or toner:
To Touch: 5 minutes
To Recoat: 10 minutes

as a basecoat or ground coat

To Touch: 15 minutes
To Handle: 30 minutes
To Recoat: 30 minutes
Force Dry: 15 minutes at 120°F

Flash Point: 22°F Pinsky Martens
Closed Cup

Package Life: 2 years, unopened

Air Quality Data: (Theoretical)

- Non-photochemically reactive
- Volatile Organic Compounds (VOC) as packaged, maximum 6.34 lb/gal, 760 g/L
- Hazardous Air Pollutants (HAPS) as packaged less than 0.4 lbs per pound 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.

Catalyzation of P63 Series Basecoats/ Groundcoats:

P63 Series Basecoats and Ground-coats must be catalyzed when the topcoat is a catalyzed product - Sher-Wood Conversion Varnish, Catalyzed Lacquers or Catalyzed Vinyl.

Catalyzing the basecoat will give improved inter-coat adhesion and resistance to wrinkling, lifting, and critical recoat with catalyzed topcoats. The basecoats should be catalyzed 2% with Sher-Wood Super KemVar Catalyst V66V26. Pot life is 24 hours at room temperature. Higher temperature, humidity or aeration will shorten working pot-life. To extend use life at the end of the day, add 300% of uncatalyzed material. Add catalyst based only on the un-catalyzed portion when ready to use the next day. Refrigeration also extends working pot life.

Do not add catalyst when using as spray stain or toner.

SPECIFICATIONS

Pigmented Spray Stains

Pigmented Spray Stains with excellent clarity, penetration and grain definition can be blended as follows:

P63 Basecoat Mix 5-10 parts
HAPS Free Reducer R7K305..... 85-80 parts
MAK - R6K3010 parts
Best grain definition is obtained by wetter application with a slow evaporating solvent such as MAK. Allow to flash off and dry 5-10 minutes before going to the next finishing step.

Pigmented/Dye Spray Stains

P63 Basecoats and Sher-Wood Universal Dye Stain Concentrates may be blended to make spray stains giving more penetration and background staining as follows:
P63 Basecoat Mix5 parts
S61 Universal Dye Stain Concentrate.....5 parts
HAPS Free Reducer R7K30590 parts
Allow to flash off 5-10 minutes and apply a wash coat or sealer to lock in color.

Toners

Toners can be made by diluting the P63 Basecoat color with R7K305 and spraying to desired color and appearance. A starting formula is
P63 Basecoat Mix 10 - 20 parts
HAPS Free Reducer R7K30580 - 90 parts

Adjust color concentration to get desired shade. After the toner has flashed off, continue the finishing process with sealers and topcoats.

Basecoats/Groundcoats

Basecoats are build coats that provide full hiding on the wood surface. They are normally applied without reduction. Spray a full wet coat of 5-6 mils wet. Allow to flash off. If needed, apply another full wet coat for hiding. Allow the basecoat to dry for 30 minutes. Then sand thoroughly and apply the topcoats.

Groundcoats are full hiding coats that penetrate in the wood and do not provide film build. They are applied at very low viscosity. For ground coats, reduce approximately 50% with HAPS Free Reducer R7K305 and spray a full wet coat to obtain hiding. A full color range of basecoats and groundcoats can be obtained by blending P63 basecoats with Sher-Wood Vinyl Sealer to obtain desired color and opacity.

To get adequate adhesion in basecoat/groundcoat, a minimum of 25% by volume of vinyl sealer (T67F3, T67F5, P63W2) must be used. Failure to add the sealer could result in poor adhesion.

P63 Basecoat Mix 50-75 parts
Vinyl Sealer 50-25 parts

APPLICATION

Typical Setups

Reducers

The P63 Vinyl Basecoat series requires a very strong solvent blend. Do not use generic lacquer thinners as they may cause kick out. R7K22 is designed to give optimum properties in this system. For faster drying, Acetone R6K9 may be used. If a retarder solvent is needed, use small quantities of MAK R6K30.

To maintain HAPS compliance you must use R7K305 to make toners, Spray Stains and Pigmented/Dye Stains. R7K22 may be used for general reduction. However, if you make a new product, not just a reduction, you must use R7K305 to maintain HAPS Compliance.

May be applied using:

Conventional Spray
Airless Spray
Air Assisted Airless
HVLP

Cleanup:

Clean tools/equipment immediately after use with Lacquer Thinner R7K22.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- Agitation is recommended to maintain uniform color.
- Agitate thoroughly before blending bases or use.
- Final color is influenced by substrate variations as well as topcoat gloss quality.
- Customer should pretest system on his substrate under shop conditions.
- Not recommended for exterior use
- Do not mix P63 Bases with lacquer or vanishes. They are incompatible.
- Do not use R7K320 or similar lacquer thinners. They are not strong enough. Use R7K22 or R7K305 only.
- Do not catalyze with Sher-Wood Kem-Var Catalyst V66V21 because it has much shorter pot life and may affect performance properties of the system.
- Do not use catalyzed P63 Basecoats under non-catalyzed topcoats because of potential inter-coat adhesion problems.

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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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