



# Industrial Wood Coatings

CC-PC11

## PROCRAFT™ 9300 Series Clear Polyurethane Topcoat

9310 Clear Matte ..... T73F10  
9330 Clear Satin ..... T73F30  
9390 Clear Gloss ..... T73C90  
9310 Catalyst..... V66V12  
9330 + 9390 Catalyst..... V66V13

DESCRIPTION	CHARACTERISTICS	SPECIFICATIONS																										
<p><b>PROCRAFT™ 9300 Series Clear Polyurethane Topcoat Polyurethane</b> is a self-sealing 2K polyurethane coating system for the general interior wood finishing market. Designed for industrial spray shop application, this polyurethane sealer/finish has been modified for optimal dry times. PROCRAFT™ 9300 Series is designed for end use applications such as residential and commercial wood furniture, kitchen cabinets, architectural woodworking and a variety of interior wood products.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"><li>• Good build and leveling</li><li>• Very fast to sand and recoat</li><li>• Alternative to other catalyzed performance coatings without concern of formaldehyde</li><li>• Good resistance to household chemicals and moisture</li><li>• Good flexibility - passes 20 cold check cycles</li><li>• Self-sealing. Same product as sealer and finish in a 2-3 coat process</li></ul> <p><b>Air Quality Data (Theoretical):</b></p> <ul style="list-style-type: none"><li>• Non-photochemically reactive</li><li>• Volatile Organic Compounds (VOC) as packaged, maximum, less exempt solvents 5.83 lb/gal, 698 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>Gloss (measured on black glass @ 60° angle):</b></p> <table><tr><td>T73F10</td><td>8-12 Units</td></tr><tr><td>T73F30</td><td>27-33 Units</td></tr><tr><td>T73C90</td><td>85+ Units</td></tr></table> <p><b>Volume Solids (packaged):</b> 20-21% ± 1%</p> <p><b>Viscosity (catalyzed):</b></p> <table><tr><td>T73F10</td><td>17-24 secs. Zahn #3</td></tr><tr><td>T73F30 + C90</td><td>14-24 secs. Zahn #2</td></tr></table> <div></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 per coat:</b></p> <table><tr><td>Mils Wet</td><td>4.0 – 5.0</td></tr><tr><td>Mils Dry</td><td>0.8 – 1.0</td></tr></table> <p><b>Spreading Rate</b> (No Application Loss) 320 sq ft/gal @ 1.0 mils DFT</p> <p><b>Drying (77°F, 50% RH):</b></p> <table><tr><td>Dust Free:</td><td>10 min.</td></tr><tr><td>To Touch:</td><td>15-20 min. To</td></tr><tr><td>Handle:</td><td>25-30 min. To</td></tr><tr><td>Sand:</td><td>30-45 min.</td></tr><tr><td>To Pack:</td><td>Overnight</td></tr><tr><td>Force Dry:</td><td>10 min. flash-off, then 20 min. @ 120-140°F.</td></tr></table> <p><b>Flash Point:</b> 25 °FPMCC</p> <p><b>Mixing Ratio (Matte):</b> 4 parts T73F10 : 1 part V66V12 Pot Life: 4 hours</p> <p><b>Mixing Ratio (Satin + Gloss):</b> 1 part T73F30 or C90 : 1 part V66V13 Pot Life: 8 hours</p> <p><b>Package Life:</b> 12 months unopened</p>	T73F10	8-12 Units	T73F30	27-33 Units	T73C90	85+ Units	T73F10	17-24 secs. Zahn #3	T73F30 + C90	14-24 secs. Zahn #2	Mils Wet	4.0 – 5.0	Mils Dry	0.8 – 1.0	Dust Free:	10 min.	To Touch:	15-20 min. To	Handle:	25-30 min. To	Sand:	30-45 min.	To Pack:	Overnight	Force Dry:	10 min. flash-off, then 20 min. @ 120-140°F.	<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>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>
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## APPLICATION

### Typical Setups

#### May be applied by:

Conventional Spray  
Airless Spray  
Air Assisted Airless  
HVLP  
LVMP

#### Reduce:

As needed for application up to 20% with R6K18 (Butyl Acetate).

#### Retard:

In high humidity environments, reduce up to 5% using MAK (R6K30).

#### Conventional Spray:

Air Pressure..... 40– 50 psi  
Fluid Pressure ..... 8 – 12 psi  
Fluid Tip.....042-.055

#### Air Assisted Airless:

Air Assist Pressure ..... 15 - 25 psi  
Fluid Pressure ..... 750 - 1000 psi  
Tip .....009" - .011"

#### HVLP:

Air Pressure at the cap ..... 9 psi  
Fluid Pressure ..... 12 psi Tip  
.....039-.055

#### LVMP

Air Pressure..... 23– 25 psi  
Fluid Pressure ..... 7 – 9 psi  
Fluid Tip.....039-.055

#### Cleanup:

Clean tools/equipment immediately after use with R6K10 MEK or R7K320 HAPS Compliant Lacquer Thinner. Follow manufacturer's safety recommendations when using any solvent.

## ADDITIONAL INFORMATION

- For interior use only.
- This product must be catalyzed before use. T73F10 uses catalyst V66V12 at a 4:1 ratio. T73F30 and T73C90 use catalyst V66V13 at a 1:1 ratio. See first page for pot-life information. Complete crosslinking and film properties will not be attained without catalyzation. Catalyst must be added by the user.
- Store at room temperature (under 80°F) after catalyzation. Higher temperatures will reduce the pot-life.
- Maximum cure and chemical resistance is attained after 14 days air-drying.
- To achieve maximum performance properties a minimum of 3 mils DFT for the total system is required
- Total film thickness of systems must not exceed 6.0 mils dry film because heavier films may show cracking and checking tendencies.
- To maintain HAPS compliance, only reduce with HAPS compliant reducers.
- Due to inherent yellowing characteristics, this coating may not be suitable for use over white or pastel colored stains or base coats.
- For applications requiring a glaze, use SHER-WOOD® KEMVAR Glaze. Refer to corresponding data sheet (CC-F61) for application details.

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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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DISCONTINUED