

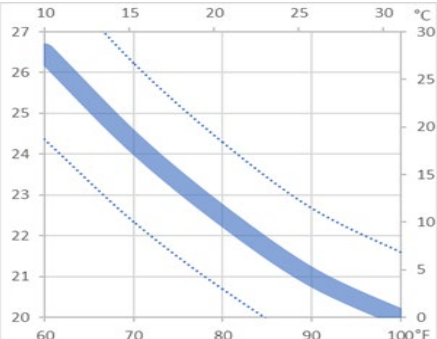


Industrial Wood Coatings

CC-PC1

PROCRAFT™ 275 White Precat Lacquer

Matte White T77W01015
Satin White T77W03040
Semi-Gloss White..... T77W06065

DESCRIPTION	CHARACTERISTICS	SURFACE PREPARATION
<p>PROCRAFT™ 275 White Precat Lacquers are pigmented nitrocellulose topcoats that are catalyzed at the manufacturing site providing a 12 month shelf- life. This pre-catalyzed lacquer coating is designed for self-sealing application for use on interior wood residential furniture and a wide variety of interior architectural woodworking products.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Quick build • Very good sanding characteristics • Catalyzed at manufacturing plant • Can be tinted up to 4 oz./gal using OptiColor® XP or GIS colorants. • Ready-to-Spray • Dry to touch in 10-15 minutes • Less than 2.3 lb/gal, 275 g/L VOC, less exempt solvents as per CFR 59.406* <p>Air Quality Data:</p> <ul style="list-style-type: none"> • Non-photochemically reactive • Volatile Organic Compounds (VOC) theoretical as packaged, maximum less exempt solvents: 2.02 lb/gal, 242 g/L • Volatile Hazardous Air Pollutants (VHAPS) as packaged, no reportable VHAPS <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com.</p> <p>*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.</p>	<p>Gloss @ 60° angle on glass:</p> <p>Matte10 -15 units Satin33 - 40 units Semi-Gloss60 - 65 units</p> <p>Volume Solids: 24.1% ± 1% Weight Solids: 34.3% ± 1%</p> <p>Viscosity (77°F, 50% RH): 22-26 seconds #2 Zahn</p>  <p><i>The above chart is for information only and should not be used as product specifications</i></p> <p>Recommended film thickness:</p> <p>Mils Wet 4.0 5.0 Mils Dry 1.0 - 1.2</p> <p>Spreading Rate (no application loss) 390 sq ft/gal @ 1.0 mils DFT</p> <p>Drying (77°F, 50% RH):</p> <p>To Touch: 10-15 minutes To Handle: 15-20 minutes To Sand: 50-60 minutes To Recoat: 50-60 minutes To Pack: Overnight Force Dry: Flash 5 minutes, then 10 minutes at 120°F</p> <p>Good air movement and humidity control are necessary for proper drying.</p> <p>Flash Point: -1°F PMCC</p> <p>Package Life: 1 year unopened</p>	<p>WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority.</p> <p>Wood—Interior only</p> <p>All finishing lumber shall be stored on the premises in dry, warm rooms to prevent absorption of moisture, shrinkage, and roughening of the wood. All surfaces shall be sanded smooth, with the grain, and never across it. 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%. Surface blemishes shall be corrected and the room cleaned of dust before proceeding with finishing coats. Finishes shall be lightly sanded between coats.</p> <p>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.</p>

APPLICATION

Typical Setups

For optimal results, it is recommended to apply this product at room temperature. Surface and ambient temperatures must be above 50°F at the time of application.

May be applied by:

Conventional Spray
Air Assisted Airless
Airless Spray HVLP

Conventional Spray:

Air Pressure..... 35-45 psi
Fluid Pressure 8-10 psi
Cap/Tip047 (1.2mm) -.063" (1.6mm)
Air Cap 11-C

Air Assisted Airless:

Air Pressure..... 15-20 psi
Fluid Pressure500-900 psi
Cap/Tip..... .009" - .013"

Airless:

Fluid Pressure1500-1800 psi
Cap/Tip......011" - .013"

HVLP:

Air Pressure at inlet 22 psi max Air
Cap Pressure 6-8 psi
Fluid Pressure 6-8 psi
Cap/Tip.....507

Reducer: Typically not needed, but can reduce with Acetone (R6K9) as needed.

Retarder: Oxsol

Cleanup:

Clean tools/equipment immediately after use with Acetone, R6K9. Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

- For interior use only.
- Agitate before and during use.
- It is recommended to apply a minimum of 2 mils dry film thickness.
- Total film thickness of system must not exceed 4.0 mils dry film because heavier films may show cracking and checking tendencies.
- This nitrocellulose quality will show yellowing upon aging, especially in whites. Topcoating with clear wood finish lacquers may cause unacceptable yellowing over time.
- PROCRAFT™ 275 White Precat Lacquer contains an acid. To prevent acid corrosion and pitting, all equipment should be made of stainless steel. Containers should be stainless steel or plastic.
- Can be tinted up to 4 ounces per gallon using OptiColor® XP or GIS colorant. To avoid settling, it is recommended to store at temperatures ranging from 40° F and 100°F.

WOOD FINISHING SYSTEM:

Primer - Apply PROCRAFT™ 275 White Precat Lacquer at 4-5 mils wet. Air dry for 50 minutes with good air movement.

Sand - Sand with 320-400 grit sandpaper and thoroughly remove sanding dust.

Topcoat - Apply second coat of PRO- CRAFT™ 275 White Precat Lacquer at 4-5 mils wet. Air dry for 50 minutes with good air movement.

Topcoat - For more build or depth, apply an additional coat at 4-5 mils wet. **Maximum dry film thickness of the system should not exceed 4.0 mils.**

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CAUTIONS

FOR PROFESSIONAL USE 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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