



## SHERWIN WILLIAMS

# SHER-WOOD® F3 Hi-Bild™ Precat Lacquer

MRE .....T85F357  
 DRE.....T85F358  
 Custom Blend .....T85XX Series  
 Catalyst .....V66V26

### DESCRIPTION

**SHER-WOOD® F3 Hi-Bild™ Precat Lacquer** is an advanced formaldehyde free catalyzed topcoat formulation developed for coating wood furniture and other interior wood products.

#### Advantages:

- Formaldehyde free coating at application, during and following curing
- Self-sealing system
- Good vertical hang characteristics
- Meets KCMA test requirements for finishes when properly applied
- Ready to apply following catalyzation, no reduction required
- Contains U.V. Absorber for added wood protection
- UL GREENGUARD Gold Certified for low chemical emissions



#### Air Quality Data:

- Non-photochemically reactive
- Volatile Organic Compounds (VOC) theoretical, as packaged, maximum, less exempt solvents: 5.13 lb/gal, 614 g/L
- Volatile Organic Compounds (VOC) theoretical, catalyzed and reduced (R6K18 at 5% by volume) maximum, less exempt solvents: 5.25 lb/gal, 629 g/L
- Volatile Hazardous Air Pollutants (VHAPS) catalyzed and reduced: No reportable VHAPS

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at [www.paintdocs.com](http://www.paintdocs.com).

### CHARACTERISTICS

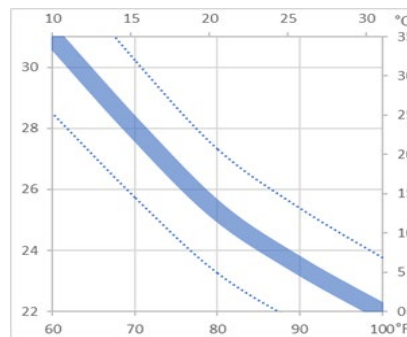
#### Gloss (measured on black glass):

Gloss—85+  
 MRE—34-38  
 DRE—17-21

**Volume Solids:** 23.3 ± 2%

#### Viscosity:

24-28 seconds #2 Zahn Cup



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

#### Recommended film thickness per coat:

Mils Wet 3.0 - 4.0  
 Mils Dry 0.7 - 0.9

**Maximum DFT for total system is 4.0 mils**

**Spreading Rate** (no application loss) 351 sq. ft./gal @ 1.0 mils DFT

#### Drying ( 77°F, 50% RH):

To Touch: 10-15 minutes To Sand: 30-45 minutes  
 To Recoat: 30-45 minutes To Pack: 8 hours  
 Force Dry: Flash 20 minutes, then 5-10 minutes at 120°F.

**Flash Point:** 29°F PMCC

#### Mixing Ratio:

1 part F3 HB Precat Lacquer  
 1.5% by volume (2.0 ounces per gallon) Catalyst V66V26

**Pot Life:** 4 months

**Package Life:** 18 months, unopened

### 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

#### Wood Finishing System:

##### **THIS PRODUCT MUST BE CATALYZED.**

1. Color Wood - Stain or tone as desired and dry thoroughly.
2. Seal - Spray a full wet coat (3-4 wet mils) of Sher-Wood F3 Hi-Bild Precat Lacquer as a seal coat. Air Dry 30 - 45 minutes.
3. Sand - Sand with 240 grit or equivalent. Remove sanding dust.
4. Topcoat - Spray a full wet coat (3-4 wet mils) of Sher-Wood Hi-Bild Precat Lacquer. Air dry 30-45 minutes.
5. Topcoat - Repeat step 4.

**6. For more depth or build, apply an additional coat. Do not exceed 4.0 mils DFT for the total system.**

**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 Pressure..... 45-55 psi  
Fluid Pressure ..... 8-10 psi

#### **Airless Spray:**

Pressure .....1800-2200 psi  
Tip..... .009 - .013"

#### **Air Assisted Airless:**

Assist Air Pressure ..... 15-25 psi  
Fluid Pressure ..... 600-900 psi  
Cap/Tip ..... .011-.013"

#### **HVLP:**

Air Pressure..... 8-10 psi  
Fluid Pressure ..... 6-8 psi

#### **LVMP:**

Max Air at Gun Inlet.....29 psi  
Fluid Pressure ..... 7-9 psi

**Reducing Options:** Reduce 3-5% with Butyl Acetate (R6K18) to adjust drying or build.

**Retarding Options:** Retard 1-3% with MAK (R6K30) as required.

#### **Cleanup:**

Clean tools/equipment immediately after use with a quality lacquer thinner or acetone. Always follow instructions given by equipment supplier

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## **ADDITIONAL INFORMATION**

- Do not over-catalyze.
- 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.
- **Agitate during use to ensure gloss consistency.**
- **To achieve optimal results, a minimum of 2 mils dry film thickness is required.**
- **Total film thickness of this finish system must not exceed 4 mils dry. Heavier films may show cracking and checking.**

## **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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