



**SHERWIN
WILLIAMS.**

Industrial Wood Coatings

CC-F64

SHER-WOOD®

Kem Aqua® Plus Surfacers

White Surfacers..... E64W520
Custom Blend.....E64PX Series

DESCRIPTION

SHER-WOOD® KEM AQUA® Plus Surfacers is a fast drying waterborne primer designed for priming interior woods. When used under Sher-Wood® Kem Aqua® Plus White (M64W521 series), it also functions as a barrier to tannins which may be extracted from the wood.

Advantages:

- Meets KCMA specifications when used under Sher-Wood Kem Aqua Plus Whites
- VOC as packaged <0.50 lb/gal, 60 g/L*
- Meets the Federal HAPS rule for wood finishes as packaged**
- Fast drying
- Sands freely with no gumming in 20 minutes
- Good gloss hold-out of topcoat
- No critical recoat time
- Application by conventional, airless, air assisted airless, or HVLP spray equipment
- Good wet and dry hiding

Not Stocked - Special Order Only: Clear Surfacers..... E64C526

Air Quality Data:

- Non-photochemically reactive
- Volatile Organic Compounds (VOC) Theoretical as packaged, less water and exempt solvents <0.50 lb/gal, 60g/L
- Volatile Hazardous Air Pollutants (VHAPS) as packaged, no reportable VHAP

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

*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.

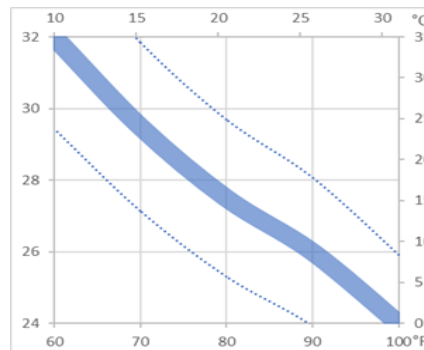
**National Standards for Hazardous Air Pollutants (HAPS) Emissions for Wood Furniture Manufacturing Operations CFR40, Part 63, Subpart JJ

CHARACTERISTICS

Gloss: Flat

Volume Solids: 40.0 ± 1%
Weight Solids: 56.2 ± 1%

Viscosity:
26-30 seconds #3 Zahn Cup



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

Recommended film thickness:

Mils Wet 4.0 - 5.0
Mils Dry 1.6 - 2.0

Spreading Rate (no application loss)
313-411 sq ft/gal @ 1.6-2.0 mils DFT

Drying (77°F, 50% RH):

To Touch: 5-10 minutes
To Handle: 15-20 minutes
To Sand: 20 minutes
To Recoat: 20 minutes
To Pack: overnight
Force Dry: 10-20 minutes at 110-140°F

Good air movement and humidity control are necessary for proper drying of water reducible coatings. When humid shop conditions exist, lower relative humidity is achieved only by raising the temperature 10-30°F and ventilating out the excess moisture.

Flash Point: None

Package Life: 1 year, 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

1. Primer—apply Sher-Wood Kem Aqua Plus Surfacers at 4-5 mils wet. Air dry thoroughly. Sand with 240 grit sandpaper. A second coat of primer may be applied for improved holdout. Sand between primer coats and before top- coat.
2. Topcoat—apply Sher-Wood Kem Aqua Plus White (M64W523 series) at 3-4 mils wet. A second coat may be applied. Sand with 240 grit sandpaper between coats.
3. A coat of Kem Aqua Plus Clear (T75C555 series) can be used a final coat for added performance properties.
4. Dry—allow overnight drying before stacking or packing
5. Maximum dry film thickness of the system should not exceed 4 mils.

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

Reduction: Apply full body. If needed reduce up to 5% with water. To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction.

Conventional Spray:

Air Pressure..... 45-55 psi
Fluid Pressure 8-10 psi Tip
..... .055-.070

Airless Spray:

Pressure1800-2100 psi
Tip013-.015"

Air Assisted Airless:

Air Pressure..... 15-20 psi
Fluid Pressure600-800 psi
Cap/Tip..... .013-.015

HVLP:

Air Pressure..... 8-10 psi
Fluid Pressure 5-10 psi
Cap/Tip..... .055-.070

Cleanup:

Clean tools/equipment immediately after use with water.

Flush equipment with water followed by flushing with 2 parts water and 1 part 2-Butoxyethanol, R6K25.

Follow manufacturer's safety recommendations when using any solvent.

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ADDITIONAL INFORMATION

- Protect from freezing.
- For interior use only.
- Reducing more than 10% with water will lessen performance as a barrier coat to tannins.
- For applications on MDF two coats of primer are recommended. Sand between coats.
- Paint, substrate and ambient conditions must be above 60°F. During high humidity use force dry up to 140°F with good air movement.
- Mix thoroughly before use. Avoid vigorous agitation which may cause foaming.
- The customer is urged to pretest the system under shop conditions.
- Excessive wet film thickness of more than 5.0 mils wet may sag.
- Do not blend with Sher-Wood Kem Aqua Plus whites (M64 Series) as package stability is poor.
- For wood substrates requiring a primer with additional filling properties (such as MDF) Kem Aqua® 65P (D61H565) Spray-Fil is recommended.
- Tank, piping and containers should be lined steel or plastic
- May be tinted with up to 4 ounces per gallon of Kem Aqua® Colorants or Blend-a-Color® (BAC) colorants.

Performance Tests:

Cold Check Resistance.....
Passes 20 cycles when top-coated with Sher-Wood Kem Aqua Plus White.

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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