



**SHERWIN  
WILLIAMS.**

# Product Finishes

CC-F64

## SHER-WOOD® Kem Aqua® Plus Surfacer

White Surfacer..... E64W520  
Custom Blend.....E64PX Series

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p><b>SHER-WOOD® KEM AQUA® Plus Surfacer</b> is a fast drying waterborne primer designed for priming interior woods. When used under Sher-Wood® Kem Aqua® Plus Whites, it also functions as a barrier to tannins which may be extracted from the wood.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• Meets KCMA specifications when used under Sher-Wood Kem Aqua Plus Whites</li> <li>• VOC as packaged &lt;0.50 lb/gal, 60 g/L*</li> <li>• Meets the Federal HAPS rule for wood finishes as packaged**</li> <li>• Fast drying</li> <li>• Sands freely with no gumming in 20 minutes</li> <li>• Good gloss hold-out of topcoat</li> <li>• No critical recoat time</li> <li>• Application by conventional, airless, air assisted airless, or HVLP spray equipment</li> <li>• Good wet and dry hiding</li> </ul> <p>Not Stocked - Special Order Only: Clear Surfacer..... E64C526</p> <p>*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.</p> <p>**National Standards for Hazardous Air Pollutants (HAPS) Emissions for Wood Furniture Manufacturing Operations CFR40, Part 63, Subpart JJ</p>	<p><b>Gloss:</b> Flat</p> <p><b>Volume Solids:</b> 40.0 ± 1%</p> <p><b>Weight Solids:</b> 56.2 ± 1%</p> <p><b>Viscosity:</b> 26-30 seconds #3 Zahn Cup</p> <p><b>Recommended film thickness:</b> Mils Wet 4.0 - 5.0 Mils Dry 1.6 - 2.0</p> <p><b>Spreading Rate</b> (no application loss) 313-411 sq ft/gal @ 1.6-2.0 mils DFT</p> <p><b>Drying</b> (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</p> <p>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.</p> <p><b>Flash Point:</b> None</p> <p><b>Package Life:</b> 1 year, unopened</p> <p><b>Air Quality Data:</b></p> <ul style="list-style-type: none"> <li>• Non-photochemically reactive</li> <li>• Volatile Organic Compounds (VOC) Theoretical as packaged, less water and exempt solvents &lt;0.50 lb/gal, 60 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.</p>	<p><b>Wood</b> (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%.</p> <p><b>Wood Finishing System</b></p> <ol style="list-style-type: none"> <li>1. Primer—apply Sher-Wood Kem Aqua Plus Surfacer 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 topcoat.</li> <li>2. Topcoat—apply Sher-Wood Kem Aqua Plus White at 3-4 mils wet. A second coat may be applied. Sand with 240 grit sandpaper between coats.</li> <li>3. A coat of Kem Aqua Plus Clears can be used a final coat for added performance properties.</li> <li>4. Dry—allow overnight drying before stacking or packing</li> <li>5. Maximum dry film thickness of the system should not exceed 4 mils.</li> </ol> <p><b>Testing:</b> Due to the wide variety of substrates, surface preparation methods, 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

**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:**

Pressure .....1800-2100 psi  
Tip ..... .013-.015"

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

Air Pressure..... 15-20 psi  
Fluid Pressure ..... 600-800 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 Butyl Cellosolve, R6K25.

Follow manufacturer's safety recommendations when using any solvent.

## 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 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 topcoated with Sher-Wood Kem Aqua Plus White.

## CAUTIONS

### **FOR INDUSTRIAL SHOP APPLICATION**

Thoroughly review product label and Material Safety Data Sheet (MSDS) for safety and cautions prior to using this product.

A Material Safety Data Sheet is available from your local Sherwin-Williams facility.

Please direct any questions or comments to your local Sherwin-Williams facility.

**Note:** Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.