



**GEMINI**  
COATINGS

# PRODUCT DATA SHEET

550 VOC CLEAR PRECATALYZED  
LACQUERS

## DESCRIPTION

This product line represents an intermediate step between our high quality water clear lacquers and our extremely durable conversion varnish series. The blending of these two technologies creates a product that demonstrates ease of application similar to a lacquer, while providing some of the performance characteristics normally associated with a conversion varnish. For premium moisture and chemical resistance see Gemini's High Performance Finishes. For wood substrates only. For interior use only.

PRODUCT NUMBERS / SHEENS	COATING PROPERTIES	PREPARATION INSTRUCTIONS
510-0017 Gloss (90°) 510-0018 Semi-Gloss (50°) 510-0019 Satin (25°) 510-0020 Flat (10°)	<p><b>Viscosity:</b> 19 #4 Ford  <b>Weight Solids:</b> 33.3-34.6 %  <b>Volume Solids:</b> 25-25.6 %  <b>Weight/Gallon:</b> 7.6-7.7 lbs./gal  <b>Coverage:</b> 401-407 sq. ft. per gallon at one mil dry film thickness.</p> <p><b>VOC (coating):</b> 4.19-4.24 lbs./gl. or 502-508g/l  <b>VOC (material):</b> 2.67-2.69 lbs./gl. or 319-322g/l  <b>VOC Ratio:</b> 0.99-1.05 lbs. VOC/lbs. solids  <b>HAPS Ratio:</b> 0.1494-0.1579 lbs. HAPS/lbs. solids</p> <p><b>Dry Times:</b>  <b>Air Dry:</b> at 78°F, relative humidity 50%            To touch: 8 minutes            To Handle: 20 minutes            To sand/recoat: 45 minutes  <b>Force Dry:</b>            Flash: 8-10 minutes            Bake: 15 @110°F minutes            Cool down: 10 minutes            Stack: 1 hour after cool down            Relative humidity will affect the speed of drying. Ideal conditions are 75°F or warmer at 50% humidity or less. Dry time will be faster at higher temperatures and lower humidity and equally slower at colder temperatures and higher humidity.</p> <p><b>Dry Film Thickness:</b>  <i>The total DFT for the complete coating system should not exceed 3 mils.</i></p> <p><b>Pot Life:</b> N/A</p> <p><b>Shelf Life:</b> 12 months @77° F if unopened and stored in a cool dry area. Always rotate stock.</p> <p><b>Storage:</b> Keep away from heat or sparks.</p>	<p><b>Catalyzation:</b> This product comes pre-catalyzed. Do NOT add catalyst.</p> <p><b>Reduction:</b>  <b>Thinning:</b> This product is supplied ready to spray. Thinning is not recommended.</p> <p><b>Retarder:</b> If a slower dry time is desired, or to prevent blushing in humid weather use SOL-0061 Retarder at levels not to exceed 4 oz per gallon (3% by volume)*</p> <p><b>Note:</b> Effective dry times will be lengthened if retarder is added</p> <p>VOC after adding recommended retarder amount is less than 550 grams per liter.</p> <p>*Thinning this material may result in increasing the VOC levels of this product. Refer to your local regulations before thinning.</p> <p><b>Approved Companion Products</b>  <b>210-0030 550 VOC Precat Sealer</b></p> <p><i>Note: These numbers represent actual control values on a smooth, sanded substrate. Spray techniques, texture, and sealing as well as film thickness may give different results on actual work, but they may be used for comparison. To the best of our knowledge, the above technical data is true and accurate at the date of issuance but is subject to change without prior notice.</i></p>
PRODUCT ADVANTAGES		
<ul style="list-style-type: none"> <li>➤ 550 VOC</li> <li>➤ HAPs Compliant</li> <li>➤ Extremely Durable</li> <li>➤ Ready to Spray</li> <li>➤ Self Sealing</li> <li>➤ Meets KCMA and ASTM Requirements When Applied To Manufacturer Specifications</li> <li>➤ Non Photo Chemically Reactive</li> <li>➤ Phthalate Free</li> </ul>		



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## PRODUCT DATA SHEET 510-001X SERIES CONTINUED



### **Substrate preparation:**

**New wood:** Remove any dirt, grease, glue or other contaminants. Moisture content of wood should be 7-9%. Sand to 150-180 grit. Proper sanding of wood is absolutely critical to achieve the best color development and adhesion of the coating to the substrate.

**Old wood:** Strip old finishes completely and remove all contaminants from the surface. Make sure the surface is dry, sand as required. Finish same as new wood.



### **Mixing Instructions:**

Mix material thoroughly before and during use. Material may be mixed by hand or mechanical agitation at moderate speed.



### **Application:**

If staining, apply the approved Gemini stain of your choosing and let dry per the instructions on the PDS for that particular stain. Using conventional, HVLP, airless, or air assisted equipment, apply this product at 3-4 wet mils per coat. Let dry a minimum of 45 minutes. Sand with 280-320 grit, no-fill sandpaper and remove sanding dust with clean compressed air, or tack rag. This product must be sanded in between coats to ensure proper adhesion. This product may be used with a sealer or as a self seal system.

If a sealer is desired, we recommend a coating system comprised of one coat of 210-0030 applied at 3-4 mils wet film build and 1-2 coats of topcoat applied at 3-4 mils wet film build. If used as a self seal system we recommend 2 coats of 510-001X series. Maximum dry film thickness of the complete system must not exceed 3 dry mils.



### **Recommended Tip Sizes:**

Conventional Air	1.3-1.8mm
HVLP	1.3-1.8mm
Airless	10-15 thousandths
Air Assisted Airless-	11-15 thousandths



### **Precautions:**

These products are intended for Professional use only. Do not proceed if you are planning on mixing with other finishing systems or other manufacturer's products. Gemini will not be held liable for finish failures due to the improper use of our products or deviation from our finishing recommendations

### **Equipment:**

All equipment used with this product must have plastic, stainless steel, or Teflon fluid passages and wetted parts

### **Containers:**

We supply this material in a lined container. All containers used in conjunction with storage and/or application of this product must be stainless steel, plastic, or otherwise acid resistant.

### **Clean up:**

Use SOL-0500 Lacquer Thinner to clean up all equipment. Dispose of in accordance with Federal, State, and Local regulation regarding pollution.

**Care and cleaning of this finish:** Use a mild dishwashing liquid and a damp cloth to remove food, grease, and other residue. Wipe dry. Do not use cleaners that contain ammonia, bleach, or abrasives as this may damage the finish.