



GEMINI
COATINGS

PRODUCT DATA SHEET

WHITE PRECAT LACQUER-550VOC
410-003X Series

DESCRIPTION

The 410-003X series is a high quality, white pre-catalyzed lacquer formulated for 550 VOC applications. These products are catalyzed at the factory and exhibit excellent chemical and moisture resistance. All products in this series pass the performance requirements established by the Kitchen Cabinet Manufacturers Association (KCMA). For wood substrates only. For interior use only.

PRODUCT NUMBERS / SHEENS	COATING PROPERTIES	PREPARATION INSTRUCTIONS
410-0033 Gloss (90°) 410-0034 Semi-Gloss (60°) 410-0035 Satin (30°) 410-0036 Flat (10°)	<p>Viscosity: 23-27 #4 Ford Weight Solids: 39.6-40.1 % Volume Solids: 23.9-24.3 % Weight/Gallon: 8.6 lbs./gal Coverage: 384-389 sq. ft. per gallon at one mil dry film thickness. VOC (reg./coating): 4.25-4.29 lbs./gl. or 510-514g/l VOC (actual/material): 2.64-2.66 lbs./gl. or 317-318g/l VOC Ratio: 0.77-.078 lbs.VOC/lbs. solids HAPS Ratio: 0.12 lbs. HAPS/lbs. solids</p> <p>Dry Times: Air Dry: at 78°F, relative humidity 50% To touch: 10 minutes To Handle: 30 minutes To sand/recoat: 45 minutes Force Dry: 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>Dry Film Thickness: <i>Maximum DFT for the complete system must not exceed 5 mils.</i></p> <p>Shelf Life: 12 months @77° F if unopened and stored in a cool dry area. Always rotate stock. Storage: Keep away from heat or sparks.</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</i></p>	<p>Catalyzation: This product comes pre-catalyzed. Do NOT add catalyst.</p> <p>Reduction: Thinning: This product is supplied ready to spray for most applications. If needed due to conditions in your facility, or for certain types of spray equipment, use SOL-9032 Non HAPs/Non VOC Thinner at levels not to exceed 10% by volume* VOC after this thinning recommendation is less than 550 grams per liter.</p> <p>Retarder: If a slower dry time is desired, or to prevent blushing in humid weather use SOL-9012 Industrial Retarder at levels not to exceed 4 oz per gallon (3% by volume)* VOC after this recommendation is less than 550 grams per liter.</p> <p>Note: Effective dry times will be lengthened if retarder is added</p> <p>Tinting: This product may be tinted up to 4 oz per gal with 844 colorants. Do not use umber pigments. Never tint with Universal Colorants that contain Glycol.</p> <p>*Thinning this material may result in increasing the VOC levels of this product. Refer to your local regulations before thinning.</p> <p>Approved Companion Products 110-0212 275 VOC White Pre-catalyzed Primer</p>
PRODUCT ADVANTAGES		
<ul style="list-style-type: none"> ➤ 550 VOC ➤ AIM Compliant ➤ Low HAPs ➤ Water And Household Chemical Resistant ➤ Ready to Spray ➤ Controlled Tint Base ➤ Short Filled For Easy Tinting ➤ Meets KCMA Requirements When Applied To Manufacturers Specifications. ➤ Non Photo Chemically Reactive ➤ Phthalate Free 		



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PRODUCT DATA SHEET 410-003X 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:

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 in conjunction with a pre-catalyzed primer, or used as a self seal system.

If a primer is desired, we recommend a coating system comprised of one coat of primer applied at 3-3.5 mils wet film build and 2 coats of topcoat applied at 3-4 mils wet film build. Please see the approved companion products section of this document for approved primers.

If used as a self seal system we recommend 2-3 coats of 410-003X series. Maximum dry film thickness of the complete system must not exceed 5 dry mils.



Recommended Tip Sizes:

Conventional Air	1.3-1.8mm
HVLP	1.5-1.9mm
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-9032 Non HAPs, Non VOC 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.