



INDUSTRIAL WOOD FINISHES

PRODUCT DATA SHEET

CORE

Clear Conversion Lacquer

DESCRIPTION

NEXUS CORE is a high solids, crosslinked, alkyd/amino coating providing superior water and chemical resistance compared to standard pre-catalyzed lacquers. It also exhibits excellent resistance to yellowing and great sanding properties. Formulated specifically for kitchen and bathroom cabinetry, architectural woodwork, and fine furniture. For wood substrates only. For interior use only.

PRODUCT NUMBERS / SHEENS	COATING PROPERTIES	PREPARATION INSTRUCTIONS
NXC-0790 GLOSS NXC-0760 SEMI-GLOSS NXC-0730 SATIN NXC-0720 DULL NXC-0710 FLAT	<p>Viscosity: 25-27' #2 Zahn Weight Solids: 30.7-32.3% Volume Solids: 23.3- 24.2% Weight/Gallon: 7.8-7.9 lbs./gal Coverage: 374-392 sq. ft. per gallon at one mil dry film thickness.</p> <p>VOC (reg/coating): 5.3-5.4 lbs./gl. or 636-645 g/l VOC (act/material): 5.3-5.37 lbs./gl. or 634-644 g/l VOC Ratio: 2.1-2.2 lbs. VOC/lbs. Solids HAPS Ratio: 0.05 lbs. HAPs/lbs. Solids</p> <p>Dry Times: Air Dry: at 78°F, relative humidity 50% To touch: 12 minutes To Handle: 20 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 a complete system must not exceed 5 dry mils.</i></p> <p>Pot Life: 120 days (4 months) once catalyzed</p> <p>Shelf Life: 12 months @77° F if unopened, un-catalyzed and stored in a cool dry area. Always rotate stock. Storage: Keep away from heat or sparks.</p>	<p>Catalyzation: THIS PRODUCT MUST BE CATALYZED EITHER BY THE DISTRIBUTOR OR END USER. Containers are short filled to allow for <u>catalyst</u>. Use pre-packaged catalyst kit: To catalyze add: 2 oz of NXCAT-0700 to gallon container 10 oz of NXCAT-0700 to 5 gallon pail 100 oz of NXCAT-0700 to drum This is equal to 1.59% by volume NOTE: DO NOT add more than the recommended amount of catalyst! This will <i>not</i> make the product cure faster or harder and may cause cracking, haziness, gloss issues, and will affect the integrity of the final product.</p> <p>Reduction: Thinning: If needed due to conditions in your facility use SOL-9059 HAPs Free Reducer, or SOL-9011 HAPs Free Thinner at levels not to exceed 10% by volume*</p> <p>Retarder: If a slower dry time is desired, use SOL-9056 PM Acetate not to exceed 8% by volume or SOL-9012 Haps Free Retarder at levels not to exceed 5% by volume*</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 PVS-0100 NEXUS Pre-cat Vinyl Sealer USM-0350 Ultra Seal Max</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</i></p>
PRODUCT ADVANTAGES		
<ul style="list-style-type: none"> ➤ High Solids ➤ Water Clear ➤ Self-Sealing ➤ Highly Crosslinked Coating Increases Performance Compared To Standard Precats ➤ 120 Day Pot Life Once Catalyzed ➤ Contains UV Inhibitor ➤ Extremely low HAPs ➤ Meets or exceeds KCMA Requirements When Applied To Manufacturer Specifications ➤ Non Photo Chemically Reactive ➤ Phthalate Free 		

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PRODUCT DATA SHEET NXC-07XX 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: PRODUCT MUST BE CATALYZED.

Catalyze Core with pre-packaged catalyst kit in a stainless steel, plastic lined container, or original container. Mix material thoroughly before and while adding catalyst. Catalyst may be mixed in by hand, shaker, or mechanical agitation at moderate speed. Containers are short filled to allow for the correct amount of catalyst.

To catalyze add:

- 2 oz of NXCAT-0700 to short filled gallon container
- 10 oz of NXCAT-0700 to short filled 5 gallon pail
- 100 oz of NXCAT-0700 to short filled drum

Material should be agitated slowly while mixing in the catalyst. Mix or agitate thoroughly before use. Write date of catalyzation on the provided sticker or directly on the container. Pot life is 120 days after catalyzation.



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 has been designed to be used as a self-seal system, but may also be used with a sealer.

If a sealer is desired, we recommend a coating system comprised of one coat of a companion sealer (see approved companion products section) 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 2-3 coats of NXC-07XX. Maximum dry film thickness of the complete system must not exceed 5 dry mils.



Recommended Tip Sizes:

Conventional Air	1.4-1.8mm
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-9059 HAPs Free Reducer or SOL-9011 Non HAPs 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.