



INDUSTRIAL WOOD FINISHES

PRODUCT DATA SHEET

NEXPRIME PRECAT PRIMER

DESCRIPTION

NEXPRIME is a HAPs Free, alkyd-amino pre-catalyzed primer that has been formulated to combine the benefits of fast dry and excellent sanding properties, while still maintaining excellent resistance to moisture. It has been specifically formulated for use under Gemini's family of pre-catalyzed topcoats on kitchen cabinetry, bathroom cabinetry, and architectural millwork. For wood substrates only. For interior use only.

PRODUCT NUMBERS / SHEENS	COATING PROPERTIES	PREPARATION INSTRUCTIONS
NEXP-6000	<p>Viscosity: 40-60 #4 Ford Weight Solids: 51.24% Volume Solids: 32.8 % Weight/Gallon: 9.86 lbs./gal Coverage: 527 sq. ft. per gallon at one mil dry film thickness.</p> <p>VOC (reg./coating): 4.5 lbs./gl. or 544.7 g/l VOC (act/material): 4.2 lbs./gl. or 506.4 g/l VOC Ratio: 0.84 lbs. VOC/lbs. Solids HAPS Ratio: 0.0 lbs. HAPS/lbs. Solids</p> <p>Dry Times: Air Dry: at 78°F, relative humidity 50% To touch: 7-10 minutes To handle: 10-15 minutes To sand/recoat: 45-60 minutes Force Dry: Flash: 8-10 minutes Bake: 15 minutes @110°F Cool down: 15 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: For optimal results, the DFT for this primer should be between 1- 2 mils. Please refer to the PDS for the specific topcoat you are using for maximum DFT for the complete system.</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>Catalyzation: This product comes pre-catalyzed. Do NOT add catalyst.</p> <p>Reduction/Thinning: This product is supplied ready to use. However, if needed due to equipment or conditions in your facility use SOL-9059 HAPs Free Reducer or SOL-9011 HAPs Free Thinner at levels not to exceed 20% by volume.* Typical reduction is usually no more than 10%.</p> <p>Tinting: Although not controlled for tint strength, this product may be tinted up to 4 oz per gallon with Chromaflow 844 colorants. 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 NEXUS White Precat NEXW-15XX Series PC-10X0 Series</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"> ➤ Pre-catalyzed From The Factory ➤ Great Build And Holdout on MDF ➤ Fast Dry And Great Sanding Properties ➤ Meets KCMA and ASTM Performance Requirements When Applied To Manufacturers Specifications ➤ Passes 10 Days ASTM Water Immersion Test D870-92 On Red Oak When Used In Conjunction With NEXUS White Precat Lacquer NEXW-15XX Series ➤ HAPs Free ➤ Non Photo Chemically Reactive ➤ Phthalate Free 		

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PRODUCT DATA SHEET NEXP-6000 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 4-5 wet mils per coat. Let dry a minimum 45-60 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. Typically we recommend a coating system comprised of one coat of NEXP-6000 applied at 4-5 mils wet film build and 1-2 coats of an approved Gemini topcoat (see approved companion products section). On MDF we recommend two coats of primer (especially on routed areas). Refer to the Product Data Sheet for the topcoat you are using for maximum dry film thickness recommendations.



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.