



Wiping Stain Base

DESCRIPTION

S3555 Wiping Stain Base is a clear base designed for custom tinting purposes. This base is an Industrial, solvent-based stain technology, designed to dry quickly while providing excellent wiping characteristics and very even color distribution. For wood substrates only. For interior use only.

PRODUCT NUMBERS / SHEENS	COATING PROPERTIES	PREPARATION INSTRUCTIONS
S3555	<p>Viscosity: 15 #2 Zahn Weight Solids: 8% Volume Solids: 5.75% Weight/Gallon: 7.26 lbs/gal Coverage: 92 sq. ft. per gallon at one mil dry film thickness.</p> <p>VOC (coating): 6.68 lbs./gl. or 800 g/l VOC (material): 6.68 lbs./gl. or 800 g/l VOC Ratio: 283.31 lbs VOC/lbs solids HAPS Ratio: 0.6209 lbs HAPS/lbs solids</p> <p>Dry Times: Air Dry: 30 minutes at 78°F, relative humidity 50%; To touch: 10-15 minutes To Handle: 20-30 minutes To sand/recoat: 30-45 minutes</p> <p>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: N/A</p> <p>Pot Life: N/A</p> <p>Shelf Life: 24 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 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>	<p>Tinting: S3555 may be tinted with the following colorants: 824.866, and/or SC-010X Stain Concentrates (Preferred), 844, Gemini NG Dye Concentrates. Maximum tint load should not exceed 23 oz per gal. (18% by volume). 824's or SC-010X Stain Concentrates are preferred for open time and workability. NG Dye levels should not exceed 6 oz per gal (5% by volume). The total of all colorants added should never exceed 23 oz per gal. (18% by volume) SC-010X Stain Concentrates may be added in any amount.</p> <p>Reduction: Thinning: This product is supplied ready to use. No thinning is recommended.</p> <p>Retarder: If more open time is desired due to environmental conditions, use SOL-0035 at levels not to exceed 6 oz per gallon (5% by volume)*</p> <p>*Adding solvent to this material may result in increasing the VOC levels of this product. Refer to your local regulations before making any additions. Also, the addition of SOL-0035 will result in increased dry times. Make sure the stain is <u>completely</u> dry before proceeding to the next step in your finishing process.</p> <p>Approved Companion Products Chromaflow 824 Series Colorants Chromaflow 866 Series Colorants Chromaflow 844 Series Colorants Gemini NG Dye Concentrates SC-010X Series Stain Concentrates</p> <p>*We require the use of insulating agent 6FPI35S06 if using this stain base in conjunction with Sirca Polyurethane products. Please refer to the PDS for the particular polyurethane product you intend to use for specific information.</p>
PRODUCT ADVANTAGES		
<ul style="list-style-type: none"> ➤ Designed Specifically For Industrial Wood Shops ➤ Excellent Wiping Characteristics ➤ Easy To Mix And Apply ➤ Mild Odor ➤ Excellent Color Stability And Settling Properties ➤ Quick Recoat Time ➤ Less Blotching Than Many Other Types Of Stains ➤ Short Filled For Tinting (118 oz fill level) ➤ Tint To Any Color With Approved Colorants 		

April, 2020

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PRODUCT DATA SHEET S3555 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 as new work.



Mixing Instructions:

Tint S3555 to desired color and mix thoroughly with mechanical agitation to ensure the colorant is fully incorporated. After tinting, mix material thoroughly before and during use. Material may be mixed by hand or mechanical agitation at moderate speed.

For short filled containers maximum tint capacity is 10 oz per gallon. If making a formula from scratch in a separate container, maximum tint load is 23 oz per gallon (18 %) by volume.



Application:

Always test the stain for color and appearance before starting a job. Intermix containers of the same color.

This stain may be applied by spray, brush, or cloth rag. When spraying, set the air pressure as low as possible typically 12-15 psi. If the air pressure is set too high, it may cause the stain to dry prematurely. Apply an even wet coat. Leave the stain on the surface for 1-3 minutes before wiping (dwell time). While the stain is *still wet*, remove the excess with a clean, lint free cloth by working the stain into the wood with a circular motion. Finish by wiping the stain clean, *with* the grain of the wood. Color depth will vary depending on how the wood is sanded, and how long the stain is left on the surface before wiping. If the stain is wiped before the recommended dwell time, the result will be a lighter color. For best results, allow the same amount of dwell time on each piece you are staining. After a minimum of 30 minutes dry time, finish with an approved Gemini coating system. For darker colors, we recommend letting the stain dry a minimum of 45 minutes.

Do not leave this stain on the surface without wiping! Leaving an excessive amount of stain on the surface may lead to adhesion failure or affect the curing of the topcoat system.



Recommended Tip Sizes:

Conventional Air	1.3-1.8mm
HVLP	1.3-1.8mm



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. . **Danger! Rags, steel wool, or waste soaked with this product may spontaneously catch fire if improperly stored or discarded. Immediately after use, place rags, steel wool, and waste, in a sealed metal container filled with water.** Dispose of in accordance with Federal, State, and Local regulation regarding pollution.

Clean up:

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