



# PRODUCT DATA SHEET

## GEM COAT 680 VOC PRECATALYZED LACQUER

### 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 wood substrates only. For interior use only.

PRODUCT NUMBERS / SHEENS	COATING PROPERTIES	PREPARATION INSTRUCTIONS
510-0050 Gloss	<b>Viscosity:</b> 27" #2 Zahn <b>Weight Solids:</b> 26.8 - 28.4% <b>Volume Solids:</b> 19.6-20.7 % <b>Weight/Gallon:</b> 7.65-7.74 lbs./gal <b>Coverage:</b> 315-331 sq. ft. per gallon at one mil dry film thickness.	<b>Catalyzation:</b> This product comes pre-catalyzed. Do NOT add catalyst.
510-0051 Semi-Gloss		<b>Reduction:</b> <b>Thinning:</b> This product is supplied ready to spray. If needed due to conditions in your facility use SOL-0500, SOL-9011 HAPs Free Thinner or SOL-9059 HAPs Free reducer at levels not to exceed 10% by volume*
510-0052 Satin		
510-0062 Dull		
510-0053 Flat	<b>VOC (coating):</b> 5.44-5.50 lbs./gl. or 652-660 g/l <b>VOC (material):</b> 5.02-5.08 lbs./gl. or 602-609 g/l <b>VOC Ratio:</b> 2.29-2.47 lbs. VOC/lbs. Solids <b>HAPS Ratio:</b> 0.63 -0.68 lbs. HAPS/lbs. solids	
510-0005 Dead Flat	<b>Dry Times:</b> <b>Air Dry:</b> at 78°F, relative humidity 50% To touch: 8 minutes To Handle: 12 minutes To sand/recoat: 30-45 minutes <b>Force Dry:</b> Flash: 8-10 minutes Bake: 15 minutes @110°F 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 temperature and lower humidity and equally slower at colder temperatures and higher humidity.  <b>Dry Film Thickness:</b> Maximum DFT for a complete system must not exceed 4 dry mils.	<b>Retarder:</b> If a slower dry time is desired, use SOL-9056 (PM Acetate) between 4-6% by volume, or SOL-9012 Haps Free Retarder at levels not to exceed 4% by volume*  <b>Note:</b> Effective dry times will be lengthened if retarder is added
<b>PRODUCT ADVANTAGES</b>		<b>*Thinning:</b> Thinning this material may result in increasing the VOC levels of this product. Refer to your local regulations before thinning.
<ul style="list-style-type: none"><li>➤ HAPs &amp; AIM Compliant</li><li>➤ User Friendly</li><li>➤ No Catalyst Required</li><li>➤ Water Clear</li><li>➤ Contains UV Inhibitor</li><li>➤ Self Sealing</li><li>➤ Meets KCMA Performance Requirements When Applied to Manufacturer's Specifications</li><li>➤ NFPA 255 Class A Rated For Flame Spread Utilizing ASTM E 84 Standard</li><li>➤ Phthalate Free</li><li>➤ Non Photo Chemically Reactive</li></ul>		<b>Approved Companion Products</b> <b>210-0215 Ultra Seal</b> <b>210-0216 FD Pre-Cat Vinyl Sealer</b>

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**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 30-45 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 a companion sealer (please refer to the Approved Companion Products section of this document) 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 510-005X series. Maximum dry film thickness of the complete system must not exceed 4 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-0500, SOL-9011 Non HAPs Thinner, or SOL-9059 HAPs Free Reducer 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.