

# Mohawk Finishing Products

Division of RPM Wood Finishes Group, Inc.

## Product Data Sheet

### Waterborne White Primer

M640-1067 gallon

**Product Description:** Waterborne White Primer is a water reducible, ultra low VOC, tintable, high solids, ready to spray white primer that has excellent build and filling characteristics. Waterborne White Primer may be topcoated with Mohawk's Waterborne Pre-Catalyzed Clear Lacquer or Waterborne Conversion Varnish to achieve any desired sheen. It is the perfect beginning to create interior white finishes for cabinets, millwork and MDF (Medium Density Fiberboard). Not for use on exterior applications.

Advantages:

1. Exceptional build and hiding qualities
2. Does not contain formaldehyde, lead or phthalates
3. Promotes adhesion with waterborne pre & post catalyzed finishes
4. Use Waterborne Colorants M684 series to create custom colors

### Characteristics:

Weight per gallon: 11.63 lbs/gal

Solids % (wt): 52.48

Solids % (vol): 33.59

Package viscosity: 23-27 seconds, # 4 Ford cup

Dry time: Air dry @ 77 F, 50% relative humidity

To touch: 10 minutes

To sand and recoat: 30-45 minutes

VOC's (coating): .8 lbs/gal (95.76 g/l)

VOC's (material): .3 lbs/gal (35.77 g/l)

VHAP's: 0.0004 lbs VHAP's/lb solids

Spread Rate: 539 sq. ft. /gal. @ 1 dry mil film thickness

Package life: 1 year

HMIS: Health – 1, Flammability – 1, Reactivity – 0, Personal Protection - X

**Directions:** Stir thoroughly before use. Apply in light, even coats of 3-4 wet mils. Always scuff sand previous coat with 320 grit sand paper and remove any sanding dust from the surface before applying any additional coats. Apply appropriate sheen of the desired type of Mohawk Waterborne topcoat. Total finishing system, including primer and topcoats, should not exceed 4 dry mils. Waterborne sealers and finishes are high solids, quick building products. Excessive finish build can lead to a cloudy finish especially in lower sheens, cracking, cold checking and other finish failures. Waterborne White Primer may be tinted with Mohawk Waterborne Colorants (M684 Series) not to exceed 10% addition by volume.

**Notes:** Protect from Freezing. Waterborne White Primer is provided at a ready to spray viscosity. Small amounts of water may be added if further reduction is needed. Stainless steel equipment is recommended. Flush equipment and fluid lines after use with warm tap water. Do not use a tack cloth to remove sanding dust. Sanding dust should be removed with a dry cloth or compressed air.

**Safety and Other Precautions:** Read MSDS for precautions before using product.

**MSDS:** If Material Safety Data Sheet is required, contact:

Mohawk Finishing Products

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## Waterborne Coatings Tip Sheet

Mohawk waterborne coatings are water reducible, self cross-linking, low VOC emitting technologies that have good color retention and are suitable for cabinet, millwork, furniture and other high traffic interior wooden surfaces.

Mohawk waterborne coatings are formulated to meet production shop needs and are an excellent environmentally friendly alternative to comparable solvent base products.

The tips below are an effort to communicate product and application tips that will assist end users to achieve the expected results when using a waterborne coating. Always consult the product's Product Data (PDS) and Material Safety Data (MSDS) Sheets before use for more detailed information and instructions.

### **Thinning/Reduction**

Waterborne coatings are manufactured at ready to spray viscosity. They may be thinned or reduced if needed, however they thin much more rapidly than solvent coatings. Typically the maximum reduction is about 5%. Regular tap water may be used.

### **Application**

Waterborne sealers and finishes are high solids, quick building products. Excessive finish build can lead to a cloudy finish especially in lower sheens, cracking, cold checking and other finish failures. For best results, apply waterborne sealers and coatings in light, even coats of no more than 4 wet mils. The first coat should be applied very thin so that it can be easily and quickly sanded smooth to prepare a level surface for subsequent coats.

Sanding is necessary between all coats for maximum adhesion. Do not use a tack cloth to remove sanding dust. Sanding dust should be removed with a dry cloth or compressed air.

Filtering is suggested at every opportunity to prevent unwanted debris from getting trapped in the film.

Minimum application temperature is 60 degrees Fahrenheit; waterborne material, substrate and spray room should all be at minimum temperature or above for proper results. Waterborne coatings should be kept warm and will exhibit higher viscosity at cooler temperatures resulting in poor spray performance. Material should be warm and stable before making viscosity adjustments or spraying.

### **Storage and Agitation**

Always protect from freezing. Modern waterborne technologies cannot survive even one freeze/thaw cycle. Always stir waterborne coatings slowly and thoroughly before use. Do not shake waterborne products. Shaking will cause air bubbles that may remain in the film when the sprayed causing an undesirable end result.

### **Maximum Film Build**

The maximum total dry film build for waterborne sealers and coatings is 4 mils.

### **Sealers**

All Waterborne finishes can be used as a self sealing system; however always use a Mohawk Waterborne Sealer under lower sheens (40 degrees or below) in order to reduce the risk of cloudy looking film that is sometimes caused by excessive build of lower sheen coatings.

For results that resemble a solvent coating looking system, use Mohawk Waterborne Wood Tone Sealer (M641-2400), if applied over wood tone stain especially, dark stain colors.

### **Equipment**

Stainless steel spray equipment is recommended to avoid iron contamination (discoloration). Flush equipment and fluid lines after use with warm tap water. Waterborne finishes tend to dry on spray gun tips more rapidly than solvent coatings. Frequent cleaning of spray tips may be needed.

Spraying waterborne coatings with Air Assisted Airless or airless systems can be difficult because of the sheer those systems create in the product. Consult your equipment supplier for air cap, tip, and nozzle or suggested pump settings if flow or other issues is identified.

### **Safety**

Always use proper ventilation and safety equipment when applying any coating. Refer to the product's MSDS for detailed safety information.