



PRODUCT DATA SHEET

High Build Economy Lacquer

DESCRIPTION

The High Build Lacquer Series is a highly efficient nitrocellulose lacquer, utilizing premium imported modifying resins which promote excellent holdout, gloss retention and visual appeal. This lacquer is intended for use on interior architectural or decorative woodwork and should not be utilized as a system for furniture, kitchen cabinetry, or where durability, chemical or water resistance is required. **Not intended for use over light or natural stains where clarity and non-yellowing are critical.** For wood substrates only. For interior use only.

PRODUCT NUMBERS / SHEENS	COATING PROPERTIES	PREPARATION INSTRUCTIONS
HBL-0090 Gloss HBL-0060 Semi-Gloss HBL-0030 Satin	<p>Viscosity: 17-19 #3 Zahn Satin 40 #4 Ford Weight Solids: 29% Volume Solids: 24% Weight/Gallon: 7.63-7.66 lbs/gal Coverage: 385-389 sq. ft. per gallon at one mil dry film thickness.</p> <p>VOC (coating): 5.41-5.43lbs/gal or 647-650 g/l VOC (material): 5.39-5.41 lbs./gal. or 647-649g/l VOC Ratio: 2.39-2.46lbs VOC/lbs Solids HAPS Ratio: 1.85-1.89 lbs HAPS/lbs solids</p> <p>Dry Times: Air Dry: at 78°, relative humidity 50%; To touch: 8 minutes To Handle: 25 minutes To sand/recoat: 45 minutes</p> <p>Relative humidity will affect the speed of drying. Ideal conditions are 75° or warmer at 50% humidity or less. Dry time will be faster at higher temperatures and lower humidities, and equally slower at colder temperatures and higher humidities.</p> <p>Dry Film Thickness: Total DFT for the complete finish system should not exceed 4 mils.</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>Reduction: Thinning: Reduction is not recommended for airless spray. If needed due to conditions in your facility use SOL-0500 Lacquer Thinner at levels not to exceed 13 oz (10% by volume)*</p> <p>Retarder: If a slower dry time is desired, or to prevent blushing in humid weather use SOL-0061 Retarder at levels not to exceed 4 oz per gallon (3% by volume)*</p> <p>Note: Effective dry times will be lengthened if retarder is added</p> <p>*Thinning this material may result in increasing the VOC levels of this product. Refer to your local regulations before thinning.</p> <p>Tinting: Do Not Tint this product</p> <p>Approved Companion Products HBLSS-0100 High Build Lacquer Sealer HSS-0100 High Solids Lacquer Sealer</p>
PRODUCT ADVANTAGES		
<ul style="list-style-type: none"> ➤ High Solids ➤ AIM Compliant ➤ Supplied Ready To Spray For Airless Application ➤ Easy To Apply ➤ Quick Dry ➤ Excellent Film Build And High Profile Appearance ➤ Phthalate Free 		

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PRODUCT DATA SHEET HBL-00XX SERIES CONTINUED



Substrate preparation:

New wood: Remove any dirt, grease, glue or other contaminants. Moisture content of wood should be 7-9%. New wood: 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:

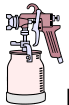
Mix material thoroughly before and during use. Material may be mixed by hand or mechanical agitation at moderate speed.



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 45 minutes. Sand with 280-320 grit, no-fill sandpaper and remove sanding dust with clean compressed air, or tack rag.

Typically 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 2 coats of topcoat applied at 3-4 mils wet film build. Maximum dry film thickness of the complete system must not exceed 4 dry mils.



Recommended Tip Sizes:

Conventional Air	1.5-1.8 mm
HVLP	1.7-1.9 mm
Airless	10-13 thousandths
Air Assisted Airless-	10-13 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 Lacquer 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.