



# PRODUCT DATA SHEET

## PC-16XX Precat Clear Series

### DESCRIPTION

PC-16XX series products are pre-catalyzed nitrocellulose lacquers designed for professional woodworkers who need a high-solids, ready-to-spray finish. Use the PC-16XX Series directly on properly prepared wood as a 3-coat self-sealing system. If a sealer is desired, use PCS-1600 Precat Clear Sealer. For wood substrates only. For interior use only.

### PRODUCT NUMBERS / SHEENS

PC-1690 Gloss  
 PC-1660 Semi-Gloss  
 PC-1630 Satin  
 PC-1620 Dull  
 PC-1610 Flat

### COATING PROPERTIES

**Viscosity:** 26-30 Seconds #4 Ford  
**Weight Solids:** 27% +/- 1.0%  
**Volume Solids:** 20% +/- 1.0%  
**Weight/Gallon:** 7.6–7.8 lbs.  
**Coverage:** 308 – 327 sq. ft. per gallon at one mil dry film thickness.  
**VOC (coating):** 5.48 - 5.58 lbs./gl. or 657 - 669 g/l  
**VOC (material):** 5.10 - 5.19 lbs./gl. or 617 - 622 g/l  
**VOC Ratio:** 2.38 – 2.61 lbs. VOC / lbs. Solids  
**HAPS Ratio:** 0.26 – 0.38 lbs. HAPS / lbs. Solids  
**Dry Times:**  
**Air Dry:** at 78° F, relative humidity 50%  
 To touch: 10 minutes  
 To handle: 20 minutes  
 To sand/recoat: 25 minutes  
**Force Dry:**  
 Flash: 10 minutes  
 Bake: 15 minutes @ 110° F  
 Cool down: 10 minutes  
**Dry Film Thickness:** Maximum DFT for a complete system must not exceed 5 dry mils.  
**Pot Life:** N/A  
**Shelf Life:** 21 months @ 77°F if unopened and stored in a cool dry area. Always rotate stock.  
**Storage:** Keep away from heat and sparks.

### PREPARATION INSTRUCTIONS

**Catalyzation:** This product is packaged pre-catalyzed. Do NOT add catalyst.

#### Reduction:

**Thinning:** Supplied ready-to-spray. If thinning is needed due to conditions in your facility use SOL-9059 HAPs Free Reducer, or SOL-9011 HAPs Free Thinner at levels not to exceed 10% by volume.\*

**Retarder:** 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.\*

#### Note:

\*Thinning this material may result in increasing the VOC levels of this product. Refer to your local regulations before thinning.

#### Approved Companion Products

PCS-1600 Precat Clear Sealer

*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.*

### PRODUCT ADVANTAGES

- Meets KCMA Standards
- Ready To Spray Viscosity
- Self-Sealing
- Resists Moisture
- Resists Chemicals

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## PRODUCT DATA SHEET PCS550-0100 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:

If staining, apply the approved Gemini stain of your choice and let dry per the instructions on the PDS for that particular stain. Use conventional, HVLP, airless, or air assisted equipment to apply this product at 3-4 wet mils per coat. Let dry for a minimum of 25 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-sealing system.

If a sealer is desired, 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 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 PC-16XX series. Maximum dry film thickness of the complete system must not exceed 5 dry mils.



### Recommended Tip Sizes:

Conventional Air	1.3-1.8 mm
HVLP	1.5-1.9 mm
Airless	10-13 thousandths
Air Assisted Airless-	11-13 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 manufacturers' 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-0020 Acetone, or SOL-9032 Zero VOC 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.