



# PRODUCT DATA SHEET

## RAY WB Clear Topcoats

### DESCRIPTION

The RAY clear series is a single component, self-crosslinked acrylic, clear waterborne finish. Ideal for wood surfaces, kitchen cabinets, restaurant and store fixtures, furniture, and fine architectural woodwork. For wood substrates only. For interior use only.

### PRODUCT NUMBERS / SHEENS

RAY-0010 Clear Flat WB TC  
RAY-0020 Clear Dull Satin WB TC  
RAY-0030 Clear Satin WB TC  
RAY-0060 Clear S/G WB TC

### COATING PROPERTIES

**Viscosity:** 70" Zahn #3 (+/-10")  
**Weight Solids:** 34% +/- 1.0%  
**Volume Solids:** 28.8% +/- 1.0%  
**Weight/Gallon:** 8.7 lbs.

**Coverage:** 459 sq. ft. per gallon depending on application method

**VOC (coating):** 0.88 lbs./gl. or 105 g/l  
**VOC (material):** 0.28 lbs./gl. or 34 g/l  
**VOC Ratio:** 0.10 lbs. VOC / lbs. Solids  
**HAPS Ratio:** 0.0 lbs. HAPs / lbs. Solids

**Dry Times:**  
**Air Dry:** at 78°F, relative humidity 50%  
To touch: 8-10 minutes  
To Handle: 30 minutes  
To coat: 1-2 hours

**Force Dry:**  
Flash: 8-10 minutes  
Bake: 15 minutes @ 110°F  
Cool down: 15 minutes  
Stack immediately 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 temperatures and lower humidity and equally slower at colder temperatures and higher humidity.

**Dry Film Thickness:** Total DFT of the complete finish system should not exceed 4.5 mils.

**Pot Life:** N/A

**Shelf Life:** 12 months @ 77°F if unopened and stored in a cool dry area. Always rotate stock.

**Storage:** Protect product from freezing.

### PREPARATION INSTRUCTIONS

**Reduction:**  
**Thinning:** Use water as required. Usually no more than 5% by volume.

**Retarder:** Not recommended

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

Tinting: 896 colorants with 6 fl. oz. max.

### Approved Companion Products

Self-Seal recommended

*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

- Exceeds KCMA Standards
- High Solids and Low Odor
- Fast Dry Times and Stacking Times
- Excellent Film Build Properties
- Excellent Sandability as a Self-Seal System
- PFAS/PFOS/PFOA Free

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## PRODUCT DATA SHEET RAY 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:**

Apply 2 to 3 coats at a rate of 3 to 5 wet mils per coat. Do not exceed 3 coats for the total system. Sandable and recoat-able after 1 hour at 68 °F. Use Scotch-Brite or 220-320 grit sandpaper between coats. Sanding dust must be removed by blowing off or tack ragging. For best adhesion, sand previous coat immediately before applying topcoat and apply topcoat to the sanded surface within 6-8 hours.

Wet film thickness per coat: 3-5 mils. Dry film thickness per coat: 0.9-1.5 mils.



### **Recommended Tip Sizes:**

Air Spraying (cup gun)	nozzle Size 0.066 35-45 PSI
Airless	9-13 thousandths 1450-2175 PSI
Air Assisted Airless	9-13 thousandths Material Pressure 400-600 PSI Assist Air pressure 10-15 PSI



### **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.

Safety Data Sheets are available from your Gemini sales or Customer Service representative. Prior to use of this product, obtain and review the Safety Data Sheet for health and safety information. Read and observe all precautionary notices on container labels.

### **Equipment:**

All equipment used with this product must have plastic, stainless steel, or Teflon fluid passages and wetted parts.

### **Containers:**

All containers used in conjunction with storage and/or application of this product should be stainless steel or plastic to avoid rust.

### **Clean up:**

Use water to clean all equipment when material is in a liquid stage. Use 80/20 mixture of water and Butyl Cellosolve (SOL-0061) to remove semi-dried coating. Clean with Acetone to remove dried coating. Dispose of in accordance with Federal, State, and Local regulation regarding pollution.