



Spray Stain Base

DESCRIPTION

A spray no wipe stain base designed for Industrial shops. It is a spray only stain and is not designed to be wiped. With proper technique this stain allows the finisher to eliminate the blotchy appearance normally associated with difficult to stain woods such as maple, cherry, and birch. For wood substrates only. For interior use only.

PRODUCT NUMBERS / SHEENS

920S1800

COATING PROPERTIES

Viscosity: 14 #2 Zahn
Weight Solids: 0.83 %
Volume Solids: 0.69 %
Weight/Gallon: 7.22 lb./gal
Coverage: 10.99 sq. ft. per gallon at one mil dry film thickness.

PREPARATION INSTRUCTIONS

Tinting:
920S1800 may be tinted with the following colorants:
844 colorants up to 9 oz per gal (7% by volume) max.
Gemini NG Dye Concentrates up to 12.8 oz per gal (10% by volume) max.

When used in combination use no more than 9 oz per gal (7% by volume) max.

Reduction:
Thinning: This product is supplied ready to use. No thinning is recommended.

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

Approved Companion Products
Chromafluo 844 Series Colorants
Gemini NG Dye Concentrates

*We require the use of an insulating agent if using this stain base in conjunction with Polyurethane products. Please refer to the PDS for the particular polyurethane product you intend to use for specific information.

PRODUCT ADVANTAGES

- **Designed Specifically For Industrial Wood Shops**
- **Quick Recoat Time**
- **Short Filled For Tinting**
- **Tint To Any Color With Approved Colorants**
- **HAPs Free**

VOC (reg./coating): 6.88 lb./gl. or 824 g/l
VOC (act/material): 2.38 lb./gl. or 286 g/l
VOC Ratio: 39.85 lb. VOC/lb. Solids
HAPS Ratio: 0.0 lb. HAPS/lb. Solids

Dry Times:
Air Dry: at 78° F, relative humidity 50%
To touch: 3-5 minutes
To handle: 10 minutes
To recoat: 15 minutes
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: N/A

Pot Life: N/A

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

Storage: Keep away from heat or sparks.

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.

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PRODUCT DATA SHEET 920S1800 CONTINUED



Substrate preparation:

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

Tint 920S1800 to desired color and mix thoroughly with mechanical agitation to ensure the colorant is fully incorporated. After tinting, mix material thoroughly before and during use. Material may be mixed by hand or mechanical agitation at moderate speed.



Application:

Typically spray no wipe stains are designed to be applied in two passes. The first pass is applied against the grain and the final pass with the grain. This is especially important when spraying raised panel doors. To achieve an even color across the surface, apply each coat so that the grain is lightly wet. Do NOT spray the stain too dry as this will result in an uneven and opaque appearance. Overlap a minimum of 50%. If the color is not dark enough after two passes the color strength will need to be adjusted.



Recommended Tip Sizes:

Conventional Air	1.0-1.4mm
HVLP	1.3-1.5mm
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 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-9059 Non HAPs 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.