



Machine Applied Coatings Millwork Primer

GENERAL DESCRIPTION

Millwork Primer is designed as an air-dry or force-dry coating to be applied to non-bleeding woods such as pine and hemlock. Primer applications also include solid and finger-joint molding, MDO substrates, or wood composite building materials. Millwork Primer is to be applied only by Professional Authorized Machine Applicators using approved machine application methods and equipment. This primer is not recommended for use on woods prone to extractive or tannin bleeding or on cementitious or masonry substrates.

APPROVED SUBSTRATES

Wood
Wood composites
Medium Density Overlay (MDO)
Medium Density Fiberboard (MDF)

GENERAL SURFACE PREPARATION

Proper surface preparation is essential. Surfaces must be free of dust, sawdust, moisture, oil, grease, mildew, and other contaminants. Substrates should be checked for moisture content. All wood to be coated must be below 19% moisture content. Priming "green" wood with a moisture content of greater than 19% will increase dry-time, inhibit adhesion, and promote extractive bleeding and blistering.

LIMITATIONS OF USE

For use by Professional Factory Finishers only. This product is designed for application only by professional, trained personnel using proper equipment under controlled conditions and are not intended for sale to the general public. Apply only when air and substrate surface are above 50°F (10°C) and at least 5°F (3°C) above the dew point, and primer temperature is above 60°F.

Radiant Infra-Red heat or hot air convection ovens may be used to force dry this product. Care must be taken to avoid overheating so that blisters in the film do not form. If blistering occurs, premature failure of the finish may occur.
All wood to be coated must be below 19% moisture content.

Primed substrates used for exterior application must be topcoated within 30 days after installation.

Protect product from freezing.

PACKAGING

Pail
Drum

PRODUCT AND TINTING INFORMATION

54656 (formerly LP201001) White

PRODUCT DATA

PRODUCT TYPE: Vinyl Acrylic Latex
VOLUME SOLIDS: 34% +/- 2%
WEIGHT SOLIDS: 53% +/- 2%
VOC: <0.4 lbs./gal. (<50 g/l)
WEIGHT/GALLON: 11.7 lbs./gal. (5.3 kg) +/- .2 lbs. (91 g)

COVERAGE: Approximately 250 - 350 sq. ft. (23.2 – 32.5 sq. m.) per gallon (3.78 L). Coverage does not include variation due to application methods, surface porosity, and/or mixing.

Theoretical Wet Film Thickness per Coat:** 4.4 - 6.2 mils
Required Dry Film Thickness per Coat: 1.5 - 2.1 mils

**Additional wet film may be necessary in order to achieve the required dry film thickness.

Viscosity (Stormer @ 77°F): 58 – 63 Krebs***
***Manufacturing specification, working viscosity may vary

DRYING TIME: A minimum of 8 hours at 70°F (19°C) and 50% humidity is recommended for air drying. Drying times listed may vary depending on temperature, humidity, color, and air movement. Under suitable conditions the product may be forced dried.

CLEANUP: Clean equipment with soap and water, high-pressure water jet, or steam cleaner.

DISPOSAL: Dispose of contents and container in accordance with all local, regional, national and international regulations.

FLASH POINT: Over 200°F (93°C)

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APPLICATION INFORMATION

Mixing: Mix thoroughly before use. Mixing blades should be 1/3 the diameter of the paint vessel. The mixing blade should be at least 4 inches from the bottom of the vessel. The goal is to generate axial flow – or a rolling doughnut effect. Simple circular primer flow within a vessel will not generate a well-mixed product. Poor mixing can cause color change within a primer run as well as varying degrees of primer hiding and performance.

Application Equipment: Millwork Primer is formulated to be applied by Authorized Machine Operators and should be applied using approved equipment under specific conditions. Contact your PPG Technical Service Department for application guidelines and assistance.

Thinning: Thinning is not recommended.

General Application Requirements

Substrate and air temperature must be above 50°F. Paint temperature must be at least 60°F. Paint must be mixed thoroughly – see mixing instructions.

Apply 5-6 wet mils – depending on application equipment. Dry mils required 1.5 – 2.1.

*Wet mils applied must result in dry mils required.

**Theoretical Wet Film Thickness per Coat is 4.4 – 6.2 mils.

A one coat system may be applied in two passes by flood or brush coater, spray, or vacuum coater. Paint may be air dried or force cured by convection oven or convection oven with IR assist. (BST 120 – 150°F). Cool to less than 100°F before slip sheet and stacking. Frequently the one coat/two pass system will include a sanding station between passes to address grain raise on the substrate.

Additional Specific Application Conditions

In all applications, the measurement of the wet mils applied may be affected by the application equipment. A minimum dry film build of 1.5 mils is required for a warranty. Temperature and humidity conditions require adjustments to be made to application parameters. These conditions are suggested guidelines, please contact your PPG Technical Service Department for additional assistance and to conduct a review and audit of specific line parameters. Additional wet film may be necessary in order to achieve the required dry film thickness.

Brush Coater

One Coat Application/One Pass: Apply 5-6 wet mils; flash a minimum of 30 seconds to 1 minute; oven setting of 145-200°F to achieve a BST of 120 – 150°F. Time in oven 4 to 8 minutes depending on oven temperature. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 100°F.

One Coat Application/Two Passes: Apply 2.5 – 3.0 wet mils; flash a minimum of 30 seconds to 1 minute; oven setting of 145 – 200°F to achieve a BST of 120 – 150°F. Time in oven 2.5 to 3.5 minutes depending on oven temperature. Cool down 20 to 30 seconds; apply second pass of 3.0 – 3.5 wet mils; oven cure at 145 – 200°F for a minimum of 4 minutes to achieve a BST of 120 – 150°F. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 100°F.

Spray Coater

Spray tip recommendation: .017 or .019 spray tips – evaluate spray pattern before coating to verify that fan width is appropriate and no fingering is visible.

One Coat Application/One Pass: Apply 5-6 wet mils; flash a minimum of 30 seconds to 1 minute; oven setting of 145-200°F to achieve a BST of 120 – 150°F. Time in oven 4 to 8 minutes depending on oven temperature. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 100°F.

One Coat Application/Two Passes: Apply 2.5 – 3.0 wet mils; flash a minimum of 30 seconds to 1 minute; oven setting of 145 – 200°F to achieve a BST of 120 – 150°F. Time in oven 2.5 to 3.5 minutes depending on oven temperature. Cool down 20 to 30 seconds; apply second pass of 3.0 – 3.5 wet mils; oven cure at 145 – 200°F for a minimum of 4 minutes to achieve a BST of 120 – 150°F. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 100°F.

Vacuum Coater*

The vacuum pressure pulled will be dependent on the vacuum system is use. The operator will need to work with the PPG Technical Service Department to determine the appropriate settings.

One Coat Application/One Pass: Apply 5-6 wet mils; flash a minimum of 30 seconds to 1 minute; oven setting of 145-200°F to achieve a BST of 120 – 150°F. Time in oven 4 to 8 minutes depending on oven temperature. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 100°F.

One Coat Application/Two Passes: Apply 2.5 – 3.0 wet mils; flash a minimum of 30 seconds to 1 minute; oven setting of 145 – 200°F to achieve a BST of 120 – 150°F. Time in oven 2.5 to 3.5 minutes depending on oven temperature. Cool down 20 to 30 seconds; apply second pass of 3.0 – 3.5 wet mils; oven cure at 145 – 200°F for a minimum of 4 minutes to achieve a BST of 120 – 150°F. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 100°F.

*IR Ovens may be used in conjunction with the vacuum coater application. Work with the PPG Technical Service Department for assistance in establishing force cure parameters.

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PRECAUTIONS

WARNING! Suspected of causing cancer. Obtain special instructions before use. Do not handle until all safety precautions have been read and understood. Wear protective gloves. Wear eye or face protection. Wear protective clothing. Emits toxic fumes when heated. **Note: These warnings encompass the product series. Prior to use, read and follow product-specific SDS and label information.** **FIRST AID:** If swallowed, seek medical advice immediately and show this container or label. Keep person warm and at rest. Do not induce vomiting. If in eyes, remove contact lenses, irrigate copiously with clean, fresh water, holding the eyelids apart for at least 10 minutes and seek immediate medical advice. If on skin, remove contaminated clothing and shoes. Wash skin thoroughly with soap and water or use recognized skin cleanser. Do not use solvents or thinners. If inhaled, remove to fresh air. Keep person warm and at rest. If not breathing, if breathing is irregular or if respiratory arrest occurs, provide artificial respiration or oxygen by trained personnel. Keep out of the reach of children. For workplace use, an SDS is available by calling (412) 492-5555. EMERGENCY SPILL INFORMATION: (412) 434-4515 (U.S.).

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