

PRODUCT DESCRIPTION

Millwork Primer is a fast-drying, stackable primer designed for interior surfaces where a smooth finish and uniform appearance is desired. This product sands with minimal effort and can be used on most unpainted interior substrates including wood, MDF, hardboard, plywood, etc.

FEATURES & SPECIFICATIONS

PERFORMANCE FEATURES

- Seals Multiple Surfaces
- Fast Dry
- Easy to Sand
- Good Enamel Holdout

SUBSTRATES

- ✓ Wood
- ✓ MDF
- ✓ Hardboard
- ✓ Plywood

APPLICATION METHODS

- ✓ Vacuum Coat
- ✓ Fan/Flow Coat
- ✓ Curtain Coat
- ✓ Spray

AVAILABLE PRODUCTS

FINISHES: 9001 Primer

BASES: 0 White

SIZES: Five Gallon, 50 Gallon, 250 Gallon

PRODUCT SPECIFICATIONS

RESIN TYPE: 100% Acrylic

VOC (ASTM D6886): < 2 g/L

SOLIDS BY VOLUME: 50 ± 2%

WEIGHT PER GAL: 13.8 ± .25 lbs.

SUBSTRATES & SYSTEM RECOMMENDATIONS

PREP: All surfaces must be cured, firm and dry. Prepare material to a viscosity of 20 – 34 secs #2 EZ ZHAN based on application below. Exact viscosity will depend on equipment, substrate, drying required, etc.

PRIME: Product is intended for horizontal flatline application.

Application Temperature: 50°F - 100°F
Dry Time: 5 mins @ 140°F

Vacuum Coat

Reduction: <5% Water, If Necessary
Nominal Pressure: 40-50 in of water column
Nominal Line Speed: 200-300 ft/min
Thickness: 3-4 Mils Wet / 1.5-2.0 Mils Dry per pass

Curtain Coat

Reduction: <2% Water, If Necessary
Nominal Line Speed: 400-600 ft/min
Thickness: 3-5 Mils Wet / 1.5-2.5 Mils Dry per pass

Fan/Flow Coat

Reduction: <2% Water, If Necessary
Nominal Line Speed: 400-600 ft/min
Thickness: 3-5 Mils Wet / 1.5-2.5 Mils Dry per pass
Tip Size: Variable, dependent on line speed, film thickness, part configuration, etc.

Airless Spray

Reduction: <3% Water, If Necessary
Pressure: 1500-2000 PSI
Tip Size: .017”-.021” orifice
Thickness: 3-5 Mils Wet / 1.5-2.5 Mils Dry per pass

HVLP Spray

Reduction: <5% Water, If Necessary
Air Pressure: 35-45 PSI
Fluid Pressure: 8-10 PSI
Needle/Nozzle/Cap: 1.3-1.4 mm
Thickness: 3-5 Mils Wet / 1.5-2.5 Mils Dry per pass

**See following pages for detailed preparation and application instructions.*

PREPARATION & APPLICATION

BEFORE PAINTING

GENERAL PREPARATION: All surfaces must be cured, firm, dry and cleaned free of dust, dirt, oil, grease, wax, chalk, rust, mildew or any other contamination or condition that would adversely affect the performance of the coating.

MOISTURE: All surfaces should be dry before painting. Wood, MDF, Hardboard, and Plywood should have an internal moisture content of less than 15%.

MIXING: Mix well before use. Solids must be dispersed evenly before application.

THINNING: Apply at can consistency/viscosity. If thinning is necessary to maintain workability, do not exceed 5%.

CONTAINERS AND TOOLS: Transfer material into a clean container for use. Use new or thoroughly cleaned tools. To avoid contamination, do not re-dip applicators or add used material into containers being used for storage.

EQUIPMENT: Ensure all application equipment is in proper working condition before loading the paint reservoir.

TESTING: Prior to full application, apply a test sample of the material to each substrate to ensure the preparation and coating system are appropriate for the use. Test adhesion per ASTM D3359. If test sample results do not meet the needs of the project, contact a Kelly-Moore representative for recommendations.

DURING PAINTING

COVERAGE: May vary depending on method of application, porosity and texture of the surface.

FILM THICKNESS: Always follow recommendations for application thickness on page 1. Over application may reduce performance and can lead to runs, extended dry times or a soft film.

AFTER PAINTING

DRYING: 140°F for 5 minutes. 110°F minimum BST out of oven before second coat or stacking after second coat.

STACKING: This product is designed to be stack at end of most productions lines. If the finish product is going to be stacked, perform a stack test is during the testing phase as each line may have different curing conditions based on application and drying.

CLEANING: Perform general clean-up with water. For difficult to clean surfaces, use a mixture of 50% butyl cellosolve and 50% water.

STORAGE: Store material at room temperature in a clean, tightly sealed container free of outside materials. Protect from freezing.

WARRANTY: The statements made on this label, product bulletins, or by any of our agents concerning this material are given for information only. They are believed to be true and accurate and are intended to provide a guide to approved construction practices and materials. As workmanship, weather, construction equipment, quality of other materials and variables affecting results are all beyond our control, Kelly-Moore Paint Company, Inc. does not make nor does it authorize any agent or representative to make any warranty of MERCHANTABILITY OR FITNESS for any purpose or any other warranty, guarantee or representation, expressed or implied, concerning this material except that it conforms to Kelly-Moore's quality control standards. Any liability whatsoever of Kelly-Moore Paint Company, Inc. to the buyer or user of this product is limited to the purchaser's cost of the product itself.

SAFETY INFORMATION

CAUTION!

Harmful if inhaled. Causes eye, nose, throat and lung irritation. Overexposure may cause lung damage. Close container after each use. Keep away from heat and flame.

Do not breath dust, vapors or spray mist. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

Ensure fresh air entry during application and drying. If you experience eye watering, headache or dizziness or if air monitoring demonstrates vapor/mist levels are above applicable limits, wear an appropriate, properly fitted respirator (NIOSH approved) during and after application. Follow respirator manufacturer's directions for respirator use.


If spilled, contain spilled material and remove with inert absorbent. Dispose of contaminated absorbent, container and unused contents in accordance with local, state and federal regulations.

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WARNING! If you scrape, sand or remove old paint from any surface, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH approved respirator to control lead exposure. Carefully clean up with a wet mop or HEPA vacuum. Before you start, find out how to protect yourself and your family by contacting the U.S. EPA/Lead Information Hotline at 1- 800-424-LEAD (5323) or log on to www.epa.gov/lead.

First Aid: If you experience difficulty in breathing, leave the area to obtain fresh air. If continued difficulty is experienced, get medical attention immediately.

**DO NOT TAKE INTERNALLY
USE ONLY WITH ADEQUATE VENTILATION
KEEP OUT OF REACH OF CHILDREN**

 **WARNING** Cancer and Reproductive Harm
www.P65Warnings.ca.gov/product

REFER TO PRODUCT'S SAFETY DATA SHEET (SDS) FOR ADDITIONAL HEALTH AND SAFETY INFORMATION

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