

# PKF750x Series

## Zenith Conversion Varnish

Date: January 10<sup>th</sup>, 2018 (supersedes all previous revisions)



### GENERAL INFORMATION

Axalta's Zenith™ Clear Conversion Varnishes are our next generation, highest-performance blend of acrylic and urethane self-crosslinking resins. Designed for finishing kitchen and bath cabinets or any woodwork needing the ultimate in protection and UV resistance. Easily passes KCMA standards and is formaldehyde and isocyanate free.



### 1. PRODUCTS

- PKF7501 PKF7502 PKF7504
- PKF7506 PKC7509



### 2. MIXING RATIO

- Stir thoroughly, do not shake



### 3. SHELF LIFE @ 77°F (25°C)

- 1 year



### 4. CLEAN UP

- Clean equipment with warm water. If coating has dried, acetone may be required to remove dried film. Keep container closed when not in use to avoid skinning



### 5. ADDITIVES

- If needed to extend dry time use Waterborne Retarder YXT0700/YXC0384 at a rate of 1-4% by volume.



### 6. SURFACE PREPARATION

- Surface must be clean and dust free with a moisture content of 6-8% prior to finishing. Remove all dust, dirt, wax and wood marks. Proper sanding and preparation of the wood is critical to achieving consistent results.
- On new wood, finish sand surface with 150-180 grit sandpaper
- On previously finished wood, remove all old paint or varnish and follow new wood procedure.



### 7. COMPANION PRODUCTS

- LKS7400 Zenith Clear Sealer
- Zenith Waterborne stains and glazes
- Zenith Waterborne Basecoats and Opaques



### 9. SUBSTRATES

- Commonly used furniture and cabinetry woods
- MDF/HDF

**NOTE:** Not to be used on exterior applications



### 10. APPLICATION

- Ready to spray. May be used as a self-seal topcoat. No thinning is recommended.
- Do not apply more than 4 coats at 3-4 wet mils per coat when used as a self-seal system. Maximum film thickness of the total coating system must not exceed **4 dry mils**.



### 11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	20 - 25 Minutes
Flash between coats	35 - 45 Minutes
To Stack	Overnight



### 12. FORCE DRY

Flash	10-12 Minutes
Bake	15 Minutes @ 130°F
Cool Down	15 Minutes ambient
Stack	After cool down/overnight



### 13. GUN SET UP

Gravity Feed	1.6 mm - 1.8 mm
Siphon Feed	1.8 mm - 2.0 mm
Airless	10 - 15 thousandths
Air-Assisted Airless	11 - 15 thousandths

### AIR PRESSURES

Gravity Feed	30-35 psi (2.0-2.4 bar)
Siphon Feed	35-40 psi (2.4-2.8 bar)
Air-Assisted Airless	5-10 psi (0.3-0.7 bar)
See spray gun manufacturer data for more information	



### 14. PHYSICAL DATA

Viscosity	14-18 Sec EZ Zahn #3
Weight Solids %	37.55%
Volume Solids %	34.66%
Actual VOC	0.50 lb/gal
VOC Ratio (lb.voc/lb.solids)	0.14 - 0.15
Regulatory VOC (less water and exempt solvents)	145 g/l
Weight Per Gallon	8.58 - 8.72 lb/gal
Flash Point	201°F
Theoretical Coverage	547.68 ft/gal @ 1 mil
VHAP (lb.HAP/lb.solids)	0.00 HAPS Free
Photochemically Reactive	No
Coating Category	Clear Topcoat

The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Axalta assumes no obligation or liability for use of this information. **UNLESS AXALTA AGREES OTHERWISE IN WRITING, AXALTA MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. AXALTA WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES.** Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option. The information in this sheet, as well as the products referenced herein, shall be considered "Confidential Information". Wet samples and uncured samples of these products shall be maintained as confidential and shall not be disclosed to any third party without the prior written permission of Axalta. IU-COR-00047

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### Application Notes:

Always pre-test the system on your substrate to verify suitability of the application.

If staining, use an approved Axalta Stain and let dry per the directions on the Technical Data Sheet for the stain you choose.

DO NOT SHAKE! Stir thoroughly before use and occasionally during use. If using an air mixer or drill, run on low speed.

Apply by spray only, using Conventional Air, HVLP, Airless, or Air Assisted Airless equipment. Apply at a rate of 3-4 wet mils per coat.

Sand between coats with 240-320 grit, no fill sandpaper. Remove sanding dust before applying the next coat. This finish must be sanded between coats for proper adhesion.

DO NOT APPLY more than 4 coats at 3-4 wet mils per coat when used as a self-seal system. Maximum film thickness of the total coating system MUST NOT EXCEED **4 dry mils**.

Do not apply if the material or substrate temperature is below 60°F.

This product is best applied when surface, material, and air temperatures are between 60-100°F and when relative humidity is below 50% during application and drying time.

Low temperatures, poor air circulation, or high humidity will extend dry times. Abnormal conditions of temperature or humidity may adversely affect product performance.

### Clean Up:

Clean equipment with warm water. If coating has dried, acetone may be required to remove dried film. Keep container closed when not in use to avoid skinning. Do not transfer contents to other containers for storage or disposal. In case of spillage, absorb with inert material such as sand or kitty litter. Dispose of empty cans or unused portion in accordance with local, state and federal regulations.

### Precautions:

These products are recommended for professional application and are designed for interior use only. Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and to avoid potential need for costly refinishing. Axalta Industrial Wood products are designed to protect and enhance the natural beauty of wood, but cannot eliminate natural discoloration or deterioration of wood as it ages.

### Additional notes:

Do not mix with other finishing systems or deviate from these finishing recommendations. Axalta will not be held liable for finish failures resulting from the mixing of products or deviations from finishing recommendations.

### Storage:

Store in a cool, dry place. DO NOT FREEZE! Product should be stored in temperatures between 50°-110°F. Close all containers after use. Do not store near heat or sparks. Spills should be cleaned up with non-sparking tools. [See the product SDS for complete safety information.](#)

### Warning:

Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and avoid potential need for costly refinishing. All dry times listed are as tested under ideal indoor environmental conditions of 78°F (26°C) with relative humidity not exceeding 50%. These products are recommended for use under temperature conditions of 60-100°F (16-38°C) and when relative humidity is below 50% during application and drying time. Low temperatures, poor air circulation or high humidity will extend dry times. **Axalta strongly recommends against use of these products if temperatures of air, material, or surface to be coated are below 60°F (16°C) or below the dew point. Abnormal conditions of temperature or humidity may adversely affect product performance.** Please contact your authorized Axalta Industrial Wood Coatings distributor for additional product use recommendations and finishing guidance.