

Pro Hi-Build™ 680 White Undercoater

OPAQUE LACQUER SANDING SEALER/UNDERCOATER WHITE

Product Code **653025**

Pro Hi-Build™ 680 is a single -component, high solids, opaque white lacquer sanding sealer/undercoater ideal for use on interior wood surfaces.

Ideal for

- Millwork
- Doors
- Interior wood surfaces
- AIM compliant at 680 g/l VOC

Performance Benefits

- Fast dry
- Easy to sand
- Excellent hide
- High Solids
- High Build

APPLICATION DATA

SURFACE PREPARATION: "White sand" wood with maximum 150 grit aluminum oxide sandpaper. Remove all sanding dust. Keep free of dirt, grease, silicone oils, lubricants and other contaminants.

APPLICATION EQUIPMENT: This product is designed for spray application through all types of equipment. Recommended settings are with trigger pulled:

Airless	No thinning required. Spray at 1000 to 1200 psi 411 or 513 tip
Air Assist	No thinning required. Spray at 700 to 900 psi fluid pressure 10 to 12 psi air cap, 411 or 513 tip.
HVLP	Thin up to 20% with recommended thinner. Spray at 28 psi through a 1.4 fluid nozzle.

THINNING: This product is designed to spray at package viscosity with airless application equipment. Thinning requirements may vary with changes in temperature and spray room conditions. If thinning is desired, use 650870 Premium Lacquer Thinner, 652081 VOC Exempt Lacquer Thinner, 652210 HAP Lacquer Thinner, or Acetone.

Note: Thinning will reduce film build and may increase VOCs or HAPs unless using VOC Exempt or HAP-free solvents. Consult your local regulations before thinning.

AGITATION: This product must be kept under slow, constant agitation to ensure proper mixing.

CLEAN UP: Use lacquer thinner compliant with local air quality rules

FINISHING SYSTEM

SEAL: Apply one coat (46 mils wet) of Pro Hi-Build 680 White Undercoater. Allow 20 minutes* dry time and sand with 220 grit silicon carbide sandpaper before finishing.

FINISH: Apply two coats (45 mils wet) of Rudd 680 Opaque PreCat or NC Lacquer. Allow 20 minutes* dry time and sand with 220/320 grit silicon carbide sandpaper between coats.

If desired, additional coats may be applied up to a total dry film of 5.0 dry mils.

*Dry times will vary with film thickness, temperature, humidity and air movement.

SAFETY PRECAUTIONS

Avoid breathing vapors, use a NIOSH approved cartridge respirator. Use prefilters to avoid breathing spray particles or sanding dust.

Flammable Liquid and Vapor. Keep away from heat, sparks and flame. Ensure adequate ventilation during use. Clean up spills with non-sparking tools and inert absorbent material. Store solvent and lacquer soaked rags and filters in watered, closed containers prior to disposal. Dispose of in safe, approved manner.

Read Material Safety Data Sheet and label before using.

SPECIFICATIONS	
Coverage	390 square feet per gallon @ 1 mil dry film thickness
Viscosity	95—105KU (Krebs Units @ 70° F)
Solids	42.0% by weight
VOC (Volatile Organic Compounds)	
VOC Regulatory	642 g/l (5.35 lbs/gal)
VOC Actual	640 g/l (5.34 lbs/gal)
VOC Ratio	1.34 lbs VOC/lbs Solid
HAP (Hazardous Air Pollutants)	Pounds HAPs per Pound Solids (HAPs Ratio)
	1.08
Dry to Sand	20 minutes @ 65-70° F
CAUTION: Thinning will reduce film build and may increase VOCs and HAPs unless using VOC Exempt and/or HAP-free thinner. Consult your local regulations before thinning.	

APPLICATION PRECAUTIONS

Pro HiBuild 680 Opaque Lacquer Sanding Sealer/Undercoater must not be used with conversion varnishes.

Thinned material may cause product to 'hard settle' over time. When thinning, thin only the amount of product that will cure in a 24-hour period.

This product is not recommended for exterior use.

Finish, substrate and curing temperatures should remain above 60°F, extremes of temperature and humidity may affect product.

Total film build of system must not exceed 5.0 dry mils.

This product has been tested on a limited number of substrates and under a limited number of coatings. The user is responsible for testing suitability and performance for their specific application.

Designed for professional use by spray application only.

Shipping & Storage Information

Flash Point: -4°F Pensky-Martin

OSHA Flammability Class: Flammable Liquid Class IB

DOT Class: Paint, 3, UN 1263, PG II



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