

CONVERSION VARNISH

Scion™ ZF 680

CLEAR FORMALDEHYDE FREE CONVERSION VARNISH

Product Code: 310630

Scion™ ZF 680 Clear Conversion Varnish is a two-part, formaldehyde free, acid cure conversion varnish ideal for interior wood cabinetry where a flawless finish is required.

Ideal For

- Kitchen cabinets
- Bathroom cabinets
- Wood placed in high moisture areas
- Residential table and bar tops
- Exceeds KCMA performance tests
- AIM compliant 680 g/l VOC
- NESHAP compliant—JJ (furniture)
- NESHAP compliant—QQQQ (doors & windows)

Performance Benefits

- Zero Formaldehyde CV resin technology
- Low odor
- Clear finish (inherent slight yellow cast)
- Color of clear finish will not change
- Excellent water and chemical resistance
- 24 hour pot life
- Excellent flow and leveling
- High Build
- Excellent sanding properties
- Super-low HAP

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. Mixing or pumping equipment that is in constant contact with Conversion Varnish should be constructed of stainless steel or other anti-corrosive material. Recommended settings below are with trigger pulled.

| | |
|------------|--|
| Airless | No thinning required. Spray at 1000 or 1200 psi 411 or 513 tip |
| Air Assist | No thinning required. Spray at 700 to 900 psi fluid pressure 10-12 psi air cap 411 or 513 tip |
| HVLP | No thinning required. Spray at 28 psi through a 1.4 fluid nozzle |

THINNING: This product is designed to spray at package viscosity with most application equipment. Thinning requirements may vary with changes in temperature and spray room conditions. If thinning is desired, use only 650870 Lacquer Thinner.

Note: Thinning will reduce film build and will increase VOCs and HAPs.

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 and regulations.

FINISHING SYSTEM

MIXING DIRECTIONS: Add 3% (4 fluid ounce) of Rudd 03-350 ZF Catalyst per gallon. Stir well during and after adding catalyst.

POT LIFE: 1 day (24 hours) @ 65-70°F.

STAIN: When staining wood, use Rudd ColorTools™ Dye Stains, ColorTools™ Spray Only Stain, or ColorTools™ Wiping Stain.

SEAL: Apply one coat (3-4 mils wet) of Scion ZF 680 Sealer. Allow to dry 20 minutes*. Sand with 220/320 grit silicon carbide sandpaper before finishing.

FINISH: Apply one or two coats (3-4 mils wet) of 310630 Scion ZF 680. Sand between all coats with 220/320 grit silicon carbide sandpaper.

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

*Dry time will vary with film thickness, temperature, humidity & air flow.

SAFETY PRECAUTIONS

.Avoid breathing vapors, use a NIOSH approved cartridge respirator. Use pre-filters 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 water-filled, closed containers prior to disposal. Dispose of in safe, approved manner.

Read Safety Data Sheet (SDS) and label before using.

FINISH PERFORMANCE TESTING

KCMA

| | |
|-------------------|---|
| Vinegar | No Visual Effect |
| Lemon Juice | No Visual Effect |
| Orange Juice | No Visual Effect |
| Grape Juice | No Visual Effect |
| Catsup | No Visual Effect |
| Olive Oil | No Visual Effect |
| 100 Proof Alcohol | No Visual Effect |
| Hot Coffee | No Visual Effect |
| Edge Soak | Passed 24 hr KCMA test with no softening, discoloration or film defects |
| Cold Check | Passed 20 cycles @ 5 mils dry film |

OTHER

| | |
|-----------------|--|
| MEK Resistance | 150+ single rubs showed no removal of finish |
| Hot Water Ring | Slight marking at 190° F after 1 hour |
| Pencil Hardness | Pass 2B |
| Mar Resistance | Excellent |
| Adhesion | Excellent |

SPECIFICATIONS

| | |
|-------------------------------------|---|
| Coverage | 425 square feet per gallon @ 1 mil dry film |
| Viscosity | ~22 Seconds (#2 Zahn @ 75°F) |
| Sag Resistance | 4 mils vertical @ 65-70°F |
| Solids* | 32.4—34.1% by weight 2.54—2.70 lbs per gallon |
| VOC (Volatile Organic Compounds) | Calculated: 5.22—5.29 lb/gal 626—634 g/l |
| HAP (Hazardous Air Pollutants) | Pounds HAP per Gallon: 0.036 Pounds HAP per Pounds Solids: < 0.8 (actual 0.013—0.014) Pounds HAP per Volume Solids: < 0.48 (actual 0.135—0.141) |
| Dry to Sand | 20 minutes @ 65-70°F |
| Block Free | 24 hours |

*Variations depend on gloss. CAUTION: Thinning will reduce film build and increase VOCs and HAPs.

APPLICATION PRECAUTIONS

- This product MUST be catalyzed with 03-350 ZF Catalyst. Do not catalyze with any other Rudd acid catalyst.
- This product has an inherent slight yellow cast and cannot be made water-clear. The dry film will not change color.
- Do not thin this product with Acetone or solvent blends containing Acetone. Use Rudd 650870 Lacquer Thinner.
- This product MUST be sanded between all coats to ensure proper adhesion. This product MUST be re-coated within 8 hours of being sanded.
- Total film build of system must not exceed 5.0 dry mils.
- Finish, substrate and curing temperatures should remain above 60°F, extremes of temperature and humidity may affect product performance.
- Do not use alkaline based products to clean surfaces finished with the Scion ZF Clear Conversion Varnish system.
- This product is not recommend for exterior use.
- This product has been tested on a limited number of substrates and over a limited number of coatings. The user is responsible for testing suitability and performance for their specific application.
- Designed for professional use with spray application only.

Shipping & Storage Information

Flash Point: 55°F Pensky-Martin

OSHA Flammability Class: Flammable Liquid—Class IB

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



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