Product Data Sheet

morrells®

xerofire Intumescent Basecoat & xerofire Clearcoat

Code	Description	Code	Description
7XBA/800	xerofire Intumescent Basecoat - Part A	7X*3/457	xerofire Clearcoat
7XBB/400	xerofire Intumescent Basecoat - Part B	7CAT/457	xerofire Clearcoat Catalyst
7XCL/000	xerofire Cleaner	7X07/457	xerofire Clearcoat Thinners
7XIS/127	xerofire Isolator	7XR/000	xerofire Basecoat Retarder

Technical Data	A unique range of leading technology, professional woodfinishing products formulated to upgrade (or maintain) the fire-rating of a wide variety of wood-based substrates including veneered panels, solid hard and softwood's, plywood, MDF and wood-composite boards. The xerofire Clearcoat is available in 90, 50, 40, 30, 20 and 10% Sheen levels.
Properties	The xerofire system comprises of a 2K Waterborne Intumescent Basecoat together in combination with a 2K Acid Catalyst Clear Topcoat providing a high quality and excellent aesthetic furniture grade finish. This system complies with the requirements for Class 0 defined in Appendix A paragraph 13 of Approved Document B "Fire Safety" to the Building Regulations and has achieved the Euro reaction to fire classification of B-s1,d0. The xerofire system also achieves the minimum requirements of FIRA Standard 6250 Horizontal Surfaces – Severe Use.
Certification/Accreditation	BS 476: Part 6: 1989 +A1: 2009 – Method of Test for Fire Propagation of Products – Report Number: 315455 issued 25th April 2012 by Exova Warrington. BS 476: Part 7: 1997 – Method for Classification of the Surface Spread of Flame of Products – Report Number: 315456 issued 25th April 2012 by Exova Warrington. EN 13501-1 : 2007 +A1 :2009 "Euro" Classification B-s1,d0 – Report Number 333923 issued 4th November 2013 by Exova Warrington. **The user should consider the Fire Retardant Accreditation for this product range as a guideline only. The tests conducted encompass the whole finishing system which may comprise additionally of substrate, adhesive, veneer and coating, and not just the coating. Application methods and coating weights are also factors which will also influence fire retardancy.** **It is the responsibility of the user to ensure that their specific system/application achieves/maintains the required Fire Retardant rating.**

Mixing Guidelines	**Xerofire isolator :** Supplied ready for use. This is recommended to avoid potential discoloration, particularly with acid sensitive timbers and fruitwoods such as maple, cherry and ash. **xerofire Intumescent Basecoat :** Due to its acidic nature this material may cause discoloration to certain timbers. Mix 2 Parts of 7XBA/800 with 1 Part of 7XBB/400 by volume. For best results add Part B slowly into the pack containing Part A and mix thoroughly until homogenous. Allow to rest 10 minutes after mixing before use. Once mixed the blend is ready for use (RFU). Mixed/reacted Xerofire Basecoat has a useable pot-life of 8-10 hours in ambient conditions. In temperatures above 25 degrees C xerofire Basecoat Retarder (7XR/000S) is recommended, added at 2-3% into catalysed xerofire Intumescent Basecoat. This product should not be thinned. In some instances a slight black tint may be apparent in the 7XBA/800 – this is a natural occurrence and does not affect the colour or performance of the applied coating. **xerofire Clearcoat :** Mix 9 parts Lacquer with 1 part 7CAT/457 by volume. The catalysed lacquer is ready for use (RFU) but can be thinned up to 5% by volume with the recommended thinner, 7X07/457, if required. Under normal conditions these products will have a workable pot-life of 36 hours after catalysis.
Application Guidance	These products are designed for spray application only. They should only be applied at temperatures > 10°C and with a relative humidity (RH) of < 65%. Recommended settings: Based on either a Sprayshop MX 32:1 or a Kremlin Eos Pump (33:1) the recommended settings for the xerofire Isolator, Intumescent Basecoat and Clearcoat are : Air Pressure: 1.5 – 2Bar Fluid Pressure: 1.5 – 2Bar Tip-Size: 0.9 – 0.11 thou For automated line applications please speak to our Technical Support Team for guidance.
Typical Handling	**Xerofire isolator** Touch dry 1-2 hours @ 18C Sandable 1-2 hours @ 18C.Use 320 grit paper to de-nib. **xerofire Intumescent Basecoat** Touch Dry: 2 - 3 @ 18°C Sandable: 3 - 4 hours @ 18°C. Use 320 grit paper to de-nib. Recoatable: 3 - 4 hours minimum @ 18°C

	This product can remain with a residual 'tack' dependent upon environmental conditions but this will not affect performance. We recommend the use of disposable or cotton gloves whilst handling to avoid unnecessary damage to the finish. **xerofire Clear coat** Touch Dry: 25 - 30 mins @ 18°C Packing Time: Overnight minimum i.e. at least 24hrs after xerofire Clearcoat has been applied, dependent on conditions. Packing media with contours such as corrugated card or bubble wrap should be avoided on the coated faces of xerofire panels. Morrells recommends a layer of brown packing paper or compressed foam packing sheet is laid uniformly across the whole face of the panel when packing/wrapping
Cleaning	**Xerofire isolator** 2007/100 should be used for equipment cleaning. It is recommended that separate, dedicated spray guns and fluid lines are used for the application of xerofire Basecoat and xerofire isolator to avoid contamination. **xerofire Intumescent Basecoat** Use water to clean down equipment immediately after use and then flush with xerofire Cleaner, 7XCL/000. xerofire Cleaner should also be used for more thorough cleaning tasks. To clean dried/cured material use X001 - Fast Thinners or 2007/100 - Gun Cleaner. Failing to clean guns and lines after use can lead to irreparable damage. **xerofire Clearcoat** 2007/100 should be used for equipment cleaning. It is recommended that separate, dedicated spray guns and fluid lines are used for the application of xerofire Basecoat and xerofire Clearcoat to avoid contamination.
Coverage	Each pack of material applied at a transfer efficiency of 70% will typically give coverage of : **Xerofire Isolator (5 litres):** 40 m^2 **xerofire Intumescent Basecoat – 2 coats (12 litres) :** 30 m^2 **xerofire Clearcoat (5 litres):** 40 m^2 Coverage is dependent upon the size, orientation and surface quality of the item being coated, and the transfer efficiency of the application method/equipment.
Tinting	This range is not suitable for tinting. xerofire Intumescent Basecoat can be used over Morrells Light Fast and Classique stains. A minimum of 1 hour drying at ambient temperature should be allowed before over coating these stains.

System Guidelines	Morrells recommends the following guidance for use of this product range: **Typical Finish:** • It is recommended that all edges are arrised to achieve optimum coating weights. • Ensure there is a minimum operating temperature of 10°C & a relative humidity < 65%. • Apply 1 coat of xerofire isolator @ 60-70 g/m2 and allow to dry for 1-2 hours. Denib with 320 grit . • Apply 1 coat of mixed/reacted Xerofire Intumescent Basecoat at a minimum of 152µ wet film thickness (approximately 180 - 190g/m^2). • Air dry in a dust-free environment for a minimum of 3 hours. • Optimum wetting and clearing of xerofire basecoat is achieved if left out of airflow after application for 30 minutes. • No denibbing required unless there is 4 hours or longer between recoating. If required lightly denib with 320/400 grit paper. • Apply a 2nd coat of **freshly** mixed/reacted xerofire Intumescent Basecoat at a minimum of 152µ wet film thickness (approximately 180 -190g/m^2). • Leave to air dry overnight. • Heat and airflow should be introduced to the panels for 1-2 hours prior to sanding and top xerofire topcoat application in order to reduce further moisture.The basecoat should have a MC of below 20 prior to topcoating. • Lightly denib with 320/400 grit paper. • Apply 1 coat xerofire Clearcoat at 76µ wet film thickness (approximately 70g/m^2). No more than 1 topcoat should be applied. Using these products in systems outside the recommended guidelines can lead to immediate and latent problems with the integrity of the finish and the end rating of the panel.
Important Information	➢ Designed for spray application. ➢ Products not recommended in this Product Data Sheet should not be used as part of the xerofire finishing system. ➢ Users should prepare a test panel prior to commencement and satisfy themselves that the specific system provides the appearance and level of performance appropriate for the end-use prior to undertaking any contract. ➢ Xerofire Isolator, xerofire Intumescent Basecoat and xerofire Clearcoat should have nominated, dedicated finishing equipment. ➢ Douse all waste materials associated with this/these materials with water before disposal and avoid prolonged/excessive exposure to heat. ➢ Store all waste materials in secure metal container outside, away from combustible materials overnight. ➢ It is advisable that the suitability of application equipment (guns, tip-sizes, pumps etc) and all associated sundries (abrasives, stains, cleaners etc.) should be considered and checked with Morrells Technical Support team when using xerofire finishing systems. ➢ Avoid contact with iron, copper, zinc, aluminum and platinum as these can attack the aqueous polymer. Ensure these metals are not present in finishing equipment used for xerofire Basecoat.

	➢ Morrells do not recommend the mixing of catalysed material with fresh material. Always mix enough for the job. ➢ Under catalysing or over catalysing can cause impairment of cure and cracking. ➢ Excessive coating weights, over-coating too early or excessive denibbing can lead to cracking or lifting. ➢ When coating darker timbers, such as walnut, mahogany or teak, slight bleaching/milkiness may occur. ➢ Users should prepare a test panel prior to commencement and satisfy themselves that the specific system provides the appearance and level of performance appropriate for the end-use. ➢ This type of finish reaches is full cure cycle 21-28 days after application. ➢ Product should be stored above 10°C and protected from frost. xerofire Intumescent Basecoat and Xerofire Clearcoat should be 'acclimatised' to a minimum of 10°C overnight prior to use for optimum results. ➢ Optimum application is achieved between 15°C and 25°C with good air movement and ventilation. ➢ Finished products should not be subjected to environments with temperatures of < 10°C. ➢ Out of scope with 2004/42/EC.
Health & Safety	Reference should be made to the appropriate MSDS for this product range, which can be found at www.morrells.co.uk The use of appropriate personal protection equipment (PPE) is recommended. xerofire Intumescent Basecoat Part A (7XBA/800) is classified as corrosive and so appropriate care should be taken when handling and using it. These products are intended for ***professional use*** only.

The information provided on this information sheet is based on the best of our knowledge and experience, is given in good faith and should only be regarded as recommendations. No guarantee should be inferred and customers are advised to carry out their own tests under local conditions.

For further technical information contact our Technical Support Team on 0161 406 5300.