

# Mohawk Finishing Products

A Division of RPM Wood Finishes Group, Inc.

## Product Data Sheet

### Sizing Liquid

M472-221

Available in 16 fluid ounces

**Product Description:** Mohawk's "Sizing Liquid" is a clear, fast drying, light color material that is designed to fix Gold and Silver Leaf gilding.

Advantages:

1. Easy to Brush
2. Excellent Flow
3. Good Tack Time

Product Limitations:

1. Not for use over latex

### Characteristics:

Weight per gallon: 7.47 lbs/gal

Flash Point: 91° F

Package Viscosity: 20 – 22 seconds #2 Zahn cup

Solids % (wt): 48.3

Solids % (vol): 42.6

Dry time: Air dry @ 72° F, 35% relative humidity

To apply leaf: 1- 4 hours depending on thickness of coating.

Application window: 2-3 hours depending on thickness of coating.

To seal leaf: 12 hour minimum, allow additional time for heavier sizing applications.

Gloss: 90+

VOC's (coating): 3.86 lbs/gal (463.08 g/l)

VOC's (material): 3.86 lbs/gal (463.08 g/l)

VHAP's: 0.0021 lbs VHAP's/lbs solids

Coverage: 650 square ft/gal @ 1 dry mil

Package Life: 2 years

HMIS: Health – 1, Flammability – 2, Reactivity – 0, Personal Protection – X

### Specifications:

**Directions:** Surface should be clean and dry. Mohawk Sizing Liquid, clear in color, is especially prepared for all leaf requiring a quick size. The article to be gilded must first be properly sealed and be thoroughly dry before applying Mohawk Sizing Liquid.

Sizing Liquid is a quick drying size with a workable tack time of about four hours. On frame gilding, use very sparingly, but for outside work, use it more freely. If necessary the dry time can be made slower by the addition of a small amount of Boiled Linseed Oil.

**See leafing tips below for additional information.**

**Safety and Other Precautions:** Read MSDS for precautions before using product.

**MSDS:** If Material Safety Data Sheet is required, contact:

Mohawk Finishing Products

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## Mohawk Sizing Liquid & Application of Leaf

Following are the steps we recommend for applying leaf using Mohawk Sizing Liquid. This process is important and short cuts will result in poor adhesion, opening seams etc. Following the directions for dry times and coating are critical for a successful finish.

Sealing the substrate is important. We recommend our EZ Vinyl Sealer both under and over the leaf. The substrate should be well sealed so the sizing liquid will form a smooth, thin continuous film over the area to be leafed. On raw wood apply an even wet coat of EZ Vinyl Sealer and sand aggressively and then apply a second coat of EZ Vinyl Sealer and allow to dry thoroughly. Scuff sand the sealer with 320 grit steared sand paper and remove the sanding dust.

Apply a thin wet coat of Mohawk Sizing Liquid in a solid, continuous film over the area to be leafed. Allow the Sizing Liquid to tack before using; typical tack times are approximately 1 to 1.5 hours depending on the amount of sizing applied. Heavier applications will give longer application windows and can be helpful on larger projects and exterior applications. A good indicator for proper start times is when you can lightly drag your finger knuckle against the film and can feel tack without excessive drag or sticking. The application window is approximately 2 hours for typical coating thicknesses. Exceeding the window of opportunity can lead to adhesion issues and should be avoided. Mohawk Sizing Liquid is an oil modified varnish formula that dries by oxidation, (exposure to oxygen). It should not be applied too heavily or irregular drying could result. Leafing too soon over wet sizing liquid or applying the sizing too early over wet sealer can result in shrinkage and wrinkling of the leaf.

Once dried to the proper tack, apply the leaf by gently guiding the sheets onto the surface in the desired pattern. Working the sheets from the books they're supplied in while using a soft natural bristle paint brush to help support the sheets you can control the application. Overlap the sheets slightly to ensure a tight gap between sheets. Continue to lay a few sheets and then use your brush to sweep the leaf down onto the sizing for a good bond. The brush should be soft enough not to scratch the delicate leaf material. You will break away the overlap which is left as you brush across the leaf causing it to break with little to no gap. Keep some sheets applied ahead of this step and use care not to brush the scrap out over your tacky sizing. Once your sizing starts to lose its tack you should stop and reapply the sizing liquid to regain the proper tack. Work sections at a time if possible to maintain the proper tack. Avoid any imperfections to the sizing such as finger prints from testing tack or brush marks etc. since they will telegraph through the leaf.

Once the leaf is applied you must allow the sizing liquid to fully cure before proceeding with the rest of the finish. The sizing liquid dries by oxidation and is now covered by leaf which will slow down the curing process. Rushing at this stage will cause adhesion failures, cracking and opening of seams. Allow a minimum of 12 hours before proceeding with your finish. Additional dry time is good insurance for a successful finish.

Once the sizing is cured you can proceed with a low solids coat of EZ Vinyl Sealer prepared by reducing with 1 part M650-010 2255 Lacquer Reducer to an equal part EZ Vinyl Sealer. Apply a light even coat of sealer as your first coat; do not flood this first seal coat or you risk opening the seams between the sheets of leaf. Allow the sealer to dry approximately 45 minutes and you can then continue with any additional finishing steps following your normal schedule for dry times etc.

I highly recommend testing with the Mohawk Sizing Liquid and Leafing materials on sample panels using the steps recommended to ensure the desired results. Test your sample panels for adhesion of the leaf both before and after the wash coat of vinyl sealer allowing for proper dry times before testing. Using a strip of strong masking tape, hold one end in your fingers and firmly rub a couple inches of the other end directly on the area to be tested and then snap the tape off the surface to see how well the leaf has bonded. Perfect bonding of leaf is an issue and you may see some degrees of failure that may be acceptable however, you should see decent bonding and you'll have to learn where the line falls between good enough and a failure. As you stick the leaf the sizing is drying and on larger surfaces you may lose your window of application; if you take too long to finish or wait too long to get started which could lead to failures on one end of a longer top. Learning when to start and how long you have to cover the sizing is critical to success.

Once you develop your process it's very important to remain consistent and to control the variables. Changes in temperature, humidity, air movement, location and timing can cause problems so develop a process that you very carefully repeat with each project; changes to your system should be tested before you initiate them.