

Product Finishes

CC-A31



**SHERWIN
WILLIAMS.**

KEM-FLASH[®] 500 Low HAPS Primer

Light Gray E61A712

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>KEM-FLASH[®] 500 Low HAPS Primer is a high quality, fast air drying, alkyd primer with very low HAPS content and VOC of less than 3.5 lbs/gal. It satisfies the performance specification requirements of the off road equipment and general metal markets.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Less than 3.5 lbs/gal VOC* as packaged • Low HAPS, less than 0.02 lbs/gal of solids • Excellent corrosion resistance • Fast drying. Can be topcoated after 30 minutes. • High solids, 54% volume solids means more build with less passes. • May be applied by airless or conventional spray without reduction or heat. • Ideal primer for farm and construction equipment, machinery, railroad cars, structural steel, and fabricated metal parts requiring excellent durability and rust protection. • Can be reduced with exempt solvents, such as acetone to improve application. • Compatible with a wide range of topcoats, including: <ul style="list-style-type: none"> Kem Fast Dry H.S. Kem Lustral[®] Enamel Opex[®] Production Lacquers Fast Production Enamel Quick Dry Enamel Quick Dry 350 High Solids Acrylic Enamel Kem Acryl[™] HS 100 Enamel <p>*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations</p>	<p>Gloss: Flat - 5-15 units</p> <p>Volume Solids: 54 ± 2% may vary by color</p> <p>Viscosity: 14-32 secs., #3 Zahn Cup 40-70 secs., #4 Ford Cup</p> <p>Recommended Film Thickness: Mils Wet 2.8 - 3.5 Mils Dry 1.5 - 1.8</p> <p>Spreading Rate (no application loss): 465-600 sq ft/gal @ 1.5 - 1.8 mils DFT</p> <p>Drying (1.5 mil DFT, 77°F, 50% RH): To Touch: 15-30 minutes Tack Free: 30-90 minutes To Recoat: 30 minutes Force Dry: 10-30 minutes at 140 to 180°F</p> <p>Flash Point: 50°F Pensky-Martens Closed Cup</p> <p>Package Life: 24 months, unopened</p> <p>Air Quality Data:</p> <ul style="list-style-type: none"> • Photochemically reactive • Volatile Organic Compounds (VOC) Theoretical as packaged, maximum, less exempt solvents: 3.26 lbs/gal, 391 g/L • Volatile Hazardous Air Pollutants (VHAPS) as packaged, less than 0.02 lbs/gal of solids <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com.</p>	<p>General: Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties. Consult Metal Preparation Brochure CC-T1 for additional details.</p> <p>Aluminum: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.</p> <p>Galvanized Steel: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.</p> <p>Steel or Iron: Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.</p> <p>Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.</p>

APPLICATION

Typical Setups

Reduction: For 3.5 lb/gal VOC, reduce up to 3.5% maximum with Butyl Acetate for lower viscosity and easier application. Heat up to 120°F may also be used for better application.

Conventional Spray:

Air Pressure..... 50 - 60 psi
Fluid Pressure 10 - 15 psi
Fluid Tip..... .055 - .070

Airless Spray:

Pressure2200 - 2600 psi
Tip013 - .015"

Air Assisted Airless:

Air Assist Pressure 20 - 30 psi
Fluid Pressure1800-2400 psi
Fluid Tip.....013 - .015"

Electrostatic Spray:

Voltage 60-85 KV
Fluid Tip..... .055 - .070
Air Pressure..... 50 - 60 psi

HVLP:

Air Pressure..... 10 psi maximum at cap
Fluid Pressure 8 - 10 psi
Fluid Tip..... .055 - .070

Clean Up:

Clean tools/equipment immediately after use with Butyl Acetate.

Follow manufacturer's safety recommendations when using any solvent.

Performance Tests

Substrate: Cleaned steel, primer applied at 1.5 mils DFT.

Salt Spray Test, ASTM B117.....500 hours, no face rust and 1/8" creepage maximum

Humidity, ASTM D2247
100°F (38°C), 100% RH..... 500 hours, passes, no blisters

45°S Florida Exposure.....1 year

ADDITIONAL INFORMATION

- For good corrosion resistance, a minimum of 1.5 mils dry film is required.
- Apply as a full wet coat, as dry spray gives poor enamel holdout and rough appearance.
- Do not topcoat with polyurethane enamels, catalyzed epoxies, high PVC flat wall paints, or latex coatings.
- On sand blasted surfaces, apply sufficient film thickness to protect the blast profile. This is typically 1 mil more than the blast profile. Multiple coats may be required.
- Because of its fast drying, this product is not recommended for brush application.
- Users should test for critical recoat and system adhesion when topcoating with products containing high strength solvents.
- Coating thickness will increase rapidly during application because of its higher solids. Heavy films will dry slower.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.paintdocs.com.

Please direct any questions or comments to your local Sherwin-Williams facility.

Note: All purchases of products from Sherwin-Williams are exclusively subject to Sherwin-Williams' terms and conditions of sale which can be found at www.sherwin.com. Please review these terms and conditions prior to the purchase of the products.

Sherwin-Williams warrants the product to be free of manufacturing defect in accordance with Sherwin-Williams' quality control procedures. Except for the preceding sentence, due to factors that are outside of Sherwin-Williams' control, including substrate selection, and customer handling, preparation, and application, Sherwin-Williams cannot make any other warranties related to the product or the performance of the product. **SHERWIN-WILLIAMS DISCLAIMS ALL WARRANTIES OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.**

Liability for products proven to be defectively manufactured will be limited solely to replacement of the defective product or the refund of the purchase price paid for the defective product, as determined by Sherwin-Williams. Under no circumstances shall Sherwin-Williams be liable for indirect, special, incidental or consequential damages, lost profits or punitive damages arising from any cause whatsoever.