Product Finishes



CC-A6

OPEX® Lacquer Primer Surfacer

Gray	P61A1
Black	P61B1
White	P61W1

DESCRIPTION

OPEX® Lacquer Primer Surfacers are nitrocellulose alkyd lacquer coatings designed for general industrial use on metal, wood, and some plastics to provide filling, corrosion protection, and fast build.

Advantages:

- · Fast air dry
- Excellent filling on rough metal surfaces, such as sand blasted steel and castings requiring surface preparation before application of a finish coat
- · Easily sanded
- · Interior and exterior use on steel
- Free of lead and chromate hazards
- · No critical recoat time
- May be used as a single coat where a flat finish is desired
- Topcoat with Opex lacquers or alkyd enamels

CHARACTERISTICS

Gloss: 0-10 units

Volume Solids (reduced 125% with K22 or K120 lacquer thinner):

15.7 ± 1%

P61B1 13.4 ± 1% P61W1 15.2 ± 1%

Viscosity:

P61A1

Full body, very high viscosity.

Reduce 125% with R7K22 or R7K120:

30-45 seconds #2 Zahn Cup 17-20 seconds #4 Ford Cup

Recommended film thickness:

Mils Wet 3.5 - 5.0 Mils Dry 0.5 - 0.8

interior applications: apply 2 coats exterior applications: apply 3 coats

Spreading Rate (no application loss) 249-536 sq ft/gal @ 0.5-0.8 mils DFT

Drying (77°F, 50% RH):

Tack Free: 5-10 minutes
To Handle: 10-20 minutes
To Recoat: no critical recoat time

To Sand: 1 hour To Pack: 1-2 hours

Force Dry: not required unless in-

creased production line

speed is desired

To Sand: 15-20 minutes @ 120-130°F

Note: Good air movement is important **Flash Point:** 21-22°F Pensky-

Martens Closed Cup

Package Life:

P61A1 3 years, unopened P61B1 3 years, unopened P61W1 18 months, unopened

Air Quality Data (Theoretical):

Non-photochemically reactive Volatile Organic Compounds (VOC)

as packaged, maximum

P61A1 4.37 lb/gal, 524 g/L P61B1 4.64 lb/gal, 556 g/L P61W1 4.44 lb/gal, 532 g/L

An Environmental Data Sheet is available from your local Sherwin-Williams facility.

SPECIFICATIONS

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.

Aluminum: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.

Galvanized Steel: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.

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.

Wood (interior only): Must be clean, dry, and finish sanded. Substrate should be free of grease, oil, dirt, fingerprints, and any contamination to ensure optimum adhesion and coating performance properties.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

APPLICATION

Typical Setups

Conventional Spray:

Air Pressure	45-60 psi
Fluid Pressure	8-12 psi
Reducer	R7K120 or R7K22

Warm Spray:

Reduce 125% with Lacquer Thinner, R7K120, or Lacquer Etching Thinner, R7K53. R7K53 improves adhesion over some ferrous substrates.

In high humidity conditions, add Opex Retarder thinner, R7K27, up to 10% or butyl cellosolve, R6K25, up to 3%.

Cleanup:

Clean tools/equipment immediately after use with Opex Lacquer Thinner, R7K120.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- This product is not recommended for use on exterior wood or wood products.
- For optimum drying and performance, avoid excessive humidity which may affect adhesion to the substrate or cause blushing.
- Do not apply directly to galvanized metal or nonferrous metals such as aluminum, brass, copper, etc. Use Industrial Wash Primer, P60G2, or Kem Aqua Wash Primer, E61G520.
- After sanding, the film may be very thin in some spots and must be recoated to achieve good corrosion resistance. Ensure at least 1.0 mil dry film after sanding, or apply another coat.

Performance Tests

Salt Spray Test, 5% ASTM B117......48-72 hours no blistering and less than 1/16" creepage at scribe.

No fracture on Conical Mandrel test, 1.0 mil DFT on 20 guage cold rolled steel after 72 hours air dry.

Print Resistance, after 1 hour withstands one psi with no print or film transfer

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION

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

A Material Safety Data Sheet is available from your local Sherwin-Williams facility.

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

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.