



# General Industrial Coatings

CC-A6

## OPEX® Lacquer Primer Surfer

Black.....P61B1 White.....P61W1  
Gray.....P61A1 Custom Blend Series.....P61XX

### DESCRIPTION

OPEX® Lacquer Primer Surfers 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
- 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

(may vary by color)

Unless otherwise noted, characteristics are for OPEX reduced 125% by volume with K22 or K120 lacquer thinners.

**60° Gloss:** 0-10

**Volume Solids:** 13-15 ± 1 %

#### Viscosity (at 77° F):

As Supplied Very High Viscosity  
Reduced 30-45 secs., #2 Zahn Cup  
17-20 secs., #4 Ford Cup

#### Recommended Film Thickness:

Mils Wet 3.5-6.0  
Mils Dry 0.5-0.8  
Interior Applications apply 2 coats  
Exterior Applications apply 3 coats

\*VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at [www.PaintDocs.Com](http://www.PaintDocs.Com).

**Spreading Rate** (no application loss):  
261-481 ft.<sup>2</sup>/gal. at 0.5-0.8 mils DFT

#### Cure:

Air Dry or  
Force Dry 15-20 mins. at 120-130° F  
Force drying is not required unless the desire is to increase production line speed.

**Substrate Disclaimer:** Curing of coating at temperatures higher than the heat distortion parameters of the substrate may cause substrate issues.

**Drying:** (0.5-0.8 mils at 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

Good air movement and humidity control are necessary for proper drying.

**Flash Point:** 21-22° F  
as supplied, Pensky Martens Closed Cup

#### Air Quality Data:

Non-Photochemically Reactive  
Volatile Organic Compounds (VOC), Less Exempts  
4.37-4.64 lbs/gal, 524-556 g/L  
as packaged, maximum, theoretical

**Recommended Storage:** Inside, sealed container, 40-120° F, no freeze hazard. Protect from moisture.

#### Package Life:

P61A1 & P61B1 36 months, unopened  
P61W1 18 months, unopened

### SPECIFICATIONS

**General:** All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

**Aluminum:** If untreated, prime with RoHS Compliant Wash Primer, P60G10, Industrial Wash Primer, P60G2 or Kem Aqua® Wash Primer, E61G522.

**Galvanized Steel:** If untreated, prime with RoHS Compliant Wash Primer, P60G10, Industrial Wash Primer, P60G2 or Kem Aqua® Wash Primer, E61G522.

**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:** 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.

## APPLICATION

### Typical Setups

**May be applied by:** Conventional Spray

#### **Conventional Spray:**

Air Pressure 45-60 psi  
Fluid Pressure 8-12 psi  
Tip 0.055-0.070 in.  
Reducer K22 or K120 Lacquer Thinners

#### **Warm Spray Conditions:**

Reducer K22 Lacquer Thinner  
Reduction Rate 100% (vol.)

Reduce 125% (vol.) with K120 (Lacquer Thinner) or R7K53 (Lacquer Etching Thinner). R7K53 improves adhesion over some ferrous substrates.

In high humidity conditions, add R7K27 (OPEX Retarder Thinner) up to 10% (vol.) or R6K25 (2-butoxy ethanol) up to 3% (vol.).

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

**Cleanup:** Clean tools/equipment immediately after use with K120 (Lacquer Thinner).

Follow manufacturer's safety recommendations when using any solvent.

## ADDITIONAL INFORMATION

1. This product is not recommended for use on exterior wood or wood products.
2. For optimum drying and performance, avoid excessive humidity which may affect adhesion to the substrate or cause blushing.
3. Do not apply directly to galvanized metal or nonferrous metals such as aluminum, brass, copper, etc. Use RoHS Compliant Wash Primer, P60G10, Industrial Wash Primer, P60G2 or Kem Aqua Wash Primer, E61G522.
4. After sanding, the film may be very thin in some spots and must be recoated to achieve good corrosion resistance. Ensure at least 0.5 mil dry film after sanding or apply another coat.
5. Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.
6. If parts have been stored for longer than one week after coating, they must be scuffed or sanded before top coating to ensure removal of any accumulated dust/dirt.
7. Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.
8. Compatible with Opticolor® and GIS colorants.

#### **Performance Tests\***

Salt Spray Test 48-72 hours  
(ASTM B117) no blisters  
<1/16" creep maximum  
Conical Mandrel, 1/8" No Fracture  
1.0 mil DFT on 20 gauge cold rolled steel  
After 72 hours air dry  
Print resistance, after 1 hour at 1 PSI  
No Print  
No Film Transfer

\*Performance test results may vary depending on dry film thickness, substrate tested and post-cure duration.

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## CAUTIONS

### **FOR INDUSTRIAL SHOP APPLICATION ONLY**

**Thoroughly review the 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](http://www.PaintDocs.Com).

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

#### **Note:**

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