



**SHERWIN  
WILLIAMS.**

# Chemical Coatings

CC-A6

## OPEX<sup>®</sup> Lacquer Primer Surfacer

Gray ..... P61A1  
 Black ..... P61B1  
 White ..... P61W1

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p><b>OPEX<sup>®</sup> Lacquer Primer Surfacer</b> are nitrocellulose alkyd lacquer coatings designed for general industrial use on metal, wood, and some plastics to provide filling, corrosion protection, and fast build.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• Fast air dry</li> <li>• Excellent filling on rough metal surfaces, such as sand blasted steel and castings requiring surface preparation before application of a finish coat</li> <li>• Easily sanded</li> <li>• Interior and exterior use on steel</li> <li>• Free of lead and chromate hazards</li> <li>• No critical recoat time</li> <li>• May be used as a single coat where a flat finish is desired</li> <li>• Topcoat with Opex lacquers or alkyd enamels</li> </ul>	<p><b>Gloss:</b> 0-10 units</p> <p><b>Volume Solids</b> (reduced 125% with K22 or K120 lacquer thinner):</p> <p>P61A1 15.7 ± 1%  P61B1 13.4 ± 1%  P61W1 15.2 ± 1%</p> <p><b>Viscosity:</b>  Full body, very high viscosity. Reduce 125% with R7K22 or R7K120:  30-45 seconds#2 Zahn Cup  17-20 seconds#4 Ford Cup</p> <p><b>Recommended film thickness:</b>  Mils Wet 3.5 - 5.0  Mils Dry 0.5 - 0.8</p> <p>interior applications: apply 2 coats  exterior applications: apply 3 coats</p> <p><b>Spreading Rate</b> (no application loss)  249-536 sq ft/gal @ 0.5-0.8 mils DFT</p> <p><b>Drying</b> (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 increased production line speed is desired</p> <p>To Sand: 15-20 minutes @ 120-130°F</p> <p><b>Note:</b> Good air movement is important</p> <p><b>Flash Point:</b> 21-22°F Pinsky-Martens Closed Cup</p> <p><b>Package Life:</b>  P61A1 3 years, unopened  P61B1 3 years, unopened  P61W1 18 months, unopened</p> <p><b>Air Quality Data:</b>  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</p> <p>An Environmental Quality Data Sheet is available from your local Sherwin-Williams facility.</p>	<p><b>General:</b> 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><b>Aluminum:</b> If untreated, prime with Industrial Wash Primer, P60G2, or Kem Aqua Wash Primer, E61G520.</p> <p><b>Galvanized Steel:</b> If untreated, prime with Industrial Wash Primer, P60G2, or Kem Aqua Wash Primer, E61G520.</p> <p><b>Steel or Iron:</b> 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><b>Wood</b> (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.</p> <p><b>Testing:</b> Due to the wide variety of substrates, surface preparation methods, and application methods and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.</p>

## APPLICATION

### **Conventional Spray:**

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

### **Warm Spray:**

Reducer ..... R7K22  
Reduce 100% with Lacquer Thinner  
R7K22.

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 af-  
ter use with Opex Lacquer Thinner,  
R7K120. Follow manufacturer's safety  
recommendations when using any sol-  
vent.

## 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

Thoroughly review product label 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.

### **LABEL CAUTIONS**

See contents statement on label.  
Contents are FLAMMABLE. Vapors may cause flash fires. Keep away from heat, sparks, and open flame. During use and until all vapors are gone: Keep area ventilated - Do not smoke - Extinguish all flames, pilot lights, and heaters - Turn off stoves, electric tools and appliances, and any other sources of ignition.

VAPOR HARMFUL. Use only with adequate ventilation. Wear an appropriate properly fitted vapor/particulate respirator (NIOSH approved) during and after application, unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage.

FIRST AID: If INHALED: If affected, remove from exposure. Restore breathing. Keep warm and quiet. If on SKIN: Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before re-use. If in EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention. If SWALLOWED: Call Poison Control Center, hospital emergency room, or physician immediately.

SPILL AND WASTE: Remove all sources of ignition. Ventilate and remove with inert absorbent. Incinerate in approved facility. Do not incinerate closed container. Dispose of in accordance with Federal, State, and Local regulation regarding pollution.

DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE.

Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN.

FOR INDUSTRIAL USE ONLY.

SEE MATERIAL SAFETY DATA SHEET.21336-051905.

**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.