



**SHERWIN  
WILLIAMS.**

# Chemical Coatings

CC-C1

## OPEX<sup>®</sup> Production Lacquers

Flamboyant Aluminum ..... L61S18  
 Red ..... L61R44  
 Blending Clear ..... T82C100

Semi-Gloss Soft White ..... L61W38  
 Gloss Black ..... L61B21  
 Yellow ..... L61Y36

Tinting White ..... L61W19  
 Gloss White ..... L61W34  
 Blending White ..... L61W100

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p><b>OPEX<sup>®</sup> Production Lacquer</b> is a nitro-cellulose alkyd lacquer for industrial product finishing</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• Fast air drying</li> <li>• Full gloss</li> <li>• Interior and exterior use on metal</li> <li>• Non-photochemically reactive</li> <li>• No critical recoat time</li> <li>• Non-bleeding pigments</li> <li>• USDA acceptable for use in areas of incidental food contact</li> <li>• All colors comply with heavy metals and lead restrictions</li> <li>• A full gloss range is available using Opex<sup>®</sup> Lacquer Flattening Agent (see data page CC-S2 for details)</li> <li>• May be tinted with 844 colorants up to 4 ounces</li> </ul>	<p><b>Gloss:</b> Full        Semi-gloss White: 40-45 units        Aluminum: 25-35 units</p> <p><b>Volume Solids:</b> 25 ± 2% at 100% reduction with R7K120 except T82C100, L61W100, and L61S18 varies by color</p> <p><b>Viscosity:</b>        20-25 seconds #2 Zahn Cup at 100% reduction with R7K120</p> <p><b>Recommended film thickness at 100% reduction with R7K120:</b>        Interior applications (achieved with multiple coats) :        Mils Wet: 6.0 - 8.0        Mils Dry: 0.8 - 1.0        Exterior applications (achieved with multiple coats) :        Mils Wet: 8.0 - 10.0 primed        11.0 - 16.0 unprimed        Mils Dry: 1.0 - 1.2 primed        1.4 - 2.0 unprimed</p> <p><b>Spreading Rate</b> (no application loss)        100-250 sq ft/gal @ 0.8-2.0 mils DFT</p> <p><b>Drying</b> (1.0 mils dft, 77°F, 45% RH):        Tack Free: 5-10 minutes        To Topcoat: no critical recoat time        To Pack: 2-4 hours        Force Dry: 10-15 minutes at 180°F</p> <p>Good air movement is more important than heat.</p> <p><b>Flash Point:</b> 21-35°F, Pensky-Martens Closed Cup</p> <p><b>Package Life:</b> 2 years, unopened</p> <p><b>Air Quality Data:</b>        Non-photochemically reactive        Volatile Organic Compounds (VOC) as packaged, maximum        6.19 lb/gal, 742 g/L        reduced 100% with R7K120, maximum        6.39 lb/gal, 767 g/L</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> Prime with Kem Aqua<sup>®</sup> Wash Primer, E61G520.</p> <p><b>Galvanized Steel:</b> Prime with Kem Aqua<sup>®</sup> 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. Opex<sup>®</sup> Lacquers are self priming on steel. For optimum exterior durability, prime with Opex<sup>®</sup> Lacquer Primer Surfer.</p> <p><b>Wood</b> (interior only): Must be clean, dry, and finish sanded. Prime with SherWood<sup>®</sup> Primer, P65W1 or P65W4.</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> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility.</p>

## APPLICATION

### Typical Setup

With high humidity, it may be necessary to use Lacquer Thinner, R7K27 to reduce or eliminate blushing.

#### **Conventional Spray:**

Reducer ..... R7K120  
Reduction Rate ..... 50-100%

#### **Warm Spray:**

Reducer ..... R7K22  
Reduction Rate ..... 50-75%

#### **Dip:**

Reducer ..... R7K22 or R7K27  
Reduction Rate ..... 50-75%  
Excessive agitation or turbulence on part immersion or withdrawal may cause foaming.

Tank maintenance (agitation, turnover rate, viscosity control, and stability) is required.

#### **Cleanup:**

Clean tools/equipment immediately after use with Lacquer Thinner R7K120. Follow manufacturer's safety recommendations when using any solvent.

## SPECIFICATIONS

#### **Product Limitations:**

- This nitrocellulose quality will show yellowing upon aging, especially in whites. Topcoating with clear wood finish lacquers may cause unacceptable yellowing over time.
- Yellow, L61Y36 has limited exterior durability.
- Saturated colors provide better color retention than very light tints on exterior exposure.
- After force drying, cool articles to prevent sticking.
- High humidity may cause blushing with lacquers, use Retarder Thinner to reduce blushing.
- Do not use on exterior wood products.
- Do not use over Industrial Wash Primer, P60G2 as poor adhesion may result. Use Kem Aqua® Wash Primer, E61G520 over untreated aluminum and galvanized metal.
- Does not meet KCMA performance specifications.
- To avoid yellowing on cabinets/furniture, Sher-Wood® Pigmented Conversion Varnish or Sher-Wood® White Vinyl Sealer, P63W2, and Sher-Wood® CAB-Acrylic Lacquer should be recommended.

#### **Performance Tests**

##### **Hardness:**

With one hour drying, this will withstand one psi with no marring or film transfer.

**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.

## 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. 26873-100606.

DANGER: Rags, steel wool, other waste soaked with this product, and sanding residue may spontaneously catch fire if improperly discarded. Immediately place rags, steel wool, other waste soaked with this product, and sanding residue in a sealed, water-filled, metal container. Dispose of in accordance with local fire regulations.