



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-B20

Fast Dry Acrylic Enamel

Gloss Black	F78B21	Machinery Red	F78R27
Silver	F78S32	Brite Red	F78R30
Gloss White	F78W28	Safety Yellow	F78Y29
Blending White	F78W100	Equipment Green	F78G25
Clear	F78T104	Catalyst (Optional)	V66V29

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>Fast Dry Acrylic Enamel is a high gloss, durable acrylic enamel. Its fast air drying properties make it ideal for coating various metal products.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Very fast air dry • Good gloss and color retention • Good one coat protection • High gloss • May be catalyzed with Polane Catalyst V66V29 for increased hardness and improved resistance properties • Application by conventional, airless, air assisted airless, and electrostatic spray • Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303. • Available in a broad range of colors <p>Fast Dry Acrylic Urethane: For increased chemical and abrasion resistance, improved hardness and color and gloss retention, Fast Dry Acrylic Enamel may be catalyzed at an 8:1 ratio with Polane Exterior Catalyst V66V29 prior to reduction. Drying times are slower than for uncatalyzed Fast Dry Acrylic. Working potlife after catalyzation is 6-8 hours at room temperature.</p>	<p>Gloss: 85+ units Volume Solids: 32-37% ± 2% varies by color Viscosity: 40-60 seconds#2 Zahn Cup 30-40 seconds#4 Ford Cup Recommended film thickness: Mils Wet 3.0 - 4.5 Mils Dry 1.0 - 1.5 Spreading Rate (no application loss) 342-593 sq ft/gal @ 1.0-1.5 mils DFT Drying (1.0 mils dft, 77°F, 50% RH): To Touch: 5-10 minutes To Handle: 10-15 minutes Tack Free: 30-45 minutes To Recoat: before 6 hours or after 36 hours Force Dry: 10-20 minutes at 140-180°F Critical recoat - do not recoat after 6 hours or before 36 hours air drying at room temperature. (Force drying, film thickness, and varying humidity conditions may change critical recoat time). Recoating should be tested on small areas under actual application conditions. Flash Point: 45°F Pinsky-Martens Closed Cup Package Life: 2 years, unopened Air Quality Data: Photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum 4.88 lb/gal, 585 g/L reduced 25% with Xylene: 5.31 lb/gal, 637 g/L An Environmental Data Sheet is available from your local Sherwin-Williams facility.</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 Industrial Wash Primer, P60G2, or Kem Aqua® Wash Primer, E61G520. Over "pre-treated" aluminum, check adhesion before use as the proprietary pre-treatment may change from supplier to supplier which may have an effect on the final adhesion.</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, prime with Kem Flash Low HAPS 500 Primer, E61 Series.</p> <p>Testing: 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.</p>

APPLICATION

Typical Setup

Conventional Spray:

Air Pressure50-60 psi
Fluid Pressure10-15 psi
Tip055-.070
Reducer Xylol R2K4
For warm temperatures and large surface areas, use a 1:1 blend of Xylol and Aromatic Naphtha-100 Flash (or mix ratios as needed)
Reduction Rate . as needed up to 25%
apply a full wet coat, allow a 10 minute flash off and apply another full wet coat

Airless Spray:

Pressure 2400-2800 psi
Tip011-.015"
Reducer Aromatic Naphtha-100 Flash
Reduction Rate . as needed up to 20%

Electrostatic Spray:

Air Pressure45-55 psi
Fluid Pressure10-15 psi
Tip055-.070"
Reducer for polarity MEK R6K10
Reduction Rate5%
Reducer for flow . Use a 1:1 blend of Xylol and Aromatic Naphtha 100.
Reduce as needed up to 25%

HVLP:

Air Pressure 10 psi max at cap
Fluid Pressure 8-10 psi
Tip055-.070"

Cleanup:

Clean tools/equipment immediately after use with Xylol R2K4. For HAPS compliant cleanup, use n-butyl acetate, R6K18.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- Critical recoat - do not recoat after 6 hours or before 36 hours air drying at room temperature. (Force drying, film thickness, and varying humidity conditions may change critical recoat time). Recoating should be tested on small areas under actual application conditions.
- Fast Drying Acrylic Enamels apply best at temperatures above 65°F
- For maximum gloss holdout use Kem 400 Primer. Primers such as Kem Flash Prime give poorer gloss holdout and may be lifted by the strong solvents in the acrylic enamel.
- When applied to properly cleaned, untreated cold rolled steel, optimum adhesion is obtained after 4-7 days air drying. Heavier films (greater than 1.5 mils) require longer drying to obtain best adhesion. Over iron phosphate pretreatment or recommended primers, topcoat adhesion develops much faster.
- Force dry schedules may affect color of whites because of the heat.
- For optimum gloss and enamel holdout:
 - A. Allow at least 2 hours drying of the primer.
 - B. Apply 1.5 - 1.8 mils dry film of topcoat. Lesser film thickness will give lower gloss.

Performance Tests:

Substrate:1.5 mils DFT on CRS Q-Panel

Salt Spray Test

ASTM B117 110-120 hours
no face rust and 1/8" creepage maximum

Humidity

ASTM D2247 (100°F and 100% relative humidity) Pass 250 hours

Pencil Hardness

ASTM 3363 3B

Impact Resistance

Direct 20 lbs
Reverse 5 lbs

Flexibility (Conical Mandrell) .. Pass 1/8 inch

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.