



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-A1

KEM-FLASH® Prime

Gray E61A45
 Buff E61H6
 Red Oxide E61R26
 White E61W12

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>KEM-FLASH® Prime metal primers are fast drying, versatile alkyd primers uniquely formulated to provide excellent corrosion resistance for a wide range of general metal applications.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Excellent corrosion resistance achieved by a scientifically balanced blend of corrosion inhibiting pigments • Fast dry to handle and recoat • Ideal primer for production line and maintenance use on steel and iron substrates • Excellent primer for use under a wide range of alkyd type topcoats • Non-photochemically reactive • Meets the performance requirements of Structural Steel Painting Council Spec 15-68T Type 1 • Compatible with a wide range of topcoats, including: <ul style="list-style-type: none"> Kem Lustral® Enamel Opex® Production Lacquers Fast Production Enamel Quick Dry Enamel Kem® 400 Enamel • Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303. 	<p>Gloss: Flat, 2-10 units</p> <p>Volume Solids: 36-38± 2% varies by color</p> <p>Viscosity: 35-40 seconds #3 Zahn Cup</p> <p>Recommended film thickness: Mils Wet 3.0 - 4.0 Mils Dry 1.0 - 1.25</p> <p>Spreading Rate (no application loss) 449-626 sq ft/gal @ 1.0 -1.25 mils DFT</p> <p>Drying (1.25 mils dft, 77°F, 50% RH): To Touch: 5 minutes To Handle: 10 minutes Tack Free: 15-20 minutes To Recoat: 20 minutes (spray) Force Dry: 10 minutes at 180°F, (not generally required)</p> <p>Flash Point: 50°F Pinsky Martens Closed Cup</p> <p>Package Life: 2 years, unopened</p> <p>Air Quality Data: Non-photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum 4.07 lb/gal, 488 g/L reduced 33% with Xylene, maximum 4.85 lb/gal, 582 g/L</p> <p>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.</p> <p>Galvanized Steel: If untreated, prime with Industrial Wash Primer, P60G2, or Kem Aqua® Wash Primer, E61G520.</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.</p> <p>Wood (interior only): Must be clean, dry, and finish sanded.</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 Setups

Reduction: Reduce with Xylol, R2K4. For lower HAPS application use n-butyl acetate (R6K18), MAK (R6K30), VM&P Naptha (R1K3) and/or Mineral Spirits (R1K4). When reducing with VM&P Naptha and/or Mineral Spirits be sure to add under agitation.

Conventional Spray:

Reducer Xylol, R2K4
Reduction Rate 25 - 33%
or to 25 seconds on a #2 Zahn Cup
for wetter spray use High Flash
Naphtha, R2K5

Airless Spray:

Tip013" - .017"
Reducer Xylol, R2K4
Reduction Rate as needed

Electrostatic Spray:

Reducer for polarity MEK, R6K10
Reduction Rate 5%
Reducer for flow Xylol, R2K4
Reduction Rate as needed

Dip: Small objects/short drain only

Reducer Xylol, R2K4
Reduction Rate 20%
or 35 seconds on a #2 Zahn Cup

Excessive agitation or turbulence on part immersion or withdrawal may cause foaming.

Cleanup:

Clean tools/equipment immediately after use with Xylol R2K4. For lower HAPS cleanup use n-butyl acetate, MAK or acetone.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- For good corrosion resistance, Kem Flash® Prime should be applied at 1.25 mils DFT or better.
- Apply as a full wet coat, since dry spray gives poor enamel holdout and film properties.
- Do not topcoat with polyurethane enamels, catalyzed epoxies, high PVC flat wall paints, or latex coatings.
- On sandblasted surfaces, apply sufficient film thickness to fully protect the blast profile. This is typically 3-5 mils wet in several applications.
- Because it is very fast drying, do not apply by brush.
- Users should test for intercoat and system adhesion when topcoating with products containing high strength solvents.
- Reduction with VM&P Naptha or Mineral Spirits may result in skinning if pail is left overnight without agitation.
- May be tinted with 844 colorants up to 4 ounces per gallon.

Performance Tests

Substrate: Cleaned steel panels
Primer: 1.25 mils dft

Salt Spray Test

ASTM B117 250 hours
1 year 45°S Florida exposure.....Passes
with no rusting or blistering

Adhesion (ASTM-3359) 5B

Humidity (ASTM-2247) 350 hours

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION

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.

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.