



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-B7

Fast Production Enamel

ASA 49 Gray F75AC1
 Gloss Black F75BC6
 Blue F75LC2
 Federal Yellow F75YC4
 Equipment Yellow G74YC165

Green F75GC2
 White F75WC1
 Safety Yellow F75YC3
 Omaha Orange F75EC2
 Catalyst (optional) V66V29

Blending White F75W100
 Flat Black F75BC7
 Red F75RC4
 Blending Clear F75V100

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>Fast Production Enamel is an alkyd enamel intended for finishing or refinishing industrial, construction and agricultural equipment.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Fast air dry • Full gloss range available • Good exterior durability, except for red, yellow, and orange • Free of lead and chromate hazards • Good one coat protection • Good flexibility and film toughness • Full range of custom colors • May be catalyzed for higher gloss, increased hardness and improved resistance properties • Working potlife after catalyzation is 6 to 8 hours at room temperature <p>Fast Production Enamel Urethane For increased chemical abrasion resistance, improved hardness, sharper gloss, and better color and gloss retention, Fast Production Enamel may be catalyzed at an 8:1 ratio with Polane Exterior Catalyst, V66V29, prior to reduction. Drying times will be slower.</p>	<p>Gloss: Full</p> <p>Volume Solids: 27-34% varies by color</p> <p>Viscosity: 22-34 seconds#3 Zahn Cup 40-60 seconds#4 Ford Cup</p> <p>Recommended film thickness: Mils Wet 3.5 - 5.0 Mils Dry 1.0 - 1.5</p> <p>Spreading Rate (no application loss) 289-545 sq ft/gal @ 1.0-1.5 mils DFT</p> <p>Drying (77°F, 45% RH): To Touch: 10 minutes To Handle: 30 minutes To Recoat: 30 minutes To Pack: 24 hours Force Dry: 20 minutes at 140°F</p> <p>Flash Point: 40-45°F Pensky-Martens Closed Cup</p> <p>Package Life: 3 years, unopened</p> <p>Air Quality Data: Non-photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum 4.8 lb/gal, 576 g/L reduced 25% with Xylene: 5.3 lb/gal, 636 g/L</p> <p>Reducing with Xylene, Toluene, Aromatic Naphtha, or other aromatic solvents makes this product photochemically reactive.</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. 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>Galvanized Iron: 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. For exterior exposure, prime with Kem-Flash® Prime.</p> <p>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.</p> <p>Testing: 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

Typical Setup

Conventional Spray:

Air Pressure 45-60 psi
Fluid Pressure 20-25 psi
Reducer Xylene R2K4
Reduction Rate 20-25%
Aromatic Naphtha R2K5 or Toluene
R2K1 can also be used

Airless Spray:

Tip013" - .017"
Reducer Xylene R2K4
Reduction Rate 10%
Aromatic Naphtha R2K5 can also be
used

Cleanup:

Clean tools/equipment immediately af-
ter use with Toluene or Xylene.
Follow manufacturer's safety recommen-
dations when using any solvent.

Performance Tests

Substrate - 1.5 mils DFT on CRS Q-Panel

Salt Spray (ASTMB117) 200 hours

Pencil Hardness 2B

Humidity - 120 hours passes

SPECIFICATIONS

Product Limitations:

- If strong solvents such as Xylene or Toluene are used, a critical recoat may occur between 2 and 18 hours.
- Blocking or sticking may occur when flat surfaces are stacked before ad-
equated cure. Allow at least 24 hours
before stacking.
- Fast Production Enamel reds, or-
anges, and yellows contain bleeding
pigments. Use caution when recoat-
ing with products containing aromatic
ester or ketone solvents.
- The reds, oranges, and yellows have
been formulated to give optimum du-
rability as packaged. Using these col-
ors for intermixing may result in color
walk out or premature fading on expo-
sure.

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 com-
ments to your local Sherwin-Williams
facility.

Catalyst CONTAINS ISOCYANATES. People who
have chronic (long-term) lung or breathing problems
or have had a reaction to isocyanates, must not be
in the area where this product is being applied. Where
overspray is present, a positive pressure air-sup-
plied respirator should be worn. If unavailable, a
properly fitted organic vapor/particulate respirator
may be effective. Consult catalyst MSDS and prod-
uct label for complete handling instructions.

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, rat-
ing, and opinions stated here pertain to the
material currently offered and represent the
results of tests believed to be reliable. How-
ever, 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 warran-
ties as to the end result.