



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-B26

KEM® 400 Enamel

Gloss Black	F75B401	Flat Black	F75B412
High Hide White	F75W404	Silver Metallic	F75S491
Blending Clear.....	F75V405	Metallic Mixing Clear	F75V412
Acrylic Modifier	V70V411	Kem 400 Catalyst	V66V1020

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>KEM® 400 Enamel is a general purpose, short oil alkyd, high gloss enamel. It is ideal for interior and exterior application for OEM finishing or refinishing of industrial, construction, and agricultural equipment as well as a wide array of general metal applications.</p> <p>Kem® 400 Acrylic Enamel For improved exterior color and gloss retention, faster drying, sharper gloss, and improved block resistance in stacking, a 10% addition of Acrylic Modifier, V70V411, may be added to Kem® 400 Enamel.</p> <p>Kem® 400 Urethane Enamel For increased chemical and abrasion resistance, improved hardness, sharper gloss, and better gloss and color retention, Kem® 400 Enamel may be catalyzed at an 8:1 ratio with Kem 400 Exterior Catalyst, V66V1020, prior to reduction. Drying times are slightly faster. Addition of catalyst eliminates the critical recoat time. Working potlife is 8 hours maximum, at room temperature. Catalyst contains isocyanates, read label cautions on V66V1020 before use.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • High Gloss • Good exterior color and gloss retention • Good one coat protection • Fast air drying • Good flexibility and film toughness • Available in a broad range of colors. • Ideal for large components because of longer open time and wet-in of overspray • Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303. • Ideal system for horse trailers, farm, garden, and construction equipment and industrial machinery and equipment 	<p>Gloss: 85+ units</p> <p>Volume Solids: 27-36 ± 2% may vary by color</p> <p>Viscosity: 50-60 seconds #2 Zahn Cup 40-50 seconds #4 Ford Cup Blending Clear (F75V405) 82-90 KU</p> <p>Recommended film thickness: Mils Wet 3.5 - 5.0 Mils Dry 1.0 - 1.5</p> <p>Spreading Rate (no application loss) 292-572 sq ft/gal @ 1.0-1.5 mil dtf:</p> <p>Drying (77°F, 50% RH): To Touch: 15-30 minutes To Handle: 30-60 minutes Tack Free: 2-3 hours To Recoat: before 3 hours and after 48 hours</p> <p>Force Dry: 20 minutes at 140-160°F</p> <p>A critical recoat time may occur between 3 and 48 hours at room temperature. This may fluctuate depending on temperature, film thickness, and drying conditions. Test a small area first.</p> <p>Flash Point: 55°F Pensky-Martens Closed Cup</p> <p>Package Life: 2 years, unopened V66V1020 23 months, unopened</p> <p>Air Quality Data: Photochemically Reactive Volatile Organic Compounds (VOC) as packaged, maximum 4.99 lb/gal, 598 g/L reduced 15% with Xylene: 5.25 lb/gal, 630 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. 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.</p> <p>For improved corrosion protection, priming is recommended. Prime with Kem® 400 Primer or Kem-Flash® Ultra-Bond™ Primer.</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

Reduction: Reduce with Xylol as needed up to 15%. For more flow and open time, use Aromatic Naphtha 100 Flash or Aromatic Naphtha 150 Flash. Use Toluol for faster flash off and in cooler temperature.

May be applied using:

Conventional Spray:
Airless Spray
Air Assisted Airless
HVLP
Dip

Conventional Spray

Air Pressure45-55 psi
Fluid Pressure 10-15psi
Tip055-.070"

Airless Spray:

Fluid Pressure 1800-2400 psi
Tip011-.013"

Air Assisted Airless:

Assist Air 10-20 psi
Fluid Pressure 1200-1800 psi
Tip011-.013"

HVLP:

Max Pressure at the Cap 10 psi
Fluid Pressure 8-10 psi
Tip055-.070"

Cleanup:

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

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- For improved corrosion resistance, priming is recommended.
- Blocking or sticking may occur when flat surfaces are stacked before adequate cure.
- Apply at temperatures above 60°F.
- Apply at least 1.25 mils dry film thickness on direct to metal applications for good film integrity.
- Custom colors are available by blending bases with Phoenix colorants.
- Gloss adjustments can be made using D64F100 or OK412.

Performance Tests

Substrate - 1.5 mils DFT on CRS Q-Panel. Air dry for 14 days.
Salt Spray (ASTM B117) 150-200 hours
Direct Impact Pass 10 pounds
Pencil Hardness (ASTM D3363) 4B

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.