



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-A26

KEM AQUA® Bonding Primer for Plastics

White E61W525

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>KEM AQUA® Bonding Primer for Plastics is a one component, low VOC, acrylic latex coating intended as a tie coating or adhesion promoting primer over structural foam plastics, such as polystyrene, polyphenylene oxide, polycarbonate, and gas counter pressure molded plastics. It can be topcoated with a wide range of coatings used in the business machine and electronic cabinetry market.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Excellent adhesion to a wide range of structural foam plastics including gas counter pressure molded plastics • Water reducible latex quality • Low VOC - less than 1.5 lb/gal • Volatile Organic Emissions are less than 1.0 lb/gal • Fast air dry or force dry cure • Low odor. Reduced fire hazards - possible lower insurance rates • Single component - no catalyzation • No critical recoat time • Application friendly - may be applied using a wide variety of application equipment • Free of lead and chromate hazards • Reduce and clean up with water • Topcoat with: <ul style="list-style-type: none"> Kem Aqua® 280 W/R Enamel Kem Aqua® 600T W/R Enamel Kem Aqua® Gloss Enamel Polane® 700T W/R Enamel Polane® Polyurethane Enamels • May be tinted to pastel colors using up to 4 oz/gal of UCDQ or Huls 896 colorants 	<p>Gloss: Flat</p> <p>Volume Solids: 40 ± 2%</p> <p>Viscosity: 20-25 seconds #3 Zahn Cup</p> <p>Recommended film thickness: Mils Wet 1.5 - 2.5 Mils Dry 0.6 - 1.0</p> <p>Spreading Rate (no application loss) @ 0.6-1 mil dft: 640-1066 sq ft/gal</p> <p>Drying (1.0 mils dft, 77°F, 50% RH): To Touch: 10-15 minutes To Handle: 20-25 minutes To Recoat: 30-40 minutes Force Dry: 30 minutes at 140°F</p> <p>Good air movement and humidity control are necessary for proper drying of water reducible coatings.</p> <p>Flash Point: none, Seta Flash Closed Cup</p> <p>Package Life: 1 year, unopened</p> <p>pH: 7.7 - 8.3</p> <p>Air Quality Data: Non-photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum, less water 1.5 lb/gal, 180 g/L Volatile Organic Emissions as packaged, maximum 1.0 lb/gal, 120 g/L</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility.</p>	<p>Plastic: Due to the diverse nature of plastic substrates, a coating or coating system must be tested for acceptable adhesion to the substrate prior to use in production. Reground and recycled plastics along with various fire retardants, flowing agents, mold release agents, and foaming/blowing agents will affect coating adhesion. Please consult your Sherwin-Williams Chemical Coatings Sales Representative for system recommendations.</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: Do not over reduce. Water reducible coatings spray easily at higher viscosity the solvent products.

Conventional Spray:

Reducer Water
Reduction Rate as needed up to 5%

Airless Spray:

Pressure 2000-2400 psi
Tip011 - .013"
Reducer Water
Reduction Rate as needed up to 5%

Air Assisted Airless:

Air Pressure 15-30 psi
Fluid Pressure 850-950 psi
Tip011 - .013"
Reducer Water
Reduction Rate .. as needed up to 10%

HVLP:

Atomization Pressure 6-9 psi
Fluid Pressure 9-12 psi
Reducer Water
Reduction Rate .. as needed up to 10%

Cleanup:

Clean tools/equipment immediately after use with water. If dried, clean with a blend of water and ammonia as soon as possible.

Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- Protect from freezing. Inside storage between 40-95°F only. Freezing will cause a dramatic increase in viscosity.
- High humidity will slow drying.
- Spray wet film for good film integrity.
- Customer must test on specific surface for performance because a wide variety of plastics exist in the marketplace.
- Do not exceed 1.5 mils dry film to avoid mudcracking and improper drying.
- Use low to moderate atomizing pressures to minimize bubbling and air entrapment.
- Do not shake or agitate violently because of tendencies to foaming and air entrapment.
- Keep container closed to prevent skinning of this fast drying coating.
- Not intended for use on metal surfaces
- Does not provide significant corrosion resistance to systems. Not recommended where salt spray resistance is required. Use Polane® W₂ Primer, E61AC514, on metal when improved salt spray and corrosion resistance is required.
- Where sanding and filling properties are needed, use Kem Aqua® Sprayfil, D61H565.
- Does not adhere to polypropylene, polyethylene, or thermoplastic polyolefins. Flame treatment or other approaches are needed for adhesion to these surfaces.
- Apply at temperatures above 50°F for optimal dry and performance properties.

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 CAUTION

SEE CONTENTS STATEMENT ON LABEL.

Use only with adequate ventilation. To avoid overexposure, open windows and doors or use other means to ensure fresh air entry during application and drying. If you experience eye watering, headaches, or dizziness, increase fresh air, or wear respiratory protection (NIOSH approved) or leave the area.

Adequate ventilation required when sanding or abrading the dried film. If adequate ventilation cannot be provided wear an approved particulate respirator (NIOSH approved). 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: In case of eye contact, flush thoroughly with large amounts of water. Get medical attention if irritation persists. 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.

Abrading or sanding of the dry film may release crystalline silica which has been shown to cause lung damage and cancer under long term exposure. **WARNING:** This product contains chemicals known to the State of California to cause cancer.

DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN.

FOR INDUSTRIAL USE ONLY.

SEE MATERIAL SAFETY DATA SHEET. 19519-100102.

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.