



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-A23

KEM AQUA® 65P Water Reducible SprayFil

Off White D61H565
Black D61B505

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>KEM AQUA® 65P Water Reducible SprayFil is a one component, VOC compliant* acrylic latex filler developed to fill and hide profile and surface imperfections on structural foam plastics and metal for the business machine and electronic cabinetry market. It may also be applied to wood for interior applications.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Water reducible latex quality • Low VOC, less than 1.2 lb/gal* • Volatile Organic Emissions under 0.9 lb/gal • No reportable HAPS as packaged • Excellent adhesion to a wide range of structural foam and injection molded plastics • Easy filling and sanding • Eliminates wicking of plastics • Fast air dry • Low odor • Reduced fire hazards, possible lower insurance rates • Single component, no catalyzation • No critical recoat time • Free of lead and chromate hazards • Reduce and clean up with water • Compatible with a wide range of topcoats, including: Kem Aqua 600T W/R Enamel Polane® 700T W/R Enamel Polane T Polane T Plus Polane 2.8T Plus Polane HS Plus • May be tinted to pastel colors using up to 6 oz/gal of Kem Aqua colorants <p>*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.</p>	<p>Gloss: Flat</p> <p>Volume Solids: 50 ± 2%</p> <p>Viscosity: 65-85 Krebs Units</p> <p>Recommended film thickness: Mils Wet 4.0 - 5.0 Mils Dry 2.0 - 2.5</p> <p>Spreading Rate (no application loss) 308-417 sq ft/gal @ 2.0-2.5 mils DFT</p> <p>Drying (2.0 mils dft, 77°F, 50% RH): To Touch: 10-15 minutes To Handle: 20-25 minutes To Sand: 30-40 minutes To Recoat: 30-40 minutes Force Dry: 30 minutes at 140°F</p> <p>Flash Point: none, Pensky-Martens 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 1.2 lb/gal, 144 g/L</p> <p>Volatile Organic Emissions as packaged, maximum 0.9 lb/gal, 107 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>Steel or Iron: Remove rust, mill scale, and oxidation products. Treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection. Should not be applied to bare steel.</p> <p>Aluminum: Prime with Kem Aqua Wash Primer, E61G520.</p> <p>Galvanized Steel: Prime with Kem Aqua Wash Primer, E61G520.</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>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 Setup

Do not over reduce. Water reducible primers must be applied at higher viscosities than solvent based primers. They apply and atomize easier at higher viscosities.

Equipment Settings:

Conventional Spray (Binks 95):

Fluid Tip 65 SS, 66 SS
Air Cap 64PB
Atomizing Pressure 50-60 psi
Fluid Pressure 8-10 psi
Viscosity Reduction 2-5%

Airless Spray (Graco 10:1 Monarch):

Fluid Tip 411-413
Fluid Pressure 2000-2400 psi
Viscosity Reduction 2-5%

Air Assisted Airless (Graco 30:1 President):

Fluid Tip 411-413
Air Cap 222-608
Atomizing Pressure 15-30 psi
Fluid Pressure 875-950 psi
Viscosity Reduction 2-5%

HVLP (Binks Mach1):

Fluid Tip 94 (.055)
Air Cap 97P
Atomizing Pressure 65 psi
Nozzel Atomizing Pressure 10 psi
Fluid Pressure 6-8 psi
Fluid Delivery 110 cc/minute
Viscosity Reduction 7-10%

Cleanup:

Clean equipment and lines immediately with water. If dried, clean with a blend of water and ammonia as soon as possible. Clean spray gun cap with MEK.

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°F and 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 plastic and wood compositions exist in the marketplace.
- Do not exceed 4.0 mils total 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.
- Do not use viscosity cups to measure viscosity, product should be applied at as heavy a viscosity as practical.
- Not intended for use on machine tool castings.
- Gloss topcoats will show decreased gloss when applied over this product, sand for best gloss holdout.
- Does not provide significant corrosion resistance to systems, not recommended where salt spray resistance is needed, use Polane W₂ Primer on metal when improved salt spray and corrosion resistance is required.
- On MDF, the surface profile of the substrate may telegraph through this product to the topcoat.
- Interior use only. Do not expose systems involving Kem Aqua 65P to exterior environments.

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 CAUTIONS

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. 19519-100402.

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.