



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-A4

OPEX® Shopcoat Primer

Red P62R1

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>OPEX® Shopcoat Primer is a fast drying lacquer for priming metal and wood substrates. It works well as a crankcase sealer to inhibit rusting and penetration of oil, cutting oil, and grease. It is also used as a shopcoat primer for castings, steel surfaces, over foundry patterns for identification.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Fast air drying • Interior and exterior use • Resistant to oil, cutting oil, and grease for use as a crankcase sealer • Excellent shopcoat primer for castings before machining • No critical recoat time • Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II, Subchapter B, part 1303. • Non-photochemically reactive • Use as a sealer for good holdout and gloss of pigmented lacquer topcoats 	<p>Gloss: 65+ units Volume Solids: 15% ± 2% Viscosity: Packaged: 35 - 50 seconds #5 Zahn Cup Reduced 50% with R7K120: 40 - 65 seconds #2 Zahn Cup Recommended film thickness: Mills dry: interior 0.5 - 0.8 exterior 1.0 - 1.5 Spreading Rate (no application loss) 301-482 sq ft/gal @ .50 -0.80 mil dft 161-241 sq ft/gal @ 1.0-1.5 mil dft Drying (1.0 mils dft, 77 °F, 45% RH): Tack Free: 5-10 minutes To Machine 1-5 hours To Recoat: no critical recoat time Force Dry: not normally needed Good air movement is more important than heat. Flash Point: 23°F Pinsky-Martens Closed Cup Package Life: 3 years, unopened</p> <p>Air Quality Data: Non-photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum 5.82 lb/gal, 698 g/L reduced 75% with R7K120: 6.44 lb/gal, 772 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 (untreated): Prime with Industrial Wash Primer, P60G2.</p> <p>Galvanized Steel (untreated): Prime with Industrial Wash Primer, P60G2.</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. 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, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.</p>

APPLICATION

Typical Setups

Spray:

Reduction: For HAPS compliant lacquer thinners use R7K320, R7K322. R7K120 or R7K53 (Opex Etching Thinner) can also be used, but are not HAPS compliant.

Reduction Rate 75-100%

Dip: (small parts only)

Reduction: For HAPS compliant lacquer thinners use R7K320, R7K322. R7K120 or R7K53 (Opex Etching Thinner) can also be used as needed 60-75%, but are not HAPS compliant.

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

Cleanup:

For HAPS compliant cleanup, clean tools/equipment immediately using R7K320, R7K322. R7K120 and R7K119 can also be used, but are not HAPS compliant. Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- Not recommended over wood or wood products for exterior use.
- For best adhesion to metal, reduce with Opex Etching Thinner, R7K53.
- Do not apply directly to galvanized metal or nonferrous metals such as aluminum, brass, copper, etc. Use Industrial Wash Primer, P60G2.
- Dip application is recommended for small parts only because of fast drying.
- If forced dried, parts should be cooled to room temperature to prevent sticking.
- For high humidity, addition of Opex Lacquer Retarder, R7K27, may be required to avoid blushing.

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.

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.