



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-B28

KEM[®] Fast Dry High Solids Enamel

Gloss Black F85B30
 Gloss Clear F85V31
 Gloss White F85W32
 Low Gloss Clear F85V41
 Low Gloss White F85W42

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>KEM[®] Fast Dry High Solids Enamel is a high quality high solids low VOC air drying alkyd enamel. It meets the general requirements of the construction machinery and farm equipment markets plus a wide range of general metal market applications.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • VOC of 3.37 lb/gal • Full gloss products have excellent color and exterior gloss retention. • Excellent one coat protection and performance • Low application viscosity at high volume solids • Can be reduced with exempt solvents such as Acetone for better application at 3.37 lb/gal VOC • Can be applied using existent application equipment - conventional, HVLP, airless, air assisted airless and electrostatic spray methods • Good flexibility and film toughness • High production output by reducing multiple pass operations • Available in a broad range of colors. • Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303. 	<p>Gloss:</p> <p>Gloss Full (85+ units) Low Gloss 5-15 units</p> <p>Volume Solids: 52 ± 2%</p> <p>Viscosity: 40-90 seconds #4 Ford (varies by color)</p> <p>Recommended film thickness:</p> <p>Mils Wet 2.0 - 2.5 Mils Dry 1.0 - 1.3</p> <p>Spreading Rate (no application loss) 616-866 sq ft/gal @ 1.0-1.3 mil DFT</p> <p>Drying (1.0-1.3 mils dft, 77°F, 50% RH):</p> <p>To Touch: 15-60 minutes To Handle: 60-120 minutes Tack Free: 2-3 hours To Recoat: before 6 hrs or after 48 hrs</p> <p>Critical recoat period will fluctuate depending on drying conditions, film thickness, etc. Test a small area first.</p> <p>To Tape: > 24 hours</p> <p>Force Dry (120 -180°F)</p> <p>To Handle: 20-60 minutes To Tape: 20-60 minutes</p> <p>Force dry is not recommended for low and intermediate gloss colors. See Product Limitations.</p> <p>Flash Point: 10°F Pensky- Martens Closed Cup</p> <p>Package Life: 1 year, unopened</p> <p>Air Quality Data: Photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum 3.37 lb/gal, 404 g/L reduced 3.5% by volume with MAK: 3.5 lb/gal, 420 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>Galvanized Steel: Prime with Industrial Wash Primer, P60G2, or Kem Aqua Wash Primer, E61G520.</p> <p>Steel or Iron: Surface must be properly cleaned and free of rust, grease, dirt, fingerprints and other contaminants. Treatment may consist of a proprietary surface chemical treatment, such as zinc or iron phosphate and/or the application of Kem Flash[®] 500 Primer or Kem Flash Ultra-Bond[™] Primer at 1.5 mil DFT. For best results on exterior exposure applications, a primer is recommended. See also Metal Preparation Brochure CC-T1.</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: Kem® Fast Dry HS Enamel may be applied without reduction at 3.37 lb/gal VOC. For applications allowing 3.5 VOC, reduce 3.5 % with MAK, R6K30, for lower viscosity and easier application. For further ease of application and smoothest appearance, this product can be reduced further with exempt solvents such as acetone to maintain 3.37 or 3.5 lb/gal VOC.

For lower viscosity and easier application, coatings may be heated up to 120°F using heated trace lines.

Conventional Spray:

Air Pressure 50-60 psi
Reducer MAK R6K30
Reduction Rate . as needed up to 3.5%

Airless Spray:

Fluid Pressure 2000-2500 psi
Tip011-.015"

Air Assisted Airless:

Air Assist Pressure 10-30 psi
Fluid Pressure 800-2000 psi
Tip011-.015"

Electrostatic Spray:

Reducer for polarity MAK R6K30 as needed

HVLP:

Reducer MAK R6K30
Reduction Rate . as needed up to 3.5%

Cleanup:

Clean tools/equipment immediately after use with MEK, R6K10 or MAK, R6K30. For HAPS free cleanup use n-butyl acetate, R6K18.

Follow manufacturer's safety recommendations when using any solvent.

Performance Tests

Substrate: 1.5 mils dft on CRS Q-Panel, cured 7 days at room temperature, 50% RH Salt Spray Test
ASTM B117-90 .. 120-240 hours (varies by gloss), ¼" creepage, no blister, no face rust Humidity
ASTM D2247 Pass 300 hours
No rust, no blisters
Pencil Hardness 2B
Direct Impact 50 in/lbs
Conical Mandrell Pass 1/8 inch
Adhesion 4B minimum

SPECIFICATIONS

Product Limitations:

- A critical recoat period may occur between 6 and 48 hours and will fluctuate, depending on drying conditions and film thickness. Test a small area first.
- Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying. Use of a primer will also slow drying.
- Not recommended for dip application.
- For improved corrosion resistance, use of a primer is recommended.
- Blocking or sticking will occur when flat surfaces are stacked before adequate cure.
- For very large machines requiring extended time to spray, adding 1-2% Butyl Carbitol will give a longer open time for overspray. Tack free time is longer.
- Parts should be air dried overnight before outdoor exposure. Force drying is acceptable for full gloss colors, however, force drying a low or intermediate color may result in a higher than expected gloss.
- Apply at temperatures above 60°F.
- Apply at least 1.25 mils dry film on DTM applications for good film integrity.
- The curing rate of this product is similar to traditional high solids air dry enamels. Caution should be taken for situations requiring fast handling and/or packing.
- Kem® Fast Dry HS Enamel low gloss products may not meet the exterior gloss retention requirements of the implement market specification for customers like Komatsu, Caterpillar and John Deere.
- The exterior gloss retention is proportional to the quantity of low gloss product used. The higher the quantity, the lower the gloss retention.
- Custom color and gloss available by blending bases with Phoenix Colorants. Gloss ranges from 10-90 units.

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.