



**SHERWIN  
WILLIAMS.**

# Chemical Coatings

CC-A30

## KEM-FLASH® 500 Primer

Gray ..... E61A750  
 Red Oxide ..... E61R751  
 Black ..... E61B752  
 White ..... E61W753

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p><b>KEM-FLASH® 500 Primers</b> are high quality, fast air drying, VOC compliant alkyd primers. They satisfy the performance specification requirements of the off road equipment and general metal markets.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• Meets the EPA solvent emission regulation of a maximum 3.5 lb/gal volatile organic compounds (VOC)</li> <li>• Excellent corrosion resistance</li> <li>• Fast drying. Can be topcoated after 30 minutes</li> <li>• High solids, 50% volume solids means more build with less passes.</li> <li>• May be applied by airless or conventional spray without reduction or heat</li> <li>• Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303</li> <li>• Ideal primer for farm and construction equipment, machinery, railroad cars, structural steel, and fabricated metal parts requiring excellent durability and rust protection</li> <li>• Can be reduced with exempt solvents, such as acetone to improve application</li> <li>• Compatible with a wide range of topcoats, including:           <ul style="list-style-type: none"> <li>Kem Lustral® Enamel</li> <li>Opex® Production Lacquers</li> <li>Fast Production Enamel</li> <li>Quick Dry Enamel</li> <li>Quick Dry 350</li> <li>High Solids Acrylic Enamel</li> <li>Kem® Fast Dry High Solids Enamel</li> <li>Kem Acryl™ HS 100 Enamel</li> </ul> </li> </ul>	<p><b>Gloss:</b> Flat, 2-10 units</p> <p><b>Volume Solids:</b> 52 ± 2% varies by color</p> <p><b>Viscosity:</b> 14-32 seconds #3 Zahn Cup 40-70 seconds #4 Ford Cup</p> <p><b>Recommended film thickness:</b> Mils Wet 3.0 - 3.5 Mils Dry 1.5 - 1.8</p> <p><b>Spreading Rate</b> (no application loss) 446-577 sq ft/gal @ 1.5-1.8 mils DFT</p> <p><b>Drying</b> (1.5 mils dft, 77°F, 50% RH): To Touch: 15-30 minutes Tack Free: 30-60 minutes To Recoat: 30 minutes Force Dry: 10-30 minutes at up to 180°F</p> <p><b>Flash Point:</b> 65°F Pensky-Martens Closed Cup</p> <p><b>Package Life:</b> 2 years, unopened</p> <p><b>Air Quality Data:</b> Photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum 3.30 lb/gal, 396 g/L</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility.</p>	<p><b>General:</b> 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><b>Aluminum:</b> If untreated, prime with Industrial Wash Primer, P60G2, or Kem Aqua Wash Primer, E61G520.</p> <p><b>Galvanized Steel:</b> If untreated, prime with Industrial Wash Primer, P60G2, or Kem Aqua Wash Primer, E61G520.</p> <p><b>Steel or Iron:</b> 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><b>Testing:</b> 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

**Reduction:** For 3.5 lb/gal VOC, reduce up to 3.5% maximum with Butyl Acetate, MAK, or MIBK for lower viscosity and easier application properties.

This product can be reduced further with exempt solvents such as acetone to improve application and still maintain 3.37 or 3.5 lbs/gal VOC. Do not exceed 10% by volume with exempt solvent.

Fluid temperature of up to 120°F may also be used for better application.

### **Conventional Spray:**

Air Pressure .....40-60 psi  
Fluid Pressure .....10-15 psi  
Fluid Tip ..... .055-0.70"

### **Airless Spray:**

Pressure ..... 2200-2600 psi  
Tip ..... .013-.015"

### **Air Assisted Airless:**

Air Pressure .....10-30 psi  
Fluid Pressure ..... 1800-2400 psi  
Fluid Tip ..... .013 - .015"

### **Electrostatic Spray:**

Reducer for polarity ..... MAK  
Voltage ..... 60-85 KV

### **HVLP:**

Air Pressure @ Cap ..... 8-9psi  
Fluid Pressure .....10-15 psi

### **Cleanup:**

Clean tools/equipment immediately after use with MAK, R6K30 or Butyl Acetate, R6K18.

Follow manufacturer's safety recommendations when using any solvent.

## SPECIFICATIONS

### **Product Limitations:**

- For good corrosion resistance, a minimum of 1.5 mils dry film is required.
- Apply as a full wet coat, as dry spray gives poor enamel holdout and rough appearance.
- Do not topcoat with polyurethane enamels, catalyzed epoxies, high PVC flat wall paints, or latex coatings.
- On sand blasted surfaces, apply sufficient film thickness to protect the blast profile. This is typically 1 mil more than the blast profile. Multiple coats may be required.
- Because of its fast drying, this product is not recommended for brush application.
- Users should test for critical recoat and system adhesion when topcoating with products containing high strength solvents.
- Coating thickness will increase rapidly during application because of its higher solids. Heavy films will dry slower.

### **Performance Tests**

Substrate: Cleaned steel, primer applied at 1.5 mils dft

Salt Spray Test ..... 500 hours

45°S Florida Exposure withstands 1 year

Adhesion ..... 5B

1/8" Conical Mandrel ..... passes

Impact Resistance - direct ..... 40 lbs.

Impact Resistance - reverse ..... 8 lbs.

## 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.

**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.