



## Product Finishes

CC-A31

**SHERWIN  
WILLIAMS.**

# KEM-FLASH® 500 Low HAPS Primer

Light Gray ..... E61A712

DESCRIPTION	CHARACTERISTICS	SPECIFICATIONS
<p><b>KEM-FLASH® 500 Low HAPS Primer</b> is a high quality, fast air drying, alkyd primer with very low HAPS content and VOC of less than 3.5 lbs/gal. It satisfies 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>• Less than 3.5 lbs/gal VOC* as packaged</li><li>• Low HAPS, less than 0.02 lbs/gal of solids</li><li>• Excellent corrosion resistance</li><li>• Fast drying. Can be topcoated after 30 minutes.</li><li>• High solids, 54% volume solids means more build with less passes.</li><li>• May be applied by airless or conventional spray without reduction or heat.</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 Fast Dry H.S.</li><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 Acryl™ HS 100 Enamel</li></ul></li></ul> <p>*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations</p>	<p><b>Gloss:</b> Flat - 5-15 units</p> <p><b>Volume Solids:</b> 54 ± 2% may vary by color</p> <p><b>Viscosity:</b> 14-32 secs., #3 Zahn Cup 40-70 secs., #4 Ford Cup</p> <p><b>Recommended Film Thickness:</b> Mils Wet 2.8 - 3.5 Mils Dry 1.5 - 1.8</p> <p><b>Spreading Rate</b> (no application loss): 465-600 sq ft/gal @ 1.5 - 1.8 mils DFT</p> <p><b>Drying</b> (1.5 mil DFT, 77°F, 50% RH): To Touch: 15-30 minutes Tack Free: 30-90 minutes To Recoat: 30 minutes Force Dry: 10-30 minutes at 140 to 180°F</p> <p><b>Flash Point:</b> 50°F Pensky-Martens Closed Cup</p> <p><b>Package Life:</b> 24 months, unopened</p> <p><b>Air Quality Data:</b></p> <ul style="list-style-type: none"><li>• Photochemically reactive</li><li>• Volatile Organic Compounds (VOC) Theoretical as packaged, maximum, less exempt solvents: 3.26 lbs/gal, 391 g/L</li><li>• Volatile Hazardous Air Pollutants (VHAPS) as packaged, less than 0.02 lbs/gal of solids</li></ul> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility or at <a href="http://www.paintdocs.com">www.paintdocs.com</a>.</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 RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.</p> <p><b>Galvanized Steel:</b> If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.</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> The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.</p>

## **APPLICATION**

### **Typical Setups**

**Reduction:** For 3.5 lb/gal VOC, reduce up to 3.5% maximum with Butyl Acetate for lower viscosity and easier application. Heat up to 120°F may also be used for better application.

### **Conventional Spray:**

Air Pressure..... 50 - 60 psi  
Fluid Pressure ..... 10 - 15 psi  
Fluid Tip..... .055 - .070

### **Airless Spray:**

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

### **Air Assisted Airless:**

Air Assist Pressure ..... 20 - 30 psi  
Fluid Pressure .....1800-2400 psi  
Fluid Tip.....013 - .015"

### **Electrostatic Spray:**

Voltage ..... 60-85 KV  
Fluid Tip..... .055 - .070  
Air Pressure..... 50 - 60 psi

### **HVLP:**

Air Pressure..... 10 psi maximum at cap  
Fluid Pressure ..... 8 - 10 psi  
Fluid Tip..... .055 - .070

### **Clean Up:**

Clean tools/equipment immediately after use with Butyl Acetate.

Follow manufacturer's safety recommendations when using any solvent.

### **Performance Tests**

Substrate: Cleaned steel, primer applied at 1.5 mils DFT.

Salt Spray Test, ASTM B117.....500 hours, no face rust and 1/8" creepage maximum

Humidity, ASTM D2247  
100°F (38°C), 100% RH..... 500 hours, passes, no blisters

45°S Florida Exposure.....1 year

## **ADDITIONAL INFORMATION**

- 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.

## **CAUTIONS**

### **FOR INDUSTRIAL SHOP APPLICATION ONLY**

**Thoroughly review product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.**

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or [www.paintdocs.com](http://www.paintdocs.com).

Please direct any questions or comments to your local Sherwin-Williams facility.

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