General Industrial Coatings

CC-A20

Kem® 400 Primer

Gray..... E61A400 Red Oxide ..... E61R402 Custom Blend Series E61KX

DESCRIPTION

KEM® 400 Primer is a fast drying primer offering corrosion protection under air dry alkyd enamels.

Advantages:

- Excellent enamel holdout for sharp gloss of the topcoat
- Fast air drying time
- Fast drying to recoat
- Spray apply using conventional, airless, air assisted airless, or HVLP spray

* VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.PaintDocs.Com.

CHARACTERISTICS

60° Gloss: 60-80
May be adjusted

Volume Solids: 25 ± 2 %
Varies by color

Viscosity: 18-35 secs., #3 Zahn Cup
(at 77° F) 45-85 secs., #4 Ford Cup

Recommended Film Thickness:
Mils Wet 4.5-5.5
Mils Dry 1.0-1.25

Spreading Rate (no application loss)**:**
295-435 ft.^{2}/gal. at 1.0-1.25 mils DFT

Cure:
Air Dry or
Force Dry 20 mins. at 140-160° F

Note: A critical recoat time may exist between 3 hours and 48 hours drying at room temperature. It may fluctuate depending on temperature, drying conditions, and film thickness. Test on a small area first.

Flash Point: 53° F
(Pensky Martens Closed Cup)

Air Quality Data:
Photochemically Reactive
Volatile Organic Compounds (*VOC), Less Exempts
As packaged 5.13 lb/gal, 615 g/L

Recommended Storage: Inside, sealed container, 40-120° F, no freeze hazard. Protect from moisture.

Package Life: 2 years, unopened

SPECIFICATIONS

General: All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

Aluminum: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.

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 and adhesion.

Testing: 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.

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APPLICATION

Typical Setups

May be applied by: Conventional Spray
Airless Spray
Air Assisted Airless Spray
Electrostatic Spray
HVLP Spray

Conventional Spray:

Air Pressure	45-55 PSI
Fluid Pressure	10-15 PSI
Tip	0.055-0.070 in.
Reducer	R2K4 (Xylene)
Reduction Rate	10-15% (vol.) or to 25 seconds, #2 Zahn Cup

Airless Spray:

Fluid Pressure	1,800-2,400 PSI
Tip	0.011-0.017 in.
Reducer	R2K4 (Xylene)
Reduction Rate	As needed

Air Assisted Airless Spray:

Assist Air Pressure	10-20 PSI
Fluid Pressure	900-1,800 PSI
Tip	0.011-0.017 in.
Reducer	R2K4 (Xylene)
Reduction Rate	As needed

Electrostatic Spray:

Reducer For Polarity	R6K10, (MEK)
Reduction Rate	5% (vol.)
Reducer For Flow	R2K4 (Xylene)
Reduction Rate	As needed

HVLP Spray:

Max Pressure At Cap	10 PSI
Fluid Pressure	8-10 PSI
Tip	0.055-0.070 in.
Reducer	R2K4 (Xylene)

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

Cleanup: Clean tools/equipment immediately after use with R2K4 (Xylene) or Toluene. For low HAPS clean up use n-butyl acetate or MAK.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. A minimum of 1.0 mils dry film thickness is required. Films of 1.25-1.50 mils offer optimum corrosion protection.
2. This primer may exhibit lifting or have a critical recoat when topcoated with alkyds containing strong solvents (Aromatics and Ketones). Users should test for critical recoat or lifting in a small area before proceeding.
3. A critical recoat time may exist between 3 hours and 48 hours drying at room temperature. It may fluctuate depending on temperature, drying conditions, and film thickness. Test on a small area first.
4. Compatible with GIS, Opticolor Express® and Phoenix® colorants.

Performance Tests

Substrate:	Cleaned steel panels
Kem 400 Primer:	1.25 mils DFT
Salt Spray Test (ASTM B117)	100 hours no blisters

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review the 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.

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

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