



General Industrial Coatings

CC-A1

KEM-FLASH® Prime

Gray.....E61A45 Buff.....E61H6 Red Oxide.....E61R26
 White.....E61W12 Custom Blend Series.....E61XX

DESCRIPTION

KEM-FLASH® Prime metal primers are fast drying, versatile alkyd primers uniquely formulated to provide excellent corrosion resistance for a wide range of general metal applications.

Advantages:

- Excellent corrosion resistance achieved by a scientifically balanced blend of corrosion inhibiting pigments
- Fast dry to handle and recoat
- Ideal primer for production line use on steel and iron substrates
- Excellent primer for use under a wide range of alkyd type topcoats
- Non-photochemically reactive
- Meets the performance requirements of Structural Steel Painting Council Paint 15 specification
- Compatible with a wide range of topcoats, including:
 - Kem Lustral® Enamel
 - Opex® Production Lacquers
 - Fast Production Enamel
 - Quick Dry Enamel
 - Kem® 400 Enamel

CHARACTERISTICS

60° Gloss: Flat, 2-10 units

Volume Solids: 36-38 ± 2 %
Varies by color

Viscosity (Zahn cup series):
35-40 secs., #3 Zahn Cup

Recommended Film Thickness:
Mils Wet 3.0-4.0
Mils Dry 1.0-1.25

Spreading Rate (no application loss):
440-640 ft.²/gal. at 1.0-1.25 mils DFT

Cure:
Air Dry or Force Dry 10 mins. at 180° F
(not generally required)

Drying: 1.25 mils at 77° F, 50% RH
To Touch 5 minutes
Tack Free 15-20 minutes
To Handle 10 minutes
To Recoat 20 minutes (spray)

Flash Point (Pensky Martens Closed Cup): 50° F

Package Life: 2 years, unopened

Air Quality Data:

- Non-photochemically reactive
- Volatile Organic Compounds (VOC)*
Theoretical as packaged, maximum, less exempt solvents 4.07 lbs/gal, 488 g/L

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.

Galvanized Steel: 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.

Wood (interior only): Must be clean, dry, and finish sanded.

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.

*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.

APPLICATION

Typical Setups

Reduction: Reduce with Xylol, R2K4. For lower HAPS application use R6K18 (n-butyl acetate), R6K30 (MAK), R1K3 (VM&P Naphtha) and/or R1K3 (Mineral Spirits). When reducing with VM&P Naphtha and/or Mineral Spirits be sure to add under agitation.

May be applied by:

Conventional
Airless
Electrostatic
Dip

Conventional Spray:

Reducer	R2K4 (Xylol)
Reduction Rate	25-33%

or to 25 seconds on a #2 Zahn Cup, for wetter spray use R2K5 (High Flash Naphtha)

Airless Spray:

Tip	0.013-0.017 in.
Reducer	R2K4 (Xylol)
Reduction Rate	as needed

Electrostatic Spray:

Reducer	R6K10 (MEK)
Reduction Rate	5%
Reducer for flow	R2K4 (Xylol)
Reduction Rate	as needed

Dip: Small objects/short drain only

Reducer	R2K4 (Xylol)
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Reduction Rate:
20% or 35 seconds on a #2 Zahn Cup
Excessive agitation or turbulence on part immersion or withdrawal may cause foaming.

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

Cleanup: Clean tools and equipment immediately after use with R2K4 (Xylol). For lower HAPS clean up use R6K9 (Acetone), R6K18 (Butyl Acetate), or R6K30 (MAK).

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. For good corrosion resistance, Kem Flash Prime should be applied at 1.25 mils DFT or better.
2. Apply as a full wet coat since dry spray gives poor enamel holdout and film properties.
3. Do not topcoat with polyurethane enamels, catalyzed epoxies, high PVC flat wall paints, or latex coatings.
4. On sandblasted surfaces, apply sufficient film thickness to fully protect the blast profile. This is typically 3-5 mils wet in several applications.
5. Because it is very fast drying, do not apply by brush.
6. Users should test for intercoat and system adhesion when topcoating with products containing high strength solvents.
7. Reduction with VM&P Naphtha or Mineral Spirits may result in skinning if pail is left overnight without agitation.
8. Compatible with Opticolor[®] Express & Phoenix[®] colorants. Maximum colorant tint load is 2 ounces per gallon in the E61W12.

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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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