



General Industrial Coatings

CC-A26

KEM AQUA® Bonding Primer For Plastics

White E61W525 Custom Blend Series E61BX

DESCRIPTION

KEM AQUA® Bonding Primer for Plastics is a one component, acrylic latex coating intended as a tie coating or adhesion promoting primer over structural foam plastics, such as polystyrene, polyphenylene oxide, polycarbonate, and gas counter pressure molded plastics. It can be topcoated with a wide range of coatings used in the business machine and electronic cabinetry market.

Advantages:

- Excellent adhesion to a wide range of structural foam plastics including gas counter pressure molded plastics
- Reduce and clean up with water[#]
- VOC* as packaged <1.5 lb/gal, 180 g/L less water and exempt solvents
- Fast air dry or force dry cure
- Single component - no catalyzation
- No critical recoat time
- Application friendly - may be applied using a wide variety of application equipment
- Topcoat with:
 - Kem Aqua 8710 W/R Enamel
 - Kem Aqua 600T W/R Enamel
 - Kem Aqua 8530
 - Polane® 700T W/R Enamel
 - Polane Polyurethane Enamels
- May be tinted to pastel colors using up to 4 oz/gal of Kem-Aqua colorants

[#]To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction.

* 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: Flat

Volume Solids: 41 ± 2 %

Viscosity (at 77° F): 20-25 secs., #3 Zahn Cup

Recommended Film Thickness:
 Mils Wet 1.5-2.5
 Mils Dry 0.6-1.0

Spreading Rate (no application loss):
 625-1,150 ft.²/gal. at 0.6-1.0 mils DFT

Cure:
 Air Dry or Force Dry 30 mins. at 140° F

Substrate Disclaimer: Curing of coating at temperatures higher than the heat distortion parameters of the substrate may cause substrate issues.

Drying: 1.0 mil at 77° F, 50% RH
 To Touch 10-15 minutes
 To Handle 20-25 minutes
 To Recoat 30-40 minutes

Good air movement and humidity control are necessary for proper drying of water reducible coatings.

Flash Point: 499° F
 Pensky Martens Closed Cup

pH: 7.7-8.3

Air Quality Data:
 Non-Photochemically Reactive
 Volatile Organic Compounds (VOC), Less Exempts
 < 1.5 lb/gal, < 180 g/L
 Volatile Hazardous Air Pollutants (VHAPS)
 No reportable VHAPS

Recommended Storage: Inside, sealed container, 40-95° F, no freeze hazard. Protect from moisture.

Package Life: 1 year, unopened

SPECIFICATIONS

Plastic: Due to the diverse nature of plastic substrates, a coating or coating system must be tested for acceptable adhesion to the substrate prior to use in production. Reground and recycled plastics along with various fire retardants, flowing agents, mold release agents, and foaming/blowing agents will affect coating adhesion. Please consult your Sherwin-Williams Sales Representative for system recommendations.

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.

APPLICATION

Typical Setups

Reduction: To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction. Do not over reduce. Water reducible coatings spray more easily at high viscosity than solvent reducible coatings.

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

Conventional Spray:

Reduction Rate As needed up to 5% (vol.)

Airless Spray:

Pressure 2,000-2,400 psi
Tip 0.011-0.013 in.
Reduction Rate: as needed up to 5% (vol.)

Air Assisted Airless Spray:

Air Pressure 15-30 psi
Fluid Pressure 850-950 psi
Tip 0.011-0.013 in.
Reduction Rate: as needed up to 10% (vol.)

HVLP Spray:

Atomizing Pressure 6-9 psi
Fluid Pressure 9-12 psi
Reduction Rate: as needed up to 10% (vol.)

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

Cleanup: Clean tools/equipment immediately after use with water. If dried, clean with a blend of water and ammonia as soon as possible. Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. Protect from freezing. Inside storage between 40-95° F only. Freezing will cause a dramatic increase in viscosity.
2. High humidity will slow drying.
3. Customer must test on their specific substrate for performance because a wide variety of plastics exist in the marketplace.
4. Spray a full wet coat at 1.5-2.5 mils wet for good film integrity.
5. Do not exceed 1.5 mils dry film to avoid mud cracking and improper drying.
6. Use low to moderate atomizing pressures to minimize bubbling and air entrapment.
7. Do not shake or agitate violently due to the tendency to cause foam and air entrapment.
8. Keep container closed to prevent skinning of this fast drying coating.
9. Not intended for use on metal surfaces
10. Does not provide significant corrosion resistance to systems. Not recommended where salt spray resistance is required. Use Polane® W2 Primer, E61A516, on metal when improved salt spray and corrosion resistance is required.
11. Where sanding and filling properties are needed, use Kem Aqua Sprayfil, D61H565.
12. Does not adhere to polypropylene, polyethylene, or thermoplastic polyolefins.
13. Flame treatment or other approaches are needed for adhesion to these surfaces.
14. Apply at temperatures above 50° F for optimal dry and performance properties.
15. Product viscosity may increase upon aging.
16. Compatible with Kem Aqua Colorants.

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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.

Note:

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