



General Industrial Coatings

CC-A30

KEM-FLASH® 500 Primer

Black.....E61B752 GrayE61A750 Red Oxide.....E61R751
WhiteE61W753 Custom Blend SeriesF61FX

DESCRIPTION

KEM-FLASH® 500 Primers are high quality, fast air drying, alkyd primers that are less than 3.5 lbs/gal VOC*. They satisfy the performance specification requirements of the off road equipment and general metal markets.

Advantages:

- Formulated to meet <3.5 lbs/gal VOC, less exempts, as packaged
- Excellent corrosion resistance
- Fast drying - Can be topcoated after 30 minutes
- High solids - 52% volume solids means more build with less passes
- May be applied by airless or conventional spray without reduction or heat
- Ideal primer for farm and construction equipment, machinery, railroad cars, structural steel, and fabricated metal parts requiring excellent durability and rust protection
- Can be reduced with exempt solvents, such as acetone to improve application
- Compatible with a wide range of top-coats, including:
 - Fast Production Enamel
 - High Solids Acrylic Enamel
 - Kem Acryl™ HS 100 Enamel
 - Kem Fast Dry High Solids Enamel
 - Kem Lustral® Enamel
 - Opex® Production Lacquers
 - Quick Dry 350
 - Quick Dry Enamel

*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

Gloss: Flat, 2-10

Volume Solids (varies by color): 52 ± 2 %

Viscosity: 14-32 secs., #3 Zahn Cup
40-70 secs., #4 Ford Cup

Recommended Film Thickness:

Mils Wet 3.0-3.5
Mils Dry 1.5-1.8

Spreading Rate (no application loss):
445-580 ft.²/gal. at 1.5-1.8 mils DFT

Cure:

Air Dry or
Force Dry 10-30 mins. at up to 180° F

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

Drying: 1.5 mils DFT, 77° F, 50% RH
To Touch 15-30 minutes
Tack Free 30-60 minutes
To Recoat 30 minutes

Flash Point (Pensky Martens Closed Cup): 65° F

Package Life: 2 years, unopened

Air Quality Data:

Photochemically Reactive
Volatile Organic Compounds (VOC)
Theoretical, as packaged, maximum, less exempts: 3.31 lbs/gal, 397 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.

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: For 3.5 lbs/gal VOC, reduce up to 3.5% maximum with R6K18 (Butyl Acetate), R6K30 (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 3.5 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 |
| Tip | 0.055-0.070 in. |

Airless Spray:

| | |
|----------------|-----------------|
| Fluid Pressure | 2,200-2,600 psi |
| Tip | 0.013-0.015 in. |

Air Assisted Airless Spray:

| | |
|---------------------|-----------------|
| Air Assist Pressure | 10-30 psi |
| Fluid Pressure | 1,800-2,400 psi |
| Fluid Tip | 0.013-0.015 in. |

Electrostatic Spray:

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

HVLP Spray:

| | |
|----------------|----------------|
| Air Pressure | 8-9 psi at cap |
| Fluid Pressure | 10-15 psi |

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

Cleanup: Clean tools and equipment immediately after use with R6K30 (MAK) or R6K18 (Butyl Acetate).

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. For good corrosion resistance, a minimum of 1.5 mils dry film is required.
2. Apply as a full wet coat, as dry spray gives poor enamel holdout and rough appearance.
3. 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.
4. Because of its fast drying, this product is not recommended for brush application.
5. Users should test for critical recoat and system adhesion when topcoating with products containing high strength solvents.
6. Coating thickness will increase rapidly during application because of its higher solids. Heavy films will dry slower.
7. Compatible with Opticolor Express & Phoenix colorants. Maximum colorant tint load is 3% (vol.) in E61W753.

Performance Tests*

| | |
|--------------------------------|---------------|
| Substrate: | Cleaned steel |
| Primer applied at 1.5 mils DFT | |
| Adhesion | 5B |
| Impact Resistance, Direct | 40 in lb |
| Impact Resistance, Indirect | 8 in lb |
| Conical Mandrel, 1/8" | Pass |

*Performance test results may vary depending on dry film thickness, substrate tested and post-cure duration.

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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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