



General Industrial Coatings

CC-D3

POLANE® Primer-Sealer

Gray.....E65A4 Catalyst.....V66V27 Custom Blend Series E65XX

DESCRIPTION

POLANE® Primer-Sealer, E65A4, is a two package polyurethane coating suitable for use as a primer over steel or as a primer-sealer over fillers and putties.

Advantages:

- Excellent impact resistance
- Excellent chemical resistance
- Excellent adhesion to cast iron and steel
- Excellent resistance to machine tool cutting oils
- Easy sanding
- Excellent hold out for full gloss top-coats
- Air dry or force dry
- Ideal for use as a crankcase sealer
- Intermediate coat for machine tool finishing systems

CHARACTERISTICS

60° Gloss: Flat

Volume Solids: 23 ± 2 %
Catalyzed and reduced

Viscosity: 17-23 secs., #3 Zahn Cup

Recommended Film Thickness:
Mils Wet 3.5-4.5
Mils Dry 1.0-1.25

Spreading Rate (no application loss):
256-385 ft.²/gal. at 1.0-1.25 mils DFT

Cure:
Air Dry or
Force Dry 10-30 mins. at 140-180° F

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

Drying: 77° F, 50% RH
To Touch 5-15 minutes
To Handle 40-60 minutes
To Recoat 30-60 minutes
To Sand 2 hours

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

Mixing Ratio (by volume):
Polane Primer-Sealer 13 Parts
Catalyst V66V27 1 Part
Reducer R7K69 3.5 Parts

Potlife: 8 hours @ 77° F

Air Quality Data (Theoretical)
Non-photochemically reactive
Volatile Organic Compounds (VOC)*
As packaged, maximum:
5.30 lbs/gal, 636 g/L
V66V27, as packaged, maximum
3.80 lbs/gal, 458 g/L
Catalyzed and reduced, as above
5.60 lbs/gal, 671 g/L

Package Life:
E65A4 3 years, unopened
V66V27 12 months, 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 (untreated): Prime with Industrial Wash Primer, P60G2, or RoHS Compliant Wash Primer, P60G10, or Kem Aqua® Wash Primer, E61G522.

Galvanized (untreated): Prime with Industrial Wash Primer, P60G2 or RoHS Compliant Wash Primer, P60G10, or Kem Aqua Wash Primer, E61G522.

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.

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.

Cast Iron: Fill with Polane SprayFil, sand, and seal with Polane Primer-Sealer.

Wood (interior only): Must be clean, dry, and finish sanded. Substrate should be free of any contamination to ensure optimum adhesion and coating performance properties.

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

May be applied by: Conventional Spray
Air Assisted Airless Spray
Electrostatic Spray
HVLV Spray
Dip, brush & flow coating are not recommended

Conventional Spray:

Air Pressure 45-55 psi
Fluid Pressure 10-15 psi
Fluid Nozzle 0.055-0.070 in.

Air Assisted Airless Spray:

Assist Air 15-25 psi
Fluid Pressure 1,800-2,400 psi
Tip 0.011-0.013 in.

Electrostatic Spray:

Air Pressure 45-55 psi
Fluid Pressure 12-20 psi
Fluid Nozzle 0.055 in.
40-85 Kv

HVLV Spray:

Air Pressure 7-10 psi
Fluid Pressure 8-10 psi
Fluid Nozzle 0.055-0.070 in.

Cleanup: Clean tools and equipment immediately after use with Polane Reducer.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. Polane Catalyst, V66V27, must be used to achieve proper performance. **Do not vary catalyst ratio.** The catalyst ratio has been established to provide optimum hardness, flexibility, gloss, and chemical resistance.
2. Heat shortens pot life. Do not spray hot.
3. Do not pump catalyzed material into circulating systems. Friction heat developed by pumps and circulation will shorten pot life.
4. Protect from moisture, water affects pot life and product properties. Store indoors.
5. Do not package Polane coated products in airtight plastic bags unless completely cured. Polane continues to cure for several weeks, the buildup of organic solvents and reaction byproducts could cause improper cure and adhesion failure in use.
6. Compatible with GIS, Opticolor® Express and Phoenix® 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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