



General Industrial Coatings

CC-B7

Fast Production Enamel

Gloss Black.....	F75BC6	Green	F75GC2	Equipment Yellow	G74YC165
Flat Black.....	F75BC7	Omaha Orange.....	F75EC2	Federal Yellow.....	F75YC4
Blue	F75LC2	Red.....	F75RC4	Safety Yellow.....	F75YC3
Blending Clear.....	F75V100	White.....	F75WC1	Catalyst (optional).....	V66V29
ASA 49 Gray.....	F75AC1	Blending White	F75W100	Custom Blend Series	F75XX

DESCRIPTION

Fast Production Enamel is an alkyd enamel intended for finishing or refinishing industrial, construction and agricultural equipment.

Advantages:

- Fast air dry
- Full gloss range available
- Good exterior durability, except for red, yellow, and orange
- Good one coat protection
- Good flexibility and film toughness
- Full range of custom colors
- May be catalyzed for increased hardness and improved chemical resistance properties
- Working potlife after catalyzation is 6-8 hours at room temperature

Fast Production Enamel Urethane For increased chemical abrasion resistance, improved hardness, sharper gloss, and better color and gloss retention, Fast Production Enamel may be catalyzed at an 8:1 ratio with Polane® Exterior Catalyst, V66V29, prior to reduction. Drying times will be slower.

CHARACTERISTICS

(may vary by color)

High Gloss: 85+

Volume Solids: 27-34 ± 1 %

Viscosity: 22-34 secs., #3 Zahn Cup

Recommended Film Thickness:

Mils Wet	3.5-5.0
Mils Dry	1.0-1.5

Spreading Rate (no application loss):
289-545 ft.²/gal. at 1.0-1.5 mils DFT

Cure:

Air Dry or	
Force Dry	20 minutes at 140° F

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

Drying: 77° F, 45% RH

To Touch	10 minutes
To Handle	30 minutes
To Recoat	30 minutes
To Pack	24 hours

Flash Point: 40-45° F

Pensky Martens Closed Cup

Potlife: 6-8 hours

After catalyzation at room temperature

Recoat Window: If strong solvents such as xylene or toluene are used, a critical recoat may occur between 2-18 hours.

Package Life: 3 years, unopened

V66V29 24 months, unopened

Air Quality Data:

**Non-photochemically reactive

*Volatile Organic Compounds (VOC), Less Exempts

As packaged, maximum	4.8 lbs/gal, 576 g/L
Reduced 25% with Xylene	5.3 lbs/gal, 636 g/L

**Reducing with xylene, toluene, Aromatic Naphtha, or other aromatic solvents makes this product photochemically reactive.

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. Over pre-treated aluminum, check adhesion before use as the proprietary pretreatment may change from supplier to supplier which may have an effect on the final adhesion.

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

Galvanized Iron: If untreated, prime with RoHS Compliant Wash Primer, P60G10, Industrial Wash Primer, P60G2, or Kem Aqua® Wash Primer, E61G522.

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. For exterior exposure, prime with Kem-Flash® Prime (E61A45 series).

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
Airless Spray

Conventional Spray:

Air Pressure 45-60 psi
Fluid Pressure 20-25 psi
Reducer R2K4 (Xylene)
Reduction Rate 20-25%
R2K5 (Aromatic Naphtha) or R2K1
(Toluene) can also be used.

Airless Spray:

Tip 0.013-0.017 in.
Reducer R2K4 (Xylene)
Reduction Rate 10%
R2K5 (Aromatic Naphtha) can also be
used.

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

Cleanup: Clean tools/equipment
immediately after use with toluene or xylene.

Follow manufacturer's safety
recommendations when using any solvent.

ADDITIONAL INFORMATION

1. If strong solvents such as xylene or toluene are used, a critical recoat may occur between 2-18 hours.
2. Blocking or sticking may occur when flat surfaces are stacked before adequate cure. Allow at least 24 hours before stacking.
3. Fast Production Enamel reds, oranges, and yellows contain bleeding pigments. Use caution when recoating with products containing aromatic ester or ketone solvents.
4. The reds, oranges, and yellows have been formulated to give optimum durability as packaged. Using these colors for intermixing may result in color walk out or premature fading on exposure.
5. Compatible with Opticolor® and GIS colorants. Do not add more than 16 ounces of colorant per gallon of base.

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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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