



## Equipment Enamel

Black ..... F75B51

DESCRIPTION	CHARACTERISTICS	SPECIFICATIONS
<p><b>Equipment Enamel</b> is a high gloss, alkyd acrylic, air-dry enamel. It offers good color and gloss retention and early moisture resistance. It is recommended for trailers and general metal finishing.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• VOC as packaged &lt;3.5 lbs/gal, 420 g/L less exempt solvents*</li> <li>• Good exterior color and gloss retention</li> <li>• High gloss</li> <li>• Compatible with a wide range of low solids alkyd primers</li> <li>• For improved application properties, color and gloss retention, corrosion resistance, and water resistance this product can be catalyzed 8 to 1 with V66V1020 hardener.</li> </ul> <p>*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.</p>	<p><b>Gloss:</b> 90 units at 60°</p> <p><b>Volume Solids:</b> 40.3% ± 2%</p> <p><b>Viscosity:</b> 20-30 seconds #2 Zahn Cup May reduce as needed up to 5% with acetone for application.</p> <p><b>Recommended film thickness:</b> Mils Wet 2.3 - 3.5 Mils Dry 1.0 - 1.5</p> <p><b>Spreading Rate</b> (no application loss) 410-679 sq ft/gal @ 1-1.5 mil DFT</p> <p><b>Drying</b> (1.0 mils dft, 77°F, 50% RH): To Touch: 30 minutes max To Handle: 4 hours Tack Free: 1-2 hours To Recoat: critical recoat time between 3 and 30 hours, or 2 and 24 hours when catalyzed 8 to 1 with V66V1020 catalyst</p> <p><b>Force Dry:</b> 20-30 minutes at 140-180°F</p> <p>A critical recoat period may occur and will fluctuate, depending on drying conditions and film thickness. Force drying, film thickness, and varying temperature and humidity conditions may change the critical recoat time. Recoating should be tested on a small area under actual application conditions.</p> <p><b>Flash Point:</b> 30°F PMCC</p> <p><b>Package Life:</b> 24 months unopened</p> <p><b>Storage:</b> Inside storage. Protect from moisture.</p> <p><b>Air Quality Data:</b></p> <ul style="list-style-type: none"> <li>• Photochemically reactive</li> <li>• Volatile Organic Compounds (VOC) theoretical as packaged, less exempt solvents maximum 3.45 lb/gal, 413 g/L</li> <li>• Hazardous Air Pollutants (HAPS) as packaged maximum 2.55 lb/gal. of solids</li> </ul> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility or at <a href="http://www.paintdocs.com">www.paintdocs.com</a>.</p>	<p><b>General:</b> Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties. Consult Metal Preparation Brochure CC-T1 for additional details.</p> <p><b>Steel or Iron:</b> 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.</p> <p>For improved corrosion resistance and/or adhesion the use of a primer, such as Kem Flash® Prime (E61A45 series) is highly recommended.</p> <p>Please consult your Sherwin-Williams Sales Representative for system recommendations.</p> <p><b>Testing:</b> 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.</p>

## **APPLICATION**

### Typical Setups

**Reduction:** Equipment Enamel can be applied without reduction. If reduction is needed, reduce with MAK (R6K30) or Acetone (R6K9). Can reduce with Acetone up to 5% maximum. To maintain 3.5 lb/gal VOC when using MAK, reduce 2% maximum.

**May be applied by:**

Conventional Spray  
Airless Spray  
Electrostatic Spray  
HVL

**Conventional Spray:**

Air Pressure..... 50-60 psi

Fluid Pressure ..... 10-30 psi

**Airless Spray:**

Pressure .....1800-2500 psi

Tip ..... 011-.015

**Electrostatic Spray:**

Follow equipment manufacturer recommendations.

**HVL:**

Atomizing Air Pressure at the cap 10 psi

Fluid Pressure ..... 10-25 psi

**Cleanup:**

Clean tools/equipment immediately after use with MEK (R6K10) or MAK (R6K30).

Follow manufacturer's safety recommendations when using any solvent.

## **ADDITIONAL INFORMATION**

- Maximum reduction with Acetone is 5% by volume. Exceeding this amount can cause settling, poor hide and kick out issues.
- A critical recoat period may occur between 3 and 30 hours when used without a catalyst, and between 2 and 24 hours when catalyzed 8 to1 with V66V1020 catalyst. The critical recoat time will fluctuate, depending on drying conditions and film thickness. Test a small area first.
- Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.
- Not recommended for dip application.
- Blocking or sticking will occur when flat surfaces are stacked before adequate cure.
- Pot life when catalyzed 8 to 1 with V66V1020 catalyst is 8 hours.
- Not recommended as a direct to metal enamel. Should be used over an alkyl primer.

## **CAUTIONS**

### FOR INDUSTRIAL SHOP APPLICATION ONLY

**Thoroughly review 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](http://www.paintdocs.com).

Please direct any questions or comments to your local Sherwin-Williams facility.

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