



SHERWIN WILLIAMS

# General Industrial Coatings

CC-E20

## Kem Aqua® Gloss Enamel

Machine Tool Gray ..... F77A567 Customer Blend Series..... F77KX

### DESCRIPTION

**KEM AQUA® Gloss Enamel, F77A567**, is a fast drying high gloss water reducible acrylic latex type coating intended for industrial product finishing and refinishing applications. It is ideal for the general metal finishing marketplace.

#### Advantages:

- \*VOC as packaged < 2.3 lbs/gal, less exempts
- Fast air drying
- \*\*Use water for reduction and clean-up
- Good one-coat protection
- Good application versatility using airless, conventional, HVLP and electrostatic spray handguns
- No reportable VHAPS

\* 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](http://www.PaintDocs.Com).

### CHARACTERISTICS

**60° Gloss:** 80+

**Volume Solids:** 30 ± 2 %

**Viscosity (Stormer):** 70-85 KU

**Recommended Film Thickness:**  
Mils Wet 3.7-4.7  
Mils Dry 1.1-1.4

**Spreading Rate (no application loss):**  
346-440 ft.<sup>2</sup>/gal. at 1.1-1.4 mils DFT

**Cure:**  
Air Dry or Force Dry 10-20 mins. at 140° F

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

Good air movement and low humidity will insure proper drying of water reducible coatings.

**Air Drying:** 1.1-1.4 mils at 77° F, 50% RH  
To Touch 15-20 minutes  
Tack Free 30-60 hours  
To Handle 30-60 hours  
To Recoat 30 minutes

**Flash Point:** 499° F  
Seta Closed Cup

**pH:** 8.6-9.1

**Air Quality Data:**  
Non-photochemically Reactive  
Volatile Organic Compounds (VOC), Less Exempts 2.0 lb/gal, 235 g/L  
Volatile Hazardous Air Pollutants no reportable VHAPS

**Recommended Storage:** Inside, sealed container, 40-120° F, **freeze hazard**. Protect from moisture.

**Package Life:** 2 years, 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:** If untreated, prime with Kem Aqua® Wash Primer, E61G522.

**Galvanized Steel:** If untreated, prime with 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. A filler or primer/barrier coat may be required. 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. Use one or two coats of Kem Aqua Gloss Enamel. For improved exterior corrosion resistance and adhesion, prime with Kem Aqua 50P Water Reducible Primer.

**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.

**May be applied by:** Conventional  
Airless  
HVLP

#### **Conventional Spray:**

Air Pressure 50-60 psi  
Fluid Pressure 10-12 psi  
Reducer Water  
Reduction Rate Up to 10% (vol.)

#### **Airless Spray:**

Fluid Pressure 2,500-2,800 psi  
Tip 0.011-0.015 in.  
Reducer None needed

#### **HVLP Spray:**

Atomizing Air 10 psi at cap  
Fluid Pressure 8-10 psi  
Tip 0.055 in.  
Reducer Water  
Reduction Rate 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 when the paint is still wet. If the paint is dry, use a 10:1 blend of water and R6K25 (2-butoxyethanol).

Follow manufacturer's safety recommendations when using any solvent.

## ADDITIONAL INFORMATION

1. Store inside. Protect from freezing. Product may be destroyed by freezing.
2. Higher humidity will increase dry time.
3. Do not apply at temperatures below 50° F.
4. Kem Aqua Gloss Enamel has limited salt spray resistance when applied as a direct-to-metal coating.
5. Liquid water reducible coatings may cause corrosion/rusting in the presence of steel. Tanks, containers, piping and application equipment should be lined with stainless steel or plastic.
6. Do not shake or agitate violently, as this may cause foaming and air entrapment.
7. Heavy films may show sagging. Do not exceed 4.0 mils wet film per coat.
8. Dry overnight before exposing the coating to the outside. Early rusting and corrosion will occur if adequate drying and coalescing has not occurred.
9. For recoat applications, customers should test for suitability.
10. The color of the freshly applied wet film may appear milky, but it will dry to the proper color.
11. Gloss levels may be adjusted by using D64F505, Kem Aqua Flatting Base. Refer to data page CC-S13 for details.
12. Do not use Kem Aqua Gloss Enamel over alkyd primers like Kem Aqua 70P Water Reducible Metal Primer.
13. Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.
14. Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.
15. Compatible with Kem Aqua colorants. Do not exceed 8 ounces colorant per gallon of base.

All trademarks are the property of their respective owners.

## 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](http://www.PaintDocs.Com).

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

#### **Note:**

All purchases of products from Sherwin-Williams are exclusively subject to Sherwin-Williams' [Standard Terms And Conditions Of Sale](#). Please review these terms and conditions prior to the purchase of the products.

Sherwin-Williams warrants the product to be free of manufacturing defect in accordance with Sherwin-Williams' quality control procedures. Except for the preceding sentence, due to factors that are outside of Sherwin-Williams' control, including substrate selection, and customer handling, preparation, and application, Sherwin-Williams cannot make any other warranties related to the product or the performance of the product. **SHERWIN-WILLIAMS DISCLAIMS ALL WARRANTIES OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.**

Liability for products proven to be defectively manufactured will be limited solely to replacement of the defective product or the refund of the purchase price paid for the defective product, as determined by Sherwin-Williams. Under no circumstances shall Sherwin-Williams be liable for indirect, special, incidental or consequential damages, lost profits or punitive damages arising from any cause whatsoever.