



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

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.²/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.

* 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

****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.

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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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