



General Industrial Coatings

CC-B22

Quick Dry 350 Enamel

Gloss Black.....	F77B701	Blending White	F77W700
Flat Black.....	F77B702	Gloss White	F77W708
Blending Clear	F77T704	Custom Blend.....	F77VX Series

DESCRIPTION

Quick Dry 350 Enamel is a high gloss, fast air drying coating intended for industrial product finishing applications. Ideal for use on a wide range of metal products including industrial OEM, maintenance, and construction applications.

Advantages:

- Available in a broad range of colors
- Free of MAK solvent odor
- Fast air dry
- High gloss
- Good one coat protection, good flow and leveling
- May be applied by conventional, airless, HVLP, and air-assisted airless spray
- Can be reduced with exempt solvents to improve application (see Application section)
- Formulated to meet 3.5 *VOC, less exempts

CHARACTERISTICS

60° Gloss
 High Gloss 80+
 Flat Black 0-10

Volume Solids: 50-54 ± 2 %

Viscosity (at 77° F):
 F75B702 50-75 secs., #4 Ford Cup
 All Others 25-55 secs., #4 Ford Cup

Recommended Film Thickness:
 Mils Wet 2.0-3.0
 Mils Dry 1.0-1.5

Spreading Rate (no application loss):
 556-898 ft.²/gal. at 1.0-1.5 mils DFT

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

Drying: (1.5 mils at 77° F, 50% RH)
 To Touch 15-30 minutes
 To Handle 20-25 minutes
 Tack Free 4 hours
 To Pack 20 hours

Recoat Window: A critical recoat time may occur between 2 and 36 hours. This may fluctuate depending on film thickness and drying conditions. Test a small area first.

Flash Point: 80° F
 Pensky Martens Closed Cup

Air Quality Data:
 Photochemically Reactive
 Volatile Organic Compounds (VOC)
 (admixed, maximum) 3.37 lb/gal, 404 g/L

Recommended Storage: Inside, sealed container, 40-120° F, no freeze hazard. Protect from moisture.

Package Life: 18 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: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2 or Kem Aqua® Wash Primer, E61G522. Over pretreated 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: Prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2 or Kem Aqua Wash Primer, E61G522.

Steel or Iron: Remove rust, mill scale, and oxidation products. For best results in corrosion protection, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate and/or prime using Kem-Flash® 500 Primer at 1.25-1.50 mils DFT.

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: Ready-to-spray. If reduction is necessary, up to 5% R6K9 (acetone, exempt solvent) is recommended. Reduce up to 3.5% by volume with Xylene or 100 Flash Naphtha to maintain 3.5 lb/gal VOC.

Maximum wet film thickness is 3.5 mils.

May be applied by: Conventional
Airless
Air Assisted Airless
HVLP

Conventional Spray:

Air Pressure 40-60 psi
Fluid Pressure 10-20 psi

Airless Spray:

Fluid Pressure 1,800-2,200 psi
Tip 0.011-0.015 in.

Air Assisted Airless Spray:

Air Assist Pressure 30-60 psi
Fluid Pressure 1,200-2,100 psi
Tip 0.011-0.015 in.

HVLP Spray:

Atomizing Air Pressure At Cap < 10 psi
Fluid Pressure 10-20 psi

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

Cleanup: Clean tools/equipment immediately after use with Hi Flash Naphtha 100. For HAPS compliant solvent clean-up, use R6K18 (n-butyl acetate).

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. Surface to be finished must be free of grease, dirt, and other foreign matter.
2. Blend custom colors using Phoenix® colorants.
3. Maximum wet film thickness per coat should not exceed 3.5 mils.
4. Quick Dry 350 Enamel has limited exterior color and gloss retention and should not be used for coating products where extended gloss and color retention properties are expected.
5. For improved corrosion resistance, use over Kem-Flash® 500 Primer. It is recommended to test with the customer's system.
6. Product is non-polar and will not spray electrostatically.
7. The addition of acetone will lower flash point.
8. 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.
9. Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.
10. Compatible with Color Express, GIS, Opticolor® Express and Phoenix® colorants.

	Maximum Tint Load
Color Express	28 oz/gal
GIS	28 oz/gal
Phoenix	28 oz/gal

Performance Tests

Substrate: Q-Panel cold rolled steel

Salt Spray Test 24-48 hours

(ASTM B117)

Humidity Resistance 144 hours

Pencil Hardness 3B*

*Pencil Hardness may vary depending on dry film thickness, substrate and tester.

Impact Resistance, Direct 20 in lb

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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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