General Industrial Coatings

CC-B10

Quick Dry Enamel

Gloss Black	F77B1	Aluminum	F77S12	Clear Tint Base	F77V100C
Flat Black	F77B2	Motor Blue	F77L6	Mid-Gloss Clear Tint Base	F77V103C
Blending Clear	F77V100	Machine Tool Gray	F77A3	Satin Clear Tint Base	F77V102C
Gloss White	F77W8	Machinery Red	F77R14	Custom Blend Series	F77XX
Blending White	F77W100	Safety Yellow	F77Y15	Custom Tint Series	F77XN
				Antimicrobial Series	F77XM

DESCRIPTION

Quick Dry Enamel is a fast drying industrial finishing enamel intended for coating various metal products. It is ideal for industrial, OEM, maintenance, and new construction applications. It offers versatility and efficiency of application because of its quick drying properties.

Quick Dry Enamel Antimicrobial Blends contain an anti-microbial additive which protects the coating surface from microbial growth. Normal cleaning and surface maintenance practices should always be followed.

Advantages:

- Very fast air drying - process efficient
- Good one coat protection
- No critical recoat time
- Can be applied using conventional spray, airless spray, or electrostatic spray equipment or by dip coating
- Available in a broad range of colors
- Lower gloss levels are available by using D64F100 Gloss Modifying Agent

* 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.

CHARACTERISTICS

60° Gloss:

High Gloss	80+
Flat Black	2-8
F77V100C (Clear Tint Base)	80+
F77V103C	55-65
F77V102C	25-35

Volume Solids (varies by color): 26-31 ± 2 %

Viscosity: 30-50 secs., #2 Zahn Cup
(varies by color) 30-45 secs., #4 Ford Cup

Recommended Film Thickness:

Mils Wet	3.5-5.0
Mils Dry	0.8-1.2

Multiple passes to obtain film build are recommended. See Additional Information section.

Spreading Rate (no application loss): 335-640 ft.^{2}/gal. at 0.8-1.2 mils DFT

Cure:

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

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

Drying: (1.0 mil at 77° F, 50% RH)

To Touch	5-10 minutes
To Handle	10-15 minutes
To Tack Free	15-30 minutes
To Recoat	30 minutes
To Pack	4-5 hours*

*varies significantly depending on application conditions

Flash Point: 35-55° F
(Pensky Martens Closed Cup)

Air Quality Data:
Photochemically Reactive
Volatile Organic Compounds 5.35 lbs/gal, 640 g/L
(VOC, theoretical as packaged, maximum, less exempts)

Recommended Storage: Inside, sealed container, 40-120° F, no 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 RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2 or Kem Aqua® Wash Primer, E61G522. 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: 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, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection. When properly cured, Kem® 400 Primer will provide better corrosion protection and gloss retention. Kem-Flash® Prime will provide the best corrosion protection.

Wood (interior only): Must be clean, dry, and finish sanded.

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.

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APPLICATION

Typical Setups

Reduction: For a wetter spray or to improve flow and leveling, reduce with small amounts of R2K5 (Hi Flash Naphtha 100) or R2KT4 (Aromatic Naphtha 150). See below for additional recommendations.

May be applied by: Conventional Spray
Airless Spray
Electrostatic Spray
Dip Coating

Conventional Spray:

Air Pressure	45-50 psi
Fluid Pressure	8-10 psi
Reducer	R2K4 (Xylene, Xylol)
Reduction Rate	20-25 % (vol.)

Airless Spray:

Fluid Pressure	1,800 psi
Tip	0.013-0.017 in.
Reducer	R2K4 (Xylene, Xylol)
Reduction Rate	15-20 % (vol.)

R6K28 (Butyldiglycol, Butyl Carbitol®), may be added up to 3% by volume as a retarder solvent.

Electrostatic Spray:

For Polarity

Reducer	R6K30 (MAK) or R6K10 (MEK)
Reduction Rate	Up to 10% (vol.) for wrap

For Flow

Reducer	R6K10 (MAK) or R2K5 (Hi Flash Naphtha 100)
Reduction Rate	As needed

Dip (small parts only)**:**

Reducer	R2K4 (Xylene, Xylol) or R2K5 (Hi Flash Naphtha 100)
Reduction Rate	15-20 % (vol.)

Excessive agitation or turbulence on part immersion or withdrawal may cause foaming. Tank maintenance (agitation, turnover rate, viscosity control, and stability) is required.

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

Cleanup: Clean tools/equipment immediately after use with R2K4 (Xylene, Xylol), R2K5 (Hi Flash Naphtha 100), or other aromatic solvents. For HAPS compliant solvent clean-up, use R6K18 (n-butyl acetate).

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. 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.
2. Multiple passes to obtain film build are recommended rather than a single heavy pass. Excessive film build may cause solvent popping because of the quick drying nature of this product.
3. Use of very slow evaporating solvents may increase the tack free time and keep the coating softer for a longer time.
4. Quick Dry Enamel has no critical recoat time and can be recoated at any time. However, field conditions may vary and recoating should be tested on a small area.
5. Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.
6. Compatible with Opticolor® Express, Phoenix® & GIS colorants. Maximum colorant tint loads are shown in the table below:

	F77V100	F77W8	F77W100
Opticolor Express	24 oz/gal	16 oz/gal	16 oz/gal
Phoenix	24 oz/gal	-	16 oz/gal
GIS	24 oz/gal	16 oz/gal	16 oz/gal

Performance Tests*

Substrate:	Steel Q-Panel®
Topcoat:	0.8-1.0 mil DFT, Quick Dry Enamel
Cure:	30 Days, Air Dry
Salt Spray Test (ASTM B117)	Passes 24-48 hours
Impact Resistance, Direct	Pass 10 in lb
Pencil Hardness	HB

*Performance test results may vary depending on dry film thickness, substrate tested and post-cure duration.

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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