General Industrial Coatings

CC-B20

Fast Dry Acrylic Enamel

Clear	F78T104	Blending White	F78W100	Silver	F78S32
Gloss Black	F78B21	Brite Red	F78R30	Safety Yellow	F78Y29
Gloss White	F78W28	Machinery Red	F78R27	Catalyst (Optional)	V66V29
				Custom Blend Series	F78XX

DESCRIPTION

Fast Dry Acrylic Enamel is a high gloss, durable acrylic enamel. Its fast air-drying properties make it ideal for coating various metal products.

Advantages:

- Very fast air dry
- Good gloss and color retention
- Good one coat protection
- High gloss
- May be catalyzed with Polane® Catalyst V66V29 for increased hardness and improved resistance properties
- Application by conventional, airless, air assisted airless, and electrostatic spray
- Available in a broad range of colors

Fast Dry Acrylic Urethane:
For increased chemical and abrasion resistance, improved hardness and color and gloss retention, Fast Dry Acrylic Enamel may be catalyzed at an 8:1 ratio with Polane Exterior Catalyst V66V29 prior to reduction. Drying times are slower than for uncatalyzed Fast Dry Acrylic. Working potlife after catalyzation is 6-8 hours at room temperature.

* 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: 85 min.

Volume Solids: 32-37 %
Varies by color

Viscosity (at 77° F):

40-60 secs.	#2 Zahn Cup
30-40 secs.	#4 Ford Cup

Recommended Film Thickness:

Mils Wet	3.0-4.5
Mils Dry	1.0-1.5

Spreading Rate (no application loss):
340-595 ft.^{2}/gal. at 1.0-1.5 mils DFT

Cure:
Air Dry
Force Dry 10-20 mins. at 140-180° F

Drying: 1.0 mil at 77° F, 50 % RH

To Touch	5-10 minutes
To Handle	10-15 minutes
Tack Free	30-45 minutes
To Recoat	*before 6 hours or after 36 hours

***Critical Recoat**:
Do not recoat after 6 hours or before 36 hours air drying at room temperature. Force drying, film thickness, and varying humidity conditions may change critical recoat time. Recoating should be tested on small areas under actual application conditions.

Mixing Ratio (when catalyzed, by volume):

Fast Dry Acrylic Enamel	8 Parts
V66V29 Catalyst	1 Part

Potlife (when catalyzed): 6-8 hours

Flash Point (Pensky Martens Closed Cup): 45° F

Air Quality Data:
Photochemically Reactive

*Volatile Organic Compounds (VOC): (theoretical as packaged, maximum, less exempt solvents)	4.95 lbs./gal 593 g/L
Reduced 25% with R2K4 (Xylene):	5.40 lbs./gal 647 g/L

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. 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.

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, prime with Kem-Flash® 500 Primer (E61A750 series) or Kem-Flash 500 Low HAPS Primer (E61A712). For optimal gloss holdout use Kem® 400 Primer (E61A400).

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

May be applied by: Conventional, Airless, Electrostatic, HVLP

Conventional Spray:

Air Pressure	50-60 psi
Fluid Pressure	10-15 psi
Tip	0.055-0.070 in.
Reducer	R2K4 (Xylene)
Reduction Rate	up to 25 % (vol.).

- Apply a full wet coat, allow a 10 mins. flash off and apply another full wet coat.
- For warm temperatures and large surface areas, use a 1:1 blend of Xylene:Aromatic Naphtha-100 Flash (adjust mix ratio as needed).

Airless Spray:

Fluid Pressure	2,400-2,800 psi
Tip	0.011-0.015 in.
Reducer	Aromatic Naphtha-100 Flash
Reduction Rate:	up to 20 % (vol.).

Electrostatic Spray:

Air Pressure	45-55 psi
Fluid Pressure	10-15 psi
Tip	055-.070"
Reducer For Polarity	R6K10 (MEK)
Reduction Rate	5 % (vol.)
Reducer For Flow	1:1 Xylene:Aromatic Naphtha 100
Reduce Rate	up to 25 % (vol.)

HVLP Spray:

Air Pressure	Max 10 psi at cap
Fluid Pressure	8-10 psi
Tip	0.055-0.070 in.

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). For HAPS compliant cleanup, use R6K18 (Butyl Acetate).

ADDITIONAL INFORMATION

1. If catalyzing, **DO NOT VARY CATALYST RATIO.** The catalyst ratio has been established for optimum hardness, flexibility, gloss, and chemical & solvent resistance.
2. Critical Recoat: Do not recoat after 6 hours or before 36 hours air drying at room temperature. Force drying, film thickness, and varying humidity conditions may change critical recoat time. Recoating should be tested on small areas under actual application conditions.
3. Fast Drying Acrylic Enamels apply best at temperatures above 65° F.
4. For maximum gloss holdout, use Kem 400 Primer. Primers such as Kem-Flash Prime give poorer gloss hold-out and may be lifted by the strong solvents in the Fast Dry Acrylic Enamel.
5. When applied to properly cleaned, untreated cold rolled steel, optimum adhesion is obtained after 4-7 days air drying. Heavier films (greater than 1.5 mils) require longer drying to obtain best adhesion. Over iron phosphate pretreatment or recommended primers, topcoat adhesion develops much faster.
6. Force dry schedules may affect color of white coatings because of the heat.
7. For optimum gloss and enamel hold-out:
   a. allow at least 2 hours drying of the primer.
   b. apply topcoat at 1.5-1.8 mils dry film thickness. Lower film thickness will product lower gloss.
8. Do not add more than 16 ounces of Opticolor® Express colorant per gallon.

Performance Tests*

Substrate:	Q-Panel cold rolled steel panels
Cure:	30 days, Air Dry
Salt Spray Resistance (ASTM B117)	110-120 hours 1/8" creep maximum no face rust
Humidity Resistance (ASTM D2247, 100° F, 100 % RH)	Pass 200 hours
Impact Resistance, Direct	20 in lb
Impact Resistance, Indirect	5 in lb
Conical Mandrel, 1/8"	Pass
Pencil Hardness	3B

*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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Follow manufacturer's safety recommendations when using any solvent.