



TECHNICAL INFORMATION

KEM AQUA® COLORLINE® EP
CLEAR
F83VC0508

CHEMICAL
COATINGS

PRODUCT DESCRIPTION

Kem Aqua® Colorline® EP, is a one component coating designed to meet the performance and application requirements of the Consumer Electronics Market for decorative plastics finishes.

Advantages:

1. VOC of less than 0.45 Kg/L (3.76 bs./gal.).
2. Volatile Organic Emissions of less than 0.22 Kg/L (1.7 lbs./gal.).
3. Excellent smoothness.
4. Low temperature cure, 60°C (140°F).
5. Excellent hardness.
6. Excellent chemical resistance.
7. Adheres to high impact polystyrene (HIPS) and Acrylonitrile-Butadiene-Styrene (ABS).
8. Reduced fire hazards and fewer odors for improved working conditions, lower insurance rates.
9. Apply with conventional or HVLP.
10. Full gloss range.
11. Can be blended with up to 4 oz/gal Kem Aqua Colorants.
12. Aluminum pigments may be added if properly wetted out with butyl cellosolve and/or butyl carbitol. The VOC does increase with this addition.

CHARACTERISTICS

Density: 1.01 Kg/L (8.33 lb./gal.)

Gloss at 60°: 85+

Volume Solids: 25 ± 1

Weight Solids: 27.5 ± 1

Package Viscosity: 22-25 sec. Zahn #3 (agitated) at 25°C (77°F) paint temperature

Dry Film Thickness: 18-25µ (0.7-1.0 mils)

Wet Film Thickness: 35-54µ (1.5-2.1 mils) (per application) coat 2 times to achieve total DFT of .7-1.0 mils.

Spreading Rate: 10.4 M²/L at 20.8µ
408 sq.ft./gal. at 1.0 mil DFT

pH: 8.6 – 8.9

Flash Point: >230°F

Package Life: 12 months

CHARACTERISTICS - continued

Air Quality Data:

Non-Photochemically reactive.

Volatile Organic Compounds (VOC):

as packaged, less water

0.45 Kg/L (3.76 lb./gal.)

Volatile Organic Emissions:

as packaged, maximum

0.24 Kg/L (1.86 lb./gal.)

Volatile HAPS 0.12 Kg/Kg(0.012 lb./lb.)

Drying:

Product must be force dried to achieve full film performance.

To touch 3 - 5 minutes

Force dry 10-12 minutes at 60°C (140°F)

Recoat after force drying

Good air movement and humidity control are necessary for proper drying of waterborne coatings.

APPLICATION

Reduction:

1. Ready to spray, but optimum agitated spray viscosity is 22 to 25 sec., Zahn #3 at 25°C (77°F) paint temperature. (As paint temperature increases, agitated Zahn #3 viscosity will decrease.)
2. When reducing use water for sprayability. Use up to 20% water (color dependent).
3. With pigmented or metallic blends a minimum of 0.7 mils or 17.5 microns is required to achieve full hiding and the over 60 degree gloss. Multiple passes to achieve film build are preferred to a single heavy pass.

Spray Equipment:

Conventional

Air Pressure 50-70 psi

Fluid Pressure 5-10 psi

Cap/Tip 797/FF

HVLP

Gun Graco Delta

Atomizing Pressure 50 psi

Fluid Pressure 8-10 psi

Cap/Tip .042 needle; 192-321 air cap

Recommended fluid delivery rate is between 4 to 8 oz./minute depending on line/application rates. Drier spray (low fluid delivery and high atomization, 60-65 psi) is recommended for metallics.. **Do not spray wet.**

APPLICATION - continued

Clean Up: This product dries hard, adheres tightly to tanks and equipment, and is difficult to clean once material is fully dry. For best results, wash with water while coating is still wet. If the product has begun drying, use a blend of water and butyl cellosolve for clean up. Use protective safety apparel (rubber gloves, organic vapor respirator, and safety glasses) when handling the solvent solution. Follow manufacturer's safety instructions when using any solvent.

SPECIFICATIONS

General: Substrate should be free of grease, oil, dirt, fingerprints, and mold release agents to ensure proper adhesion and appearance.

Plastics: Kem Aqua® Colorline® EP is designed primarily for use on high impact polystyrene, but will adhere to ABS. Given the broad diversity of plastics, you should consult with your Sherwin-Williams representative for specific applications.

Product Limitations:

1. Avoid freezing. Store at temperatures of 10-40°C (50-100°F).
2. Keep container closed to prevent skinning. Filtering may be required.
3. Shelf life is 12 months.
4. Mix under slow agitation only 15 minutes for 19L (5 gallon) sample.
5. Minimum 10µ (0.4 mils) dry is required for good adhesion and film integrity.

Chemical Resistance:

Isopropanol	Excellent
Windex®	Excellent
Castor Oil	Excellent
Ethanol	Excellent

Stain Resistance:

Coffee	Excellent
Coca Cola®	Excellent
Catsup	Excellent

(continued on back)

CAUTIONS

Thoroughly review product label for safety and cautions prior to using product. A Material Safety Data Sheet is available from your local Sherwin-Williams facility.

VAPOR HARMFUL.

Use only with adequate ventilation. Wear an appropriate properly fitted vapor/particulate respirator (NIOSH/MSHA approved) during and after application, unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Avoid contact with skin and eyes. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage.

FIRST AID:

If In Eyes: Flush eyes with large amounts of water. Get medical attention if irritation persists.

If Swallowed: Get medical attention immediately.

Spill And Waste: Remove all sources of ignition. Ventilate and remove with inert absorbent. Incinerate in approved facility. Do not incinerate closed container. Dispose of in accordance with Federal, State, and local regulation regarding pollution.

Warning: This product contains chemicals known to the State of California to cause cancer.

**DO NOT TAKE INTERNALLY
KEEP OUT OF REACH OF CHILDREN
FOR INDUSTRIAL USE ONLY
SEE MATERIAL SAFETY DATA SHEET**

Note:

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating and opinions stated above pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties or guarantees as to the end results.