



**SHERWIN
WILLIAMS**

General Industrial Coatings

CC-C1

OPEX[®] Production Lacquers

Gloss Black.....	L61B21	Blending White	L61W100	Flamboyant Aluminum	L61S18
Blending Clear	T82C100	Gloss White	L61W34	Red	L61R44
		Semi-Gloss Soft White.....	L61W38	Yellow	L61Y36
		Tinting White.....	L61W19	Custom Blend Series	L61XX

DESCRIPTION

OPEX[®] Production Lacquer is a nitrocellulose alkyd lacquer for industrial product finishing.

Advantages:

- Fast air drying
- Interior and exterior use on metal
- No critical recoat time
- Non-bleeding pigments
- USDA acceptable for use in areas of incidental food contact
- A full gloss range is available using Opex Lacquer Flattening Agent L65F1, (see data page CC-S2 for details)

Air Quality Data

Photochemically reactive

Volatile Organic Compounds (VOC)*

- as packaged, theoretical, maximum, less exempts: 6.19 lbs/gal, 742 g/L
- reduced 100% with R7K120
6.39 lbs/gal, 767 g/L

*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

Gloss: Full
Semi-gloss White 40-45 units
Aluminum 25-35 units

Volume Solids (varies by color): 25 ± 2 %
Except L61S18, T82C100 & L61W100

Viscosity: 20-25 secs., #2 Zahn Cup
Reduced 100% with R7K120

Recommended Film Thickness:
(Reduced 100% with R7K120)

Interior applications:
(achieved with multiple coats)

Mils Wet 6.0-8.0

Mils Dry 0.8-1.0

Exterior applications:
(achieved with multiple coats)

Mils Wet 8.0-10.0 primed

11.0-16.0 unprimed

Mils Dry 1.0-1.2 primed

1.4-2.0 unprimed

Spreading Rate (no application loss):
100-250 ft.²/gal. at 0.8-2.0 mils DFT

Cure:
Air Dry or
Force Dry 10-15 mins. at 180° F
Good air movement is more important than heat.

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

Drying: 1.0 mil DFT, 77° F, 45% RH
Tack Free 5-10 minutes
To Topcoat No critical recoat time
To Pack 2-4 hours

Flash Point (Pensky Martens Closed Cup):
21-40° F, PMCC

Package Life:
L61S18, T82C100, L61W100 2 years unopened
All others 3 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: Prime with Kem Aqua[®] Wash Primer, E61G522.

Galvanized Steel: Prime with 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. Opex Lacquers are self-priming on steel. For optimum exterior durability, prime with Opex Lacquer Primer Surfacer, P61 series.

Wood (interior only): Must be clean, dry, and finish sanded. Prime with Sher-Wood[®] Primer, P65W1 or P65W4.

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.

APPLICATION

Typical Setups

With high humidity, it may be necessary to use Lacquer Thinner, R7K27 to reduce or eliminate blushing.

Conventional Spray:

Reducer R7K120
Reduction Rate 50-100%

Warm Spray:

Reducer R7K22
Reduction Rate 50-75%

Dip:

Reducer R7K22 or R7K27
Reduction Rate 50-75%

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 Lacquer Thinner R7K120.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. This nitrocellulose quality will show yellowing upon aging, especially in whites. Topcoating with clear wood finish lacquers may cause unacceptable yellowing over time.
2. To avoid yellowing on cabinets/furniture, Sher-Wood Pigmented Conversion Varnish or Sher-Wood White Vinyl Sealer, P63W2, and Sher-Wood CAB-Acrylic Lacquer systems should be recommended.
3. Saturated colors provide better color retention than very light tints on exterior exposure.
4. After force drying, cool articles to prevent sticking.
5. High humidity may cause blushing with lacquers, use Retarder Thinner to reduce blushing.
6. Do not use on exterior wood products.
7. Do not use over Industrial Wash Primer, P60G2 as poor adhesion may result. Use Kem Aqua Wash Primer, E61G522 over untreated aluminum and galvanized metal.
8. Does not meet KCMA performance specifications.
9. Yellow, L61Y36, has limited exterior durability
10. Custom colors and custom gloss ranges available. Please consult your local Sherwin-Williams facility or representative.
11. Compatible with GIS, Opticolor Express & Phoenix colorants. Maximum colorant tint load is 32 ounces per gallon in the T82C100 and 4 ounces per gallon in the L61W100.

Performance Tests*

Hardness:

With one hour drying, this will withstand one psi with no marring or film transfer.

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

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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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