



**SHERWIN  
WILLIAMS.**

# Industrial Wood Coatings

CC-E25

## KEM AQUA® BP ENAMEL

White .....M64WL535  
Phthalo Green .....M64GL541

Bright Red.....M64RL540  
Black.....M64BL537

Blending Clear .....M64CL536  
Red Oxide.....M64RL538  
Yellow Oxide.....M64YL539  
Custom Blend.....M64BP Series

DESCRIPTION	CHARACTERISTICS	SPECIFICATIONS
<p><b>KEM AQUA® BP ENAMEL</b> is a one component waterbased acrylic polyurethane dispersion enamel. It can be used on pre-primed metal, PVC, wood, fiberglass pultrusions and SMC fiberglass door skins.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"><li>• Emitted VOC as packaged &lt;1.0lb/gal*</li><li>• Good gloss and color retention</li><li>• Interior and exterior use</li><li>• Can be used on pre-primed metal, plastic, wood, or composite with the appropriate primer, basecoat, or surface preparation.</li></ul> <p>*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.</p>	<p><b>Gloss @ 60°:</b> 30 - 40 units</p> <p><b>Volume Solids:</b> 31- 36 ± 2% As packaged, varies by color and reduction</p> <p><b>Viscosity:</b> 23 – 30 Secs #3 Signature Zahn</p> <p><b>Recommended film thickness:</b> Mils Wet 3.0-5.0 mils Mils Dry 1.1-1.8 mils</p> <p><b>Spreading Rate</b> (no application loss) 275 – 525 sq ft/gal @ 1.0 – 1.8 mils DFT</p> <p><b>Drying (77°F, 50% RH):</b> To Touch: 10 – 15 minutes To Handle: 40 – 50 minutes Tack Free: 15 - 20 minutes To Sand: 50 – 60 minutes To Recoat: no critical recoat (sand between coats) To Topcoat: 60 minutes To Pack: overnight Force Dry: Flash off time 5 minutes, then 15 minutes at 140°F</p> <p>Good air movement and humidity control are necessary for proper drying of water reducible coatings.</p> <p><b>Flash Point:</b> None</p> <p><b>Package Life:</b> 12 months, unopened Protect from freezing</p> <p><b>Air Quality Data:</b></p> <ul style="list-style-type: none"><li>• Non-Photochemically reactive</li><li>• VOC theoretical as packaged, maximum, less water and exempt solvents: 1.10 lb/gal 132 g/L</li></ul> <p>Hazardous Air Pollutants (HAPS) as packaged &lt;0.8 lbs/gal solids</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility or at <a href="http://www.paintdocs.com">www.paintdocs.com</a>.</p>	<p><b>General:</b> Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivity treatments to ensure optimum adhesion and coating performance properties.</p> <p><b>Any use over metal must be primed. Compatibility and suitability of each primer should be tested with Kem Aqua® BP Enamel to insure it meets customer's specifications.</b> Consult Metal Preparation Brochure CC-T1 for additional details.</p> <p><b>Plastic/composites:</b> Due to the diverse nature of plastic/composite substrates, a coating or coating system must be tested for acceptable adhesion to the substrate prior to use in production. Reground and recycled plastics along with various fire retardants, flowing agents, mold release agents, and foaming/blowing agents will affect coating adhesion. A filler or primer/barrier coat may be required. Please consult your Sherwin-Williams Sales Representative for system recommendations.</p> <p><b>Wood (interior):</b> Must be clean, dry, and finish sanded. Substrate should be free of any contamination to ensure optimum adhesion and coating performance properties. Moisture content of wood should be 6-8%. Use suitable interior millwork primer.</p> <p><b>Wood (Exterior) –</b> Must be primed clean, dry, and finish sanded. Substrate should be free of any contamination to ensure optimum adhesion and coating performance properties. Use suitable exterior quality millwork primer. Due to the nature of wood and use of various primers these products should be thoroughly tested for exterior performance.</p>

## **SPECIFICATIONS**

**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

### **May be applied by:**

Conventional Spray  
Airless Spray  
Air Assisted Airless  
HVLP

### **Conventional Spray:**

Air Pressure.....25 – 60 psi  
Fluid Pressure .....5 – 20 psi

### **Airless Spray:**

Pressure .....1000 - 1200 psi  
Tip ..... Dependent on line speed

### **Air Assisted Airless:**

Air Assist Pressure.....10 - 20 psi  
Fluid Pressure .....200-800 psi

### **HVLP:**

Gun.....Binks Mach 1  
Air Pressure at the cap .....40 - 65 psi  
Fluid Pressure ..... 6-10 psi

### **Cleanup:**

Clean tools and equipment immediately after use with a mixture of water and 2-Butoxyethanol (R6K25). Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using solvents.

## **ADDITIONAL INFORMATION**

- All colors for heat sensitive substrates (Vinyl, PVC, etc) **MUST** be submitted to the Building Products Lab for TSR and HBU testing and approval before the product is used in customer production environments. Contact Building Products Lab or Building Products Marketing for further details.
- Bright Red (M64RL540) is intended for interior applications. Use of this colorants for exterior applications should be evaluated on a case by case basis
- Product is designed for interior or exterior use. Please consult your Sherwin-Williams Representative to discuss use for exterior applications.
- If Kem Aqua® colorants are used product must be tested for compatibility and exterior testing must be performed.
- Do not use D59B500 (Kem Aqua® black colorant) in this product.
- Do not use M64CL536 (Blending Clear) as a stand alone clear finish. It is intended to be used for custom blending.
- Protect from freezing. Store inside between 45° - 90°F.
- Do not apply below 60°F. Recommended application temperature is 60° - 90° F

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## **CAUTIONS**

FOR INDUSTRIAL SHOP APPLICATION  
ONLY

**Thoroughly review 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](http://www.paintdocs.com).

Please direct any questions or comments to your local Sherwin-Williams facility.

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