Industrial Wood Coatings

SHERWIN WILLIAMS

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

KEM AQUA® BP ENAMEL 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.

Advantages:

- Emitted VOC as packaged <1.0lb/ gal*
- Good gloss and color retention
- Interior and exterior use
- Can be used on pre-primed metal, plastic, wood, or composite with the appropriate primer, basecoat, or surface preparation.

*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.

CHARACTERISTICS

Gloss @ 60°: 30 - 40 units

Volume Solids: 31- 36 ± 2%
As packaged, varies by color and reduction

Viscosity:
23 – 30 Secs #3 Signature Zahn

Recommended film thickness:

Mils Wet	3.0-5.0 mils
Mils Dry	1.1-1.8 mils

Spreading Rate (no application loss)
275 – 525 sq ft/gal @ 1.0 – 1.8 mils DFT

Drying (77°F, 50% RH):

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

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

Flash Point: None

Package Life: 12 months, unopened
Protect from freezing

Air Quality Data:

- Non-Photochemically reactive
- VOC theoretical as packaged, maximum, less water and exempt solvents: 1.10 lb/gal 132 g/L

Hazardous Air Pollutants (HAPS) as packaged <0.8 lbs/gal solids

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com.

SPECIFICATIONS

General: 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.

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. Consult Metal Preparation Brochure CC-T1 for additional details.

Plastic/composites: 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.

Wood (interior): 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.

Wood (Exterior) – 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.

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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

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.

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