



# General Industrial Coatings

CC-E33

## KEM AQUA® 3001 Enamel

Waterborne Acrylic Urethane Topcoat for Building Products

Blending Clear Satin ..... M64V601    White Satin ..... M64W600    Standard Blend ..... M64SK Series  
Blending Clear Semi-Gloss .... M64V603    White Semi-Gloss ..... M64W602    Solar Reflective Blend ..... M64XS Series

### DESCRIPTION

**KEM AQUA® 3001 Enamel** is a single component, waterborne acrylic urethane topcoat available in satin and semi-gloss sheen. This waterborne enamel is developed for vinyl and fiberglass substrates on interior and exterior building products, such as shutters, moldings, doors and windows.

KEM AQUA 3001 Enamel is designed to meet AAMA 613 and AAMA 623 performance requirements. Refer to the AAMA standards for performance requirements & testing. For those customers requiring AAMA 614 or 624 performance, contact Marketing for additional information.

#### Advantages:

- Good gloss retention.
- Interior and exterior use.
- Can be applied directly to most vinyl substrates.
- Can be used for both horizontal and vertical applications.
- May be used in one coat or two coat applications, with light sanding between coats
- No critical recoat period.
- For heat sensitive substrates, custom colors are available using **Kem Aqua Solar Reflective** colorants.
- For Fiberglass and non-heat sensitive composites, **standard** KEM AQUA colorants can be used.
- Complies with 2.3 \*VOC solvent emissions.
- Formulated to be HAPS free.
- Free of chromate hazards.

\* 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](http://www.PaintDocs.Com).

### CHARACTERISTICS

#### 60° Gloss (varies by color):

Satin	15-20
Semi-Gloss	36-45

#### Volume Solids:

Satin	29-32 ± 2 %
Semi-Gloss	28-31 ± 2 %

#### Viscosity (at 77° F):

As Packaged 28-36 secs., #3 Zahn Cup

#### Recommended Film Thickness:

One Coat Application	
Mils Wet	3.4-5.0
Mils Dry	1.1-1.4
Two Coat Application	
Mils Wet, Per Coat	2.8-3.1
Mils Dry, Per Coat	0.9-1.0
Mils Dry, Total	1.7-2.0

#### Spreading Rate (no application loss):

450-510 ft.<sup>2</sup>/gal. at 1.0 mil DFT

#### Cure:

Air Dry or  
Force Dry 10 mins. flash, 10 mins. at 140° F

See Additional Information section for more information.

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

#### Drying:

(at 77° F, 50% RH)

To Touch	30-45 minutes
Tack Free	20-35 minutes
To Handle	35-45 minutes
To Sand	45-60 minutes
To Recoat w/ Itself	No Critical Recoat Time
To Pack	Overnight
Total (Full Properties)	7-10 days

**Recoat Window:** If the coating is older than 7 days, it must be sanded/scuffed prior to reapplication or topcoating to ensure removal of any accumulated dust/dirt.

#### Flash Point

N/A

#### pH:

7.5-9.0

#### Air Quality Data:

Non-photochemically Reactive	
Volatile Organic Compounds (VOC):	2.30 lb/gal
As packaged, maximum,	275 g/L
less exempts solvents & water	
Volatile Hazardous Air Pollutants:	None
(VHAPS), as packaged	Reportable

**Recommended Storage:** Inside, sealed container, 50-95° F. Freeze hazard, protect from freezing.

#### Package Life:

1 year, 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.

**Vinyl:** Due to the diverse nature of vinyl substrates, a coating or coating system must be tested for acceptable adhesion to the substrate prior to use in production.

**All surfaces must be properly cleaned & prepped prior to paint application. For dusty or soiled surfaces we recommend using R19K10001 Vinyl Prep Surface Cleaner as an initial wash and require the R7KL4 Vinyl Prep Conditioner used as the final surface cleaning prior to application of the Kem Aqua 3001.**

**Fiberglass:** Due to diverse nature of fiberglass substrates, coating systems must be tested for acceptable adhesion to the substrate prior to use in production. Adhesion promoters S64 Transparent Adhesion Promoter or Mid-Coat Z777 Adhesion Promoter can be tested and used if required to gain acceptable adhesion.

Reground and recycled plastics, along with various fire retardants, flowing agents, mold release agents, and foaming/blowing agents will affect coating adhesion. Please consult your Sherwin-Williams Sales Representative for system recommendations.

**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**

**Reduction:** If needed, reduce with deionized water up to 5% maximum (by volume). To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction.

**May be applied by:** Conventional  
Airless  
Air Assisted Airless  
HVLP

### **Conventional Spray:**

Air Pressure 20-60 psi  
Fluid Pressure 5-20 psi  
Tip 0.797/FF - Part Size Dependent

### **Airless Spray:**

Fluid Pressure > 1,000 psi  
Tip Part Size Dependent

### **Air Assisted Airless Spray:**

Air Assist Pressure 10-20 psi  
Fluid Pressure 100-500 psi  
Tip Part Size Dependent

### **HVLP Spray:**

Air Pressure 40-65 psi  
Fluid Pressure 6-10 psi  
Tip 0.047-0.070 in.

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

**Cleanup:** Clean tools/equipment immediately after use with a 1:1 mix of water and R6K25 (2-butoxyethanol). Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using any solvent.

## **ADDITIONAL INFORMATION**

1. 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.
2. Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility on all vinyl, fiberglass, wood or any composite substrates prior to full scale application.
3. Tank, piping and containers should be lined steel or plastic.
4. Do not use blending clear bases (M64V601 and M64V603) as a standalone clear or over white base coats or pastels.
5. Good air movement and humidity control are necessary for proper drying of water reducible coatings.
6. Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.
7. Protect from freezing. It is recommended that indoor storage in the temperature range of 50° F - 95° F be instituted to maximize product shelf life.

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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](http://www.PaintDocs.Com).

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

### **Note:**

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Sherwin-Williams warrants the product to be free of manufacturing defect in accordance with Sherwin-Williams' quality control procedures. Except for the preceding sentence, due to factors that are outside of Sherwin-Williams' control, including substrate selection, and customer handling, preparation, and application, Sherwin-Williams cannot make any other warranties related to the product or the performance of the product. **SHERWIN-WILLIAMS DISCLAIMS ALL WARRANTIES OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.**

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Building Products Laboratory  
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