## Fast Dry Acrylic Enamel

**Gloss:**
- Black: F78B21
- Silver: F78S32
- White: F78W28
- Blending: F78W100
- Clear: F78T104
- Machinery Red: F78R27
- Brite Red: F78R30
- Safety Yellow: F78Y29
- Custom Blend: F78XX Series
- Catalyst (Optional): V66V29

**Characteristics**

<table>
<thead>
<tr>
<th>Characteristic</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gloss</td>
<td>85+ units</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>32-37% ± 2% varies by color</td>
</tr>
<tr>
<td>Viscosity</td>
<td>40-60 seconds #2 Zahn Cup</td>
</tr>
<tr>
<td></td>
<td>30-40 seconds #4 Ford Cup</td>
</tr>
<tr>
<td>Recommended film thickness:</td>
<td></td>
</tr>
<tr>
<td>Mils Wet</td>
<td>3.0 - 4.5</td>
</tr>
<tr>
<td>Mils Dry</td>
<td>1.0 - 1.5</td>
</tr>
<tr>
<td>Spreading Rate</td>
<td>340-595 sq ft/gal @ 1.0-1.5 mils DFT</td>
</tr>
<tr>
<td>Drying (1.0 mils dft, 77°F, 50% RH):</td>
<td></td>
</tr>
<tr>
<td>To Touch</td>
<td>5-10 minutes</td>
</tr>
<tr>
<td>To Handle</td>
<td>10-15 minutes</td>
</tr>
<tr>
<td>Tack Free</td>
<td>30-45 minutes</td>
</tr>
<tr>
<td>To Recoat</td>
<td>before 6 hours or after 36 hours</td>
</tr>
<tr>
<td>Force Dry</td>
<td>10-20 minutes at 140-180°F</td>
</tr>
<tr>
<td>Critical recoat</td>
<td>do not recoat after 6 hours or 36 hours</td>
</tr>
<tr>
<td></td>
<td>at room temperature.</td>
</tr>
<tr>
<td>Air Quality Data</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Photochemically reactive</td>
</tr>
<tr>
<td></td>
<td>Volatile Organic Compounds (VOC)*</td>
</tr>
<tr>
<td></td>
<td>theoretical as packaged, maximum, less exempt solvents:</td>
</tr>
<tr>
<td></td>
<td>4.95 lb/gal, 593 g/L</td>
</tr>
<tr>
<td></td>
<td>Reduced 25% with Xylene, R2K4: 5.40 lb/gal, 647 g/L</td>
</tr>
</tbody>
</table>

**Specifications**

**General:** Substrate should be free of grease, oil, dirt, fingerprints, drying compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties. Consult Metal Preparation Brochure CC-T1 for additional details.

**Aluminum:** If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2. Over "pre-treated" aluminum, check adhesion before use as the proprietary pre-treatment may change from supplier to supplier which may have an effect on the final adhesion.

**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, prime with Kem-Flash® 500 Primer (E61A750 series) or Kem-Flash® 500 Low HAPS Primer (E61A712). For optimal gloss holdout use Kem® 400 Primer (E61A400).

**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 per-

**Air Quality Data:**
- Photochemically reactive
- Volatile Organic Compounds (VOC)* theoretical as packaged, maximum, less exempt solvents:
  - 4.95 lb/gal, 593 g/L
  - Reduced 25% with Xylene, R2K4: 5.40 lb/gal, 647 g/L

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

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

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## Description

**Fast Dry Acrylic Enamel** is a high gloss, durable acrylic enamel. Its fast air drying properties make it ideal for coating various metal products.

**Advantages:**
- Very fast air dry
- Good gloss and color retention
- Good one coat protection
- High gloss
- May be catalyzed with Polane® Catalyst V66V29 for increased hardness and improved resistance properties
- Application by conventional, airless, air assisted airless, and electrostatic spray
- Available in a broad range of colors

**Fast Dry Acrylic Urethane:**
For increased chemical and abrasion resistance, improved hardness and color and gloss retention, Fast Dry Acrylic Enamel may be catalyzed at an 8:1 ratio with Polane® Exterior Catalyst V66V29 prior to reduction. Drying times are slower than for uncatalyzed Fast Dry Acrylic. Working potlife after catalyzation is 6-8 hours at room temperature.

Not Stocked - Special Order Only:
- Equipment Green: F78G25
### APPLICATION

**Typical Setups**

**Conventional Spray:**
- **Air Pressure**: 50-60 psi
- **Fluid Pressure**: 10-15 psi
- **Tip**: .055-.070
- **Reducer**: Xylene R2K4

For warm temperatures and large surface areas, use a 1:1 blend of Xylene and Aromatic Naphtha-100 Flash (or mix ratios as needed)

**Reduction Rate**: as needed up to 25%

Follow manufacturer's safety recommendations when using any solvent.

**Air Pressure**
- Max at cap
- **Fluid Pressure**: 8-10 psi
- **Tip**: .011-.015

**Electrostatic Spray:**
- **Air Pressure**: 45-55 psi
- **Fluid Pressure**: 10-15 psi
- **Tip**: .011-.015

**Airless Spray:**
- **Air Pressure**: 50-60 psi
- **Fluid Pressure**: 10-15 psi

**Cleanup:**
- Clean tools/equipment immediately after use with Xylene R2K4. For HAPS compliant cleanup, use n-butyl acetate, R6K18.

Follow manufacturer's safety recommendations when using any solvent.

### ADDITIONAL INFORMATION

- Critical recoat - do not recoat after 6 hours or before 36 hours air drying at room temperature. (Force drying, film thickness, and varying humidity conditions may change critical recoat time).
- Recoating should be tested on small areas under actual application conditions.
- Fast Drying Acrylic Enamels apply best at temperatures above 65°F
- For maximum gloss holdout use Kem® 400 Primer. Primers such as Kem-Flash Prime give poorer gloss holdout and may be lifted by the strong solvents in the acrylic enamel.
- When applied to properly cleaned, untreated cold rolled steel, optimum adhesion is obtained after 4-7 days air drying. Heavier films (greater man 1.5 mils) require longer drying to obtain best adhesion. Over iron phosphate pretreatment or recommended primes, topcoat adhesion develops much faster.
- Force dry schedules may affect color of whites because of the heat.
- For optimum gloss and enamel holdout:
  - **A.** Allow at least 2 hours drying of the primer.
  - **B.** Apply 1.5 - 1.8 mils dry film of topcoat. Lesser film thickness will give lower gloss.

**Performance Tests:**
- **Substrate**: 1.5 mils DFT on CRS Q-Panel
- **Salt Spray Test**
  - ASTM B117 (110-120 hours)
  - No face rust and 1/8" creepage maximum

**Humidity**
- ASTM D2247 (100°F and 100% relative humidity)
  - Pass 250 hours

**Pencil Hardness**
- ASTM 3363
  - 3B

**Impact Resistance**
- **Direct**: 20 lbs
- **Reverse**: 5 lbs

**Flexibility (Conical Mandrell)**
- Pass 1/8 inch

### 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.

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