**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 Flatting 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

**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 |
  - Mils Dry | 1.0-1.2 primed |
  - Mils Dry | 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.

*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.

CC-C1 02/2023 continued on back
**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.


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.*

---

**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:

All purchases of products from Sherwin-Williams are exclusively subject to Sherwin-Williams' [Standard Terms And Conditions Of Sale](http://www.PaintDocs.Com). Please review these terms and conditions prior to the purchase of the products.

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.

Liability for products proven to be defectively manufactured will be limited solely to replacement of the defective product or the refund of the purchase price paid for the defective product, as determined by Sherwin-Williams. Under no circumstances shall Sherwin-Williams be liable for indirect, special, incidental or consequential damages, lost profits or punitive damages arising from any cause whatsoever.

---

All trademarks are the property of their respective owners.