**DESCRIPTION**

OPEX® Production Lacquer is a nitrocellulose alkyd lacquer for industrial product finishing.

**Advantages:**
- Fast air drying
- Interior and exterior use on metal
- Non-photochemically reactive
- 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)
- White bases may be tinted with 844 colorants up to 4 oz./gallon.

**CHARACTERISTICS**

- **Gloss:**
  - Full
  - Semi-gloss White: 40-45 units
- **Volume Solids:**
  - 25 ± 2% except T82C100, L61W100, and L61S18, varies by color
- **Viscosity:**
  - 20-25 seconds #2 Zahn Cup at 100% reduction with R7K120
- **Recommended film thickness at 100% reduction 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
    - 11.0 - 16.0 unprimed
    - Mils Dry: 1.0 - 1.2 primed
    - 1.4 - 2.0 unprimed
- **Spreading Rate:**
  - (no application loss) 100-250 sq ft/gal @ 0.8-2.0 mils DFT
- **Drying (1.0 mils dft, 77°F, 45% RH):**
  - Tack Free: 5-10 minutes
  - To Topcoat: no critical recoat time
  - To Pack: 2-4 hours
  - Force Dry: 10-15 minutes at 180°F
- **Flash Point:**
  - 21-40°F, PMCC
- **Package Life:**
  - L61S18, T82C100, L61W100 2 years, unopened
  - All others 3 years, unopened
- **Air Quality Data:**
  - Photochemically reactive
  - Volatile Organic Compounds (VOC) theoretical as packaged, maximum, less exempt solvents:
    - 6.19 lb/gal, 742 g/L
    - reduced 100% with R7K120, maximum 6.39 lb/gal, 767 g/L

**SPECIFICATIONS**

**General:** Substrate should be free of grease, oil, dirt, fingerprints, drawing 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:** 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.

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

**Typical Setups**

With high humidity, it may be necessary to use Lacquer Thinner, R7K27 to reduce or eliminate blushing.

**Conventional Spray:**
Reduser: R7K120
Reduction Rate: 50-100%

**Warm Spray:**
Reduser: R7K22
Reduction Rate: 50-75%

**Dip:**
Reduser: 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.

**Cleanup:**
Clean tools/equipment immediately after use with Lacquer Thinner R7K120.

Follow manufacturer's safety recommendations when using any solvent.

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**ADDITIONAL INFORMATION**

- This nitrocellulose quality will show yellowing upon aging, especially in whites. Topcoating with clear wood finish lacquers may cause unacceptable yellowing over time.
- 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.
- Saturated colors provide better color retention than very light tints on exterior exposure.
- After force drying, cool articles to prevent sticking.
- High humidity may cause blushing with lacquers, use Retarder Thinner to reduce blushing.
- Do not use on exterior wood products.
- 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.
- Does not meet KCMA performance specifications.
- Yellow, L61Y36, has limited exterior durability
- Custom colors and custom gloss ranges available. Please consult your local Sherwin-Williams facility or representative.

**Performance Tests**

**Hardness:**
With one hour drying, this will withstand one psi with no marring or film transfer.

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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.

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

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