

# Product Finishes



**SHERWIN  
WILLIAMS.**

CC-A23

## KEM AQUA<sup>®</sup> 65P Water Reducible SprayFil

Off White .....D61H565  
Black .....D61B505  
Custom Blend.....D61WX Series

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p><b>KEM AQUA<sup>®</sup> 65P Water Reducible SprayFil</b> is a one component acrylic latex filler developed to fill and hide profile and surface imperfections on structural foam plastics and metal for the business machine and electronic cabinetry market. It may also be applied to wood for interior applications.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• Reduce and clean up with water*</li> <li>• Easy filling and sanding</li> <li>• VOC** as packaged &lt;1.0 lb/gal, 120 g/L less water and exempt solvents</li> <li>• Excellent adhesion to a wide range of structural foam and injection molded plastics</li> <li>• Eliminates wicking of plastics</li> <li>• Fast air dry</li> <li>• Single component, no catalyzation</li> <li>• No critical recoat time</li> <li>• Compatible with a wide range of top-coats, including: Kem Aqua<sup>®</sup> 600T W/R Enamel Polane<sup>®</sup> 700T W/R Enamel Polane<sup>®</sup> T Polane<sup>®</sup> T Plus Polane<sup>®</sup> 2.8T Plus Polane<sup>®</sup> HS Plus</li> <li>• May be tinted to pastel colors using up to 6 oz/gal of Kem Aqua<sup>®</sup> colorants</li> </ul> <p>*To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction.</p> <p>**VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.</p>	<p><b>Gloss:</b> Flat <b>Volume Solids:</b> 51 ± 2% <b>Viscosity:</b> 80-100 Krebs Units <b>Recommended film thickness:</b> Mils Wet 4.0 - 5.0 Mils Dry 2.0 - 2.5 <b>Spreading Rate</b> (no application loss) 315-425 sq ft/gal @ 2.0-2.5 mils DFT <b>Drying</b> (2.0 mils dft, 77°F, 50% RH): To Touch: 10-15 minutes To Handle: 20-25 minutes To Sand: 30-40 minutes To Recoat: 30-40 minutes Force Dry: 30 minutes at 140°F <b>Flash Point:</b> none, Pensky-Martens Closed Cup <b>Package Life:</b> 1 year, unopened <b>pH:</b> 7.7 - 8.3</p> <p><b>Air Quality Data:</b></p> <ul style="list-style-type: none"> <li>• Non-photochemically reactive</li> <li>• Volatile Organic Compounds (VOC) Theoretical as packaged, less water and exempt solvents &lt;1.0 lb/gal, 120 g/L</li> <li>• Volatile Hazardous Air Pollutants (VHAPS) as packaged, no reportable VHAPS</li> </ul> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility or at <a href="http://www.paintdocs.com">www.paintdocs.com</a>.</p>	<p><b>General:</b> 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.</p> <p><b>Steel or Iron:</b> Remove rust, mill scale, and oxidation products. Treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection. Should not be applied to bare steel.</p> <p><b>Aluminum:</b> Prime with Kem Aqua<sup>®</sup> Wash Primer, E61G522.</p> <p><b>Galvanized Steel:</b> Prime with Kem Aqua<sup>®</sup> Wash Primer, E61G522.</p> <p><b>Plastic:</b> Due to the diverse nature of plastic 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. Please consult your Sherwin-Williams Sales Representative for system recommendations.</p> <p><b>Wood</b> (interior only): Must be clean, dry, and finish sanded.</p> <p><b>Testing:</b> 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.</p>

## APPLICATION

### Typical Setups

**Reduction:** To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction. Do not over reduce. Water reducible primers must be applied at higher viscosities than solvent based primers. They apply and atomize easier at higher viscosities.

### **Conventional Spray:**

Air Pressure ..... 45-55 PSI  
Tip ..... .055-.070  
Reduction ..... as needed up to 5%

### **Airless Spray:**

Pressure ..... 2000-2400 PSI  
Tip ..... .011-.013  
Reduction ..... as needed up to 10%

### **Air Assisted Airless:**

Atomizing Air ..... 15-30 PSI  
Fluid Pressure ..... 850-950 PSI  
Tip ..... .011-.013  
Reduction ..... as needed up to 10%

### **HVLP:**

Air Pressure max at the cap .... 10 PSI  
Fluid Pressure ..... 6-9 PSI  
Tip ..... .055-.070  
Reduction ..... as needed up to 10%

### **Cleanup:**

Clean equipment and lines immediately with water. If dried, clean with a blend of water and ammonia as soon as possible. Clean spray gun cap with MEK.

Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using any solvent.

## ADDITIONAL INFORMATION

- Protect from freezing. Inside storage between 40°F and 95°F only. Freezing will cause a dramatic increase in viscosity.
- High humidity will slow drying.
- Spray wet film for good film integrity.
- Customer must test on specific surface for performance because a wide variety of plastic and wood compositions exist in the marketplace.
- Do not exceed 4.0 mils total dry film to avoid mudcracking and improper drying.
- Use low to moderate atomizing pressures to minimize bubbling and air entrapment.
- Do not shake or agitate violently because of tendencies to foaming and air entrapment.
- Keep container closed to prevent skinning of this fast drying coating.
- Do not use viscosity cups to measure viscosity, product should be applied at as heavy a viscosity as practical.
- Not intended for use on machine tool castings.
- Gloss topcoats will show decreased gloss when applied over this product, sand for best gloss holdout.
- Does not provide significant corrosion resistance to systems, not recommended where salt spray resistance is needed, use Polane® W<sub>2</sub> Primer on metal when improved salt spray and corrosion resistance is required.
- On MDF, the surface profile of the substrate may telegraph through this product to the topcoat.
- Interior use only. Do not expose systems involving Kem Aqua® 65P to exterior environments.

## 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](http://www.paintdocs.com).

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

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