General Industrial Coatings

CC-A23

Kem Aqua® 65P Water Reducible SprayFil

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

DESCRIPTION

KEM AQUA® 65P Water Reducible SprayFil 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.

Advantages:

- Reduce and clean up with water#
- Easy filling and sanding
- VOC* (as packaged) <1.0 lb/gal, 120 g/L less water and exempt solvents
- Excellent adhesion to a wide range of structural foam and injection molded plastics
- Eliminates wicking of plastics
- Fast air dry
- Single component, no catalyzation
- No critical recoat time
- Compatible with a wide range of topcoats, including:
  - Kem Aqua 600T W/R Enamel
  - Polane® 700T W/R Enamel
  - Polane 2.8T Plus
  - Polane HS Plus
  - Polane T
  - Polane T Plus
- May be tinted to pastel colors using up to 6 oz/gal of Kem Aqua colorants

#To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction.

* 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.

CHARACTERISTICS

Gloss: Flat

Volume Solids: 51 ± 2 %

Viscosity (at 77° F)**:** 80-100 Krebs Units

Recommended Film Thickness:

Mils Wet	4.0-5.0
Mils Dry	2.0-2.5

Spreading Rate (no application loss)**:** 315-425 ft.^{2}/gal. at 2.0-2.5 mils DFT

Cure:

Air Dry or Force Dry	30 mins. at 140° F

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

Drying: 2.0 mils at 77° F, 50% RH

To Touch	10-15 minutes
Tack Free	?? hours
To Handle	20-25 minutes
To Sand	30-40 minutes
To Recoat	30-40 minutes

Flash Point: 499° F
Pensky Martens Closed Cup

pH: 7.7-8.3

Air Quality Data:
Non-Photochemically Reactive
Volatile Organic Compounds (VOC),
Less Exempts, Maximum < 1.0 lb/gal, < 120 g/L
Volatile Hazardous Air Pollutants (VHAPS)
No reportable VHAPS

Recommended Storage: Inside, sealed container, 40-95° F, freeze hazard. Protect from moisture.

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.

Aluminum: Prime with Kem Aqua Wash Primer, E61G522.

Galvanized Steel: Prime with Kem Aqua Wash Primer, E61G522.

Iron or Steel: 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. Kem Aqua 65P should not be applied to bare steel.

Plastic: 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.

Wood (interior only)**:** Must be clean, dry, and finish sanded.

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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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 more easily at higher viscosities.

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

Conventional Spray:

Air Pressure	45-55 psi
Tip	0.055-0.070 in.
Reduction	As needed up to 5% (vol.)

Airless Spray:

Fluid Pressure	2,000-2,400 psi
Tip	0.011-0.013 in.
Reduction	As needed up to 10% (vol.)

Air Assisted Airless Spray:

Atomizing Air	15-30 psi
Fluid Pressure	850-950 psi
Tip	0.011-0.013 in.
Reduction	As needed up to 10% (vol.)

HVLP Spray:

Air Pressure	Max 10 psi at cap
Fluid Pressure	6-9 psi
Tip	0.055-0.070 in.
Reduction	As needed up to 10% (vol.)

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

Cleanup: Clean tools/equipment immediately after use water. If dried, clean with a blend of water and ammonia as soon as possible. Clean spray gun cap with MEK.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. Protect from freezing. Inside storage between 40° F and 95° F only. Freezing will cause a dramatic increase in viscosity.
2. High humidity will slow drying.
3. Spray wet film for good film integrity.
4. Customer must test on their specific substrate for performance because a wide variety of plastic and wood compositions exist in the marketplace.
5. Do not exceed 4.0 mils total dry film to avoid mud cracking and improper drying.
6. Use low to moderate atomizing pressures to minimize bubbling and air entrapment.
7. Do not shake or agitate violently; this may cause foaming and air entrapment.
8. Keep container closed to prevent skinning of this fast drying coating.
9. Do not use viscosity cups to measure viscosity Kem Aqua 65P should be applied at as high a viscosity as practical.
10. Not intended for use on machine tool castings.
11. Gloss topcoats will show decreased gloss when applied over this Kem Aqua 65P. Sand for best gloss holdout.
12. Kem Aqua 65P does not provide significant corrosion resistance to systems. It is not recommended where salt spray resistance is needed. Use Polane® W_2 Primer on metal when improved salt spray and corrosion resistance is required.
13. On MDF, the surface profile of the substrate may telegraph through this product to the topcoat.
14. For interior use only. Do not expose systems involving Kem Aqua 65P to exterior environments.
15. Compatible with Kem Aqua Colorants.

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.

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

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