**Product Finishes**

**KEM-FLASH® 500 Low HAPS Primer**

**DESCRIPTION**

KEM-FLASH® 500 Low HAPS Primer is a high quality, fast air drying, alkyd primer with very low HAPS content and VOC of less than 3.5 lbs/gal. It satisfies the performance specification requirements of the off road equipment and general metal markets.

**Advantages:**
- Less than 3.5 lbs/gal VOC* as packaged
- Low HAPS, less than 0.02 lbs/gal of solids
- Excellent corrosion resistance
- Fast drying. Can be topcoated after 30 minutes.
- High solids, 54% volume solids means more build with less passes.
- May be applied by airless or conventional spray without reduction or heat.
- Ideal primer for farm and construction equipment, machinery, railroad cars, structural steel, and fabricated metal parts requiring excellent durability and rust protection.
- Can be reduced with exempt solvents, such as acetone to improve application.
- Compatible with a wide range of topcoats, including:
  - Kem Fast Dry H.S.
  - Kem Lustral® Enamel
  - Opex® Production Lacquers
  - Fast Production Enamel
  - Quick Dry Enamel
  - Quick Dry 350
  - High Solids Acrylic Enamel
  - Kem Acryl™ HS 100 Enamel

**CHARACTERISTICS**

<table>
<thead>
<tr>
<th>Characteristic</th>
<th>Value</th>
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<tbody>
<tr>
<td>Gloss</td>
<td>Flat - 5-15 units</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>54 ± 2%</td>
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<tr>
<td>Viscosity</td>
<td>14-32 secs., #3 Zahn Cup</td>
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<tr>
<td></td>
<td>40-70 secs., #4 Ford Cup</td>
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<tr>
<td>Recommended Film Thickness:</td>
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<tr>
<td>Mils Wet</td>
<td>2.8 - 3.5</td>
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<tr>
<td>Mils Dry</td>
<td>1.5 - 1.8</td>
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<tr>
<td>Spreading Rate (no application loss):</td>
<td></td>
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<tr>
<td></td>
<td>465-600 sq ft/gal @ 1.5 - 1.8 mils DFT</td>
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<tr>
<td>Drying (1.5 mil DFT, 77°F, 50% RH):</td>
<td></td>
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<tr>
<td>To Touch:</td>
<td>15-30 minutes</td>
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<tr>
<td>Tack Free:</td>
<td>30-90 minutes</td>
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<tr>
<td>To Recoat:</td>
<td>30 minutes</td>
</tr>
<tr>
<td>Force Dry:</td>
<td>10-30 minutes at 140° to 180°F</td>
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<tr>
<td>Flash Point:</td>
<td>50°F Pensky-Martens Closed Cup</td>
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<tr>
<td>Package Life:</td>
<td>24 months, unopened</td>
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**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:** If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.
- **Galvanized Steel:** If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.
- **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.

**Air Quality Data:**
- Photochemically reactive
- Volatile Organic Compounds (VOC) Theoretical as packaged, maximum, less exempt solvents: 3.26 lbs/gal, 391 g/L
- Volatile Hazardous Air Pollutants (VHAPS) as packaged, less than 0.02 lbs/gal of solids

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

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

- For good corrosion resistance, a minimum of 1.5 mils dry film is required.
- Apply as a full wet coat, as dry spray gives poor enamel holdout and rough appearance.
- Do not topcoat with polyurethane enamels, catalyzed epoxies, high PVC flat wall paints, or latex coatings.
- On sand blasted surfaces, apply sufficient film thickness to protect the blast profile. This is typically 1 mil more than the blast profile. Multiple coats may be required.
- Because of its fast drying, this product is not recommended for brush application.
- Users should test for critical recoat and system adhesion when topcoating with products containing high strength solvents.
- Coating thickness will increase rapidly during application because of its higher solids. Heavy films will dry slower.

### 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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**CC-A31**  
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