**DESCRIPTION**

**KEM LUSTRAL® Enamel** is an air dry enamel with excellent film characteristics for interior and exterior use. Its ease of application makes it ideal for product finishing and maintenance use.

**Advantages:**
- May be applied with a wide variety of application equipment and methods.
- Good color and gloss retention on exterior exposure.
- Custom color capability by tinting with up to 8 oz/gal Chroma Chem 844 colorants or up to 4 oz/gal of Blend-A-Color Toner.
- Full gloss range available by using Gloss Modifying Agent, D64F100.
- USDA acceptance on many colors. Contact your Sherwin-Williams Representative for listing.
- Ideal for plant maintenance and color coding as safety colors.

**CHARACTERISTICS**

<table>
<thead>
<tr>
<th>Characteristic</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gloss</td>
<td>High gloss, except F65B50</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>38 ± 2%</td>
</tr>
<tr>
<td>Viscosity</td>
<td>50-60 seconds #4 Zahn Cup</td>
</tr>
<tr>
<td>Spreading Rate</td>
<td>374-548 sq ft/gal @ 1.2-1.5 mils DFT</td>
</tr>
<tr>
<td>Drying (1.2 mils dft, 77°F, 50% RH):</td>
<td></td>
</tr>
<tr>
<td>To Touch</td>
<td>1½ hours</td>
</tr>
<tr>
<td>To Handle</td>
<td>3-4 hours</td>
</tr>
<tr>
<td>Tack Free</td>
<td>5-6 hours</td>
</tr>
<tr>
<td>To Recoat</td>
<td>spray after 8 hours brush after 16 hours</td>
</tr>
<tr>
<td>Force Dry</td>
<td>60-90 minutes at 140-160°F (see product limitations)</td>
</tr>
<tr>
<td>Flash Point</td>
<td>102°F - 105°F Pensky-Martens Closed Cup</td>
</tr>
<tr>
<td>Package Life</td>
<td>3 years, unopened</td>
</tr>
</tbody>
</table>

**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 or Kem Aqua® Wash Primer, E61G522. Over "pre-treated" aluminum, check adhesion before use as the proprietary pre-treatment may change from supplier to supplier which may have an effect on the final adhesion.

**Galvanized Steel:** If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2 or 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. For exterior use, prime with Kem Flash® Prime, E61A45 series.

**Wood:** Must be clean, dry, and finish sanded. For exterior use, prime with A-100 Exterior Oil Stain Blocking Primer, Y24W20.

**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.
### APPLICATION

**Typical Setups**

**Brush or Roller:**
Full body, no reduction.

**Conventional Spray:**
Reducer .................. VM&P Naphtha, R1K3
Reduction Rate ............. up to 25%

**Airless Spray:**
Pressure ..................... 2000 psi
Tip ............................. .013" - .017"
Reducer .................. VM&P Naphtha, R1K3
Reduction Rate ............. up to 5%

**Electrostatic Spray:**
Reducer for polarity ......... MEK, R6K10
Reduction Rate ............. 18-22", Zahn #2

**Dip:**
(short drain and small dip tanks)
Reducer .................. VM&P Naphtha, R1K3
Reduction Rate ............. up to 20%
(longer flow and large dip tanks)
Reducer .................. Mineral Spirits, R1K4
Reduction Rate ............. up to 20%

Excessive agitation or turbulence on part immersion or withdrawal may cause foaming.

**Cleanup:**
Clean tools/equipment immediately after use with Mineral Spirits R1K4. Follow manufacturer's safety recommendations when using any solvent.

### ADDITIONAL INFORMATION

- Reds, Oranges, and Yellows contain bleeding pigments. Caution should be exercised when recoating with products containing aromatic, ester, or ketone solvents. Using these colors for intermixing may result in:
  - A. Color walk-out or premature fading on exposure.
  - B. Bronzing (blooming on exposure to light or heat, or if cured by force drying temperatures over 190 °F).

- Reds, Oranges, and Yellows should not be force dried at temperatures above 190 °F.

- All exterior recommendations for galvanized surfaces should be tested and approved by the customer.

- Do not use Blend-A-Color Yellow for exterior applications.

### 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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