DESCRIPTION

Kem Aqua® 8300 Baking Enamel, is a waterborne alkyd-amino baking enamel designed for general metal finishing. It provides a hard, tough coating, complying with 2.8 lb/gal VOC*.

Advantages:
- Excellent flow and leveling
- Excellent flexibility and toughness
- Reduces with water, means considerable cost savings in solvent
- Water can be used for cleanup of equipment
- Low Odor
- Versatile - may be applied by conventional, HVLP, air assisted airless and electrostatic spray, dip and dip-spin methods
- *Complies with 2.8 lbs./gal. VOC.

CHARACTERISTICS (vary by color)

60° Gloss:
- Low Gloss 5-15
- Medium Gloss 25-35
- High Gloss 85+

Volume Solids: 30-35

Viscosity (at 77° F, Stormer): 85-95 KU

Recommended Film Thickness:
- Mils Wet 3.0-4.0
- Mils Dry 1.0-1.5
  Do not apply over 1.25 mils DFT per coat because of the potential for solvent popping during the bake cycle.

Spreading Rate (no application loss): 500-550 ft²/gal. at 1.0 mil DFT

Cure:
- Bake 20 mins. flash, 15 mins. at 325°F
- Good air movement helps water evaporate during flash off.

Recoat Window: Paint is recoatable with itself after baking, provided the first coat is not over baked.

Flash Point (Seta Flash Closed Cup):
- F83B490 N.A.
- All Others 110-130°F
  Refer to product EDS for individual colors

Air Quality Data:
- Non-Photochemically Reactive
- Volatile Organic Compounds (VOC), Less Exempts (maximum) ≤ 2.80 lb/gal, ≤ 340 g/L

Recommended Storage: Inside, sealed container, 35-95°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: A proprietary chrome phosphate metal treatment is required. Apply an Alodine treatment on aluminum.

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.

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

Water reducible enamels must be applied at higher viscosities than solvent based enamels. They do apply and atomize easily at higher viscosities.

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

Conventional Spray:
- Air Pressure 30-60 psi
- Fluid Pressure 4-10 psi
- Reduction Water
- As needed, up to 10% (vol.)
- Reduce to 30-40 secs., #3 Zahn cup
- Do not over reduce

Air Assisted Airless Spray:
- Air Assist Pressure 30 psi
- Fluid Pressure 600-2,200 psi
- Tip 0.011 in.
- Reduction None

Electrostatic Spray:
- Equipment must be isolated
- Reduction Water
- As needed, up to 3-15% (vol.)
- Reduce to 30-35 secs., #3 Zahn cup
- Do not over reduce

For Turbo Bells
(Ransburg RPM 5062-PC)
- Fluid Pressure 8 psi
- Fluid Tip 3/32"
- Turbine Air 10-21 psi
- Bell RPM 15,000-30,000
- Voltage 90 KV
- Delivery Rate 160 cm³/min

HVLP Spray:
- Air Pressure 30 psi
- Fluid Pressure 4-8 psi
- Cap/Tip 97P/92
- Reduction Water
- As needed, 3-15% (vol.)
- Reduce to 30-35 secs., #3 Zahn cup
- Do not over reduce

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

Cleanup: Clean tools/equipment immediately after use with water when paint is wet. When dry, use R6K25 (2-butoxy ethanol) or MIBK.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. Do not spray at temperatures below 50°F.
2. Store in plastic or lined metal containers because the paint contains water.
3. Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.
4. Do not apply over 1.25 mils dry film thickness per coat because of potential solvent popping during the bake cycle.
5. To ensure adequate cure, minimum bake is 10 mins. at 325°F or 20 minutes at 300°F. Longer time and/or higher temperature may be needed depending on the mass of ware coated.
6. Water reducible coatings may cause corrosion in the presence of steel. Tanks, containers, piping and application equipment should be lined, stainless steel, or plastic.
7. Product will not easily texture. Use Kem Aqua 1700T for texture bake finish.
8. When shading colors adjust the viscosity at the end of shading.
9. Do not add more than 12 ounces of Kem Aqua colorant per gallon of base.

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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Follow manufacturer's safety recommendations when using any solvent.

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