KEM KROMIK®
UNIVERSAL METAL PRIMER

B50NZ0006 BROWN
B50WZ0001 OFF WHITE
B50AZ0006 GRAY

CHARACTERISTICS

KEM KROMIK UNIVERSAL METAL PRIMER is a rust inhibiting, modified phenolic alkyd resin primer designed for use over iron and steel substrates. Can be used as a universal primer under high performance topcoats. Suitable as a barrier coat over conventional coatings which would normally be attacked by strong solvents in high performance coatings.

Features:
- High film build to protect sand blasted steel
- Corrosion resistant
- Universal, can be topcoated with epoxies and urethanes
- Exterior/interior metal primer
- Suitable for use in USDA inspected facilities

For use on properly prepared:
- Steel

Recommended for use in:
- Shopcoat primer
- Maintenance primer
- Structural steel
- Machinery
- Marine vessels

Tinting: DO NOT TINT
Shelf Life: 36 months, unopened
Finish: Flat

SPECIFICATIONS

Color: White, Brown & Gray

Recommended Spread Rate per coat: White B50WZ0001 (varies by base)

wet mils: 6.0 – 8.0
dry mils: 3.3 - 4.4
coverage: 267 - 200 sq ft/gal approximate
Theoretical coverage: 882 sq ft/gal @ 1 mil dry

Drying Schedule @ 6.0 mils wet, 50% RH:
@ 40°F/4.5°C @ 77°F/25°C @ 110°F/43°C
To touch: 2 hours 30 minutes  15 minutes
Tack handle: 2.5 hours 1 hours  45 minutes
To recoat: with itself & alkyds  2.5 hours 1 hours  45 minutes
To recoat:*  36 hours 16 hours  16 hours
To cure: 7 days 7 days     7 days

* Recoat with hot solvents or high performance coatings. For maximum adhesion, acrylic topcoats require 48 - 72 hours drying of primer. Drying and recoat times are temperature, humidity, and film thickness dependent.

White B50WZ0001

VOC(except exempt solvents) 389 g/L - 3.24 lb/gal
(as per 40 CFR 59.406 and SOR/2009-264, s. 12)
Volume Solids: 55 ± 2%
Weight Solids: 75 ± 2%
Weight per Gallon: 12.86 lb/gal ± .2 lb
Flash Point: 80°F PMCC

Brown B50NZ0006

VOC(except exempt solvents) 409 g/L - 3.24 lb/gal
(as per 40 CFR 59.406 and SOR/2009-264, s. 12)
Volume Solids: 53 ± 2%
Weight Solids: 73 ± 2%
Weight per Gallon: 12.62 lb/gal ± .2 lb
Flash Point: 80°F PMCC

SYSTEMS

The systems listed above are representative of the product’s use, other systems may be appropriate. Other topcoats may be appropriate.

Steel:
1ct. Kem Kromik Universal Primer

Acceptable Topcoats:
Acrolon 218 HS Polyurethane
Hi-Solids Polyurethane
Industrial Enamel
Macropoxy HS Epoxy
Metalatex Semi-Gloss Enamel
Pro Industrial Acrylic
Pro Industrial DTM Acrylic
Pro Industrial Waterbased Epoxy

System: (unless otherwise indicated)
Substrate: Steel
Surface Preparation: SSPC-SP6/NACE 3
Primer: 1ct. Kem Kromik Universal Metal Primer, @ 3.0 – 4.4 mils dft/ct.

Adhesion:
Method: ASTM D3359
Result: 4B

Corrosion Resistance:
Method: ASTM D5894, 1008
Result: Pass

Dry Heat Resistance:
Method: ASTM D2485
Result: 200°F

Flexibility:
Method: ASTM D522, 1/4" mandrel
Result: Pass

Fineness of grind:
Method: Hegman
Result: 4B Hegman minimum

Sag Test:
Method: ASTM D4400
Result: 12 mils minimum

Viscosity:
Result: 84-94 KU

Water Resistance:
Result: Pass

* 1ct. Kem Kromik Primer 4.5-5 WFT 2 Standard test based on Certificate of Analysis

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SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority.

Iron & Steel - Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Prime any bare steel within 8 hours or before flash rusting occurs.

Previously Painted Surfaces - If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system. Other substrates may or may not be appropriate. If a specific substrate is not listed above, consult your Sherwin-Williams representative for more information.

As a “Barrier” Coat - If it is necessary to topcoat a previously painted surface with chemically resistant or strong solvent topcoats, Kem Kromik Universal Metal Primer can be used as a barrier coat to help reduce lifting. Apply a coat of Kem Kromik Universal Metal Primer to a small area to test for adhesion or bleeding. If there is evidence of either poor adhesion or bleeding, clean surface to bare steel and apply recommended system.

APPLICATION PROCEDURES

Apply paint at the recommended film thickness and spreading rate as indicated on front page. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness, or porosity of the surface, skill, and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, over thinning, climatic conditions, and excessive film build.

SAFETY PRECAUTIONS

Refer to the SDS sheet before use. FOR PROFESSIONAL USE ONLY
Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

PERFORMANCE TIPS

Mix paint thoroughly to a uniform consistency with slow speed power agitation prior to use. Stripe coat crevices, welds, and sharp angles to prevent early failure in these areas. When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle. Not recommended for immersion service or exposure to acids, alkalis, or strong solvents. Intimate contact with the steel surface and primer is necessary for adequate rust inhibition and adhesion.

For maximum adhesion, acrylic topcoats require 48 - 72 hours drying of primer.

APPLICATION

Refer to the SDS sheet before use

Temperature: 40°F (4.5°C) minimum
120°F (49°C) maximum
(Air, surface, and material)
Relative humidity: 85% maximum

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.

Reducer: Not recommended
Clean Up: Xylene, R2K4

Airless Spray
Pressure: 1800-3000 psi
Hose: 1/4" ID
Tip: 0.015-.019"
Filter: 60 mesh

Conventional Spray
Gun: Binks 95
Fluid Nozzle: 63C
Air Nozzle: 63PB
Atomization Pressure: 15-20 PSI
Fluid Pressure: 50 PSI

CLeanUp INFORMATION

Clean spills, spatters & tools with compliant cleanup solvent. After cleaning, flush spray equipment with compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using solvents.

DANGER: Rags, steel wool, other waste soaked with this product, and sanding residue may spontaneously catch fire if improperly discarded. Immediately place rags, steel wool, other waste soaked with this product, and sanding residue in a sealed, water-filled, metal container. Dispose of in accordance with local fire regulations.

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative or visit www.paintdocs.com to obtain the most current version of the PDS and/or an SDS.