INDUSTRIAL ENAMEL HS

B54WZ0401 PURE WHITE
B54WZ0413 DEEP BASE
B54TZ0404 ULTRADEEP BASE
B54BZ0411 BLACK
B54EZ0439 SAFETY ORANGE
B54RZ0438 SAFETY RED
B54YZ0437 SAFETY YELLOW

SPECIFICATIONS

Color: Pure White, Deep Base, Ultradeep Base, Black, Safety Red/Orange & Yellow
Recommended Spread Rate per coat: Pure White B54WZ0401 (varies by base)
wet mils: 3.5 – 7.0
dry mils: 2.0 - 4.1
coverage: 473 - 230 sq ft/gal approximate
Theoretical coverage: 946 sq ft/gal @ 1 mil dry
Drying Schedule @ 4.0 mils wet, 50% RH:
To touch: @ 45°F/7°C @ 77°F/25°C @ 120°F/49°C
6 hours  4 hours  2 hours
To Handle: 14 hours   10 hours  6 hours
To recoat: 24 hours   16 hours  12 hours
To cure: 14 days      7 days  4 days
Drying and recoat times are temperature, humidity, and film thickness dependent.

RECOMMENDED SYSTEMS

Steel & Rusted Galvanized, acrylic primer:
1ct. Pro Industrial Pro-Cryl Primer
2cts. Industrial Enamel HS
Steel alkyd primer:
1ct. Kem Bond HS
Or
1ct. Kem Kromik Universal Metal Primer
2cts. Industrial Enamel HS
Aluminum/Galvanized waterbased primer:
1ct. DTM Wash Primer
Or
1ct. Galvite HS
2cts. Industrial Enamel HS
Concrete Block:
1ct. Pro Industrial Heavy Duty Block Filler
2cts. Industrial Enamel HS
Steel, Rusted, & Galvanized:
1ct. Pro Industrial Pro-Cryl Primer
2cts. Industrial Enamel HS
Steel alkyd primer:
1ct. Kem Bond HS
Or
1ct. Kem Kromik Universal Metal Primer
2cts. Industrial Enamel HS
Concrete Block:
1ct. Pro Industrial Heavy Duty Block Filler
2cts. Industrial Enamel HS

System: (unless otherwise indicated)
Substrate: Steel
Surface Preparation: SSPC-SP2
Finish: Industrial Enamel, B54WZ0401 @ 2.0 mils dry/ct.

Drywall Interior:
1ct. ProMar 200 Zero VOC Primer
2cts. Industrial Enamel HS
Plaster & Poured Concrete Walls, Interior:
1ct. Loxon Concrete and Masonry Primer
2cts. Industrial Enamel HS
Wood, Exterior:
1ct. Exterior Oil-Based Wood Primer
2cts. Industrial Enamel HS
Wood, Interior:
1ct. Premium Wall & Wood Primer
2cts. Industrial Enamel HS
Wood, floors:
2cts. Industrial Enamel HS

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

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Substrate: Steel
Surface Preparation: SSPC-SP2
Finish: Industrial Enamel, B54WZ0401 @ 2.0 mils dry/ct.

Dry Heat Resistance:
Method: ASTM D2485
Result: 200°F (discolors)
Flexibility:
Method: ASTM D522, method B
Result: Pass
Fineness of grind1:
Method: Hegman
Result: 6 Hegman minimum

1 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.

Aluminum - Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Primer required.

Galvanized Steel - Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. When the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP16 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned. Primer required.

Concrete Block - Surface should be thoroughly clean and dry. Air, material and surface temperatures must be at least 50°F (10°C) before filling. Use Pro Industrial Heavy Duty Block Filler or Loxon Block Surfacer. The filler must be thoroughly dry before topcoating.

Masonry - All masonry must be free of dirt, oil, grease, loose paint, mortar, masonry dust, etc. Clean per SSPC-SP13/Nace 6/ICRI No. 310.2R, CSP 1-3. Poursed, troweled, or tilt-up concrete, plaster, mortar, etc. must be thoroughly cured at least 30 days at 75°F(23.9°C). Form release compounds and environmental and application conditions. The 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.

Application

Refer to the SDS sheet before use

Temperature: 40°F(4.5°C) minimum
120°F(49°C) maximum

(Air, surface, and material)

At least 5°F above dew point

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/Clean Up ............... Xylene, R2K4

AIRLESS SPRAY

Pressure .............................................. 1800 psi

Hose .............................................. 3/8" ID

Tip .............................................. .017-.019"

Filter .............................................. 1/4-3/8" lambswool or synthetic cover

Reduction ....................... As needed up to 3% by volume

BRUSH

Brush .............................................. Natural Bristle

Roll .............................................. 1/4-3/8" lambswool or synthetic cover

Reduction ....................... not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with compliant solvent.

CLEANUP INFORMATION

Clean spills, splatters & 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.

APPLICATION PROCEDURES

Mix paint thoroughly to a uniform consistency with slow speed power agitation prior to use.

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.

Deep tinted colors may exhibit burnishing characteristics.

Do not use colorants formulated for interior use only when applying exterior.

SAFETY PRECAUTIONS

Refer to the SDS sheets 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.

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