INDUSTRIAL ENAMEL
B54W00101 PURE WHITE
B54W00113 DEEP BASE
B54T00104 ULTRADEEP BASE
B54B00011 BLACK
B54E00039 SAFETY ORANGE
B54R00038 SAFETY RED
B54Y00037 SAFETY YELLOW

SPECIFICATIONS

Color: Pure White, Deep Base, Ultradeep Base, Black, Safety Red/Orange & Yellow
Recommended Spread Rate per coat: Pure White B54W00101 (varies by base)
wet mils: 4.5 –9.0
dry mils: 1.9 - 3.9
coverage: 360- 175 sq ft/gal approximate
Theoretical coverage: 689 sq ft/gal @ 1 mil dry
Drying Schedule @ 4.6 mils wet, 50% RH:
To touch: 3 hours @ 50°F/10°C 1-3 hours @ 77°F/25°C 30 minutes @ 110°F/43°C
Tack free: 8 hours 4-6 hours 4 hours
To recoat: 12 hours 8 hours 3 hours
To cure: 7 days 7 days 3 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
Steel alkyd primer: 1ct. Kem Bond HS
Or 1ct. Kem Kromik Universal Metal Primer
Aluminum/Galvanized waterbased primer: 1ct. DTM Wash Primer
Concrete Block: 1ct. Pro Industrial Heavy Duty Block Filler
Plaster & Poured Concrete Walls, Interior: 1ct. Loxon Concrete and Masonry Primer
Wood, Exterior: 1ct. Exterior Oil-Based Wood Primer
Wood, Interior: 1ct. Premium Wall & Wood Primer
Wood, floors: 2cts. Industrial Enamel

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

Abrasion Resistance1:
Method: ASTM D4060,CS17 wheel 500 cycles 1 kg load
Results: 58 mg loss

Dry Heat Resistance:
Method: ASTM D2485
Result: 200°F (discolors)

Flexibility:
Method: ASTM D522, 180° bend, 3/16” mandrel
Result: Pass

Fineness of grind2:
Method: Hegman
Result: 6 Hegman minimum

System: (unless otherwise indicated)
Substrate: Steel
Surface Preparation: SSPC-SP6/NACE 3
Finish: 1ct. Kem Kromik Universal Metal Primer @ 3.0 –4.0 mils dft/ct.
1ct. Industrial Enamel, B54W00101 @ 3.0 mils dft/ct.

*unless otherwise noted below

1 1ct. Industrial Enamel, B54W00101 2.8 mils  2 Standard test based on Certificate of Analysis
INDUSTRIAL ENAMEL

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 Clean 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 Luxon Block Surfac er. The filler must be thoroughly dry before topcoating. Primer required.

Wood - Surface must be clean, dry and sound. Prime with recommended primer. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped, sanded and spot primed before full coat of primer is applied. All nail holes or small openings must be properly caulked.

Previously Painted Surfaces - If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dull 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.

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 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. 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.

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 ......................... Not recommended
Clean Up ...................... Compliant Mineral Spirits

Airless Spray
Pressure................................. 2500 psi
Hose ..................................... 1/4" ID
Tip ........................................... .015"
Filter ..................................... 100 mesh

Conventional Spray
Gun ......................................... Binks 95
Fluid Nozzle .............................. .66
Air Nozzle ......................... .63FB
Atomization Pressure .................. 50 PSI
Fluid Pressure ...................... 20-25 PSI

Brush ................................. Natural Bristle
Roll .................................. 3/8" woven with solvent resistant core

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.

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.