**SPECIFICATIONS**

**Color:** Extra White, Clear Tint Base, Black, Safety Red & Safety Yellow

**Recommended Spread Rate per coat:** Extra White B55W00311 (varies by base)

- **wet mils:** 4.0 - 5.0
- **dry mils:** 2.1 - 2.7

**coverage:** 412 - 320 sq ft/gal approximate

**Theoretical coverage:** 866 sq ft/gal @ 1 mil dry

**Drying Schedule @ 4.0 mils wet, 50% RH:**

- **To touch:**
  - @ 50°F/10°C: 25 minutes
  - @ 77°F/25°C: 20 minutes
  - @ 120°F/49°C: 10 minutes

- **Tack Free:**
  - @ 50°F/10°C: 90 minutes
  - @ 77°F/25°C: 60 minutes
  - @ 120°F/49°C: 30 minutes

- **Block resistance:**
  - @ 50°F/10°C: 24 hours
  - @ 77°F/25°C: 6 hours
  - @ 120°F/49°C: 3 hours

- **To recoat:**
  - @ 50°F/10°C: <4 or >24 hours
  - @ 77°F/25°C: <2 or >24 hours
  - @ 120°F/49°C: <2 or >24 hours

- **To cure:**
  - @ 50°F/10°C: 7 days
  - @ 77°F/25°C: 7 days
  - @ 120°F/49°C: 5 days

* Critical: A critical recoat time may occur between 2 hrs and 24 hrs when the temperature is above 50°F (10°C). (Force drying, film thickness and varying humidity conditions may change critical recoat time). Recoating should be tested on small areas under actual application conditions.

**Drying and recoat times are temperature, humidity, and film thickness dependent.**

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**KEM® 4000**

**ACRYLIC ALKYD ENAMEL**

B55W00311 EXTRA WHITE  
B55T00304 CLEAR TINT BASE  
B55B00300 BLACK  
B55R00300 SAFETY RED  
B55Y00300 SAFETY YELLOW  
V70V00411 ACRYLIC MODIFIER  
V66V01020 EXTERIOR CATALYST

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**CHARACTERISTICS**

KEM 4000 is a higher solids, gloss, general purpose acrylic alkyd enamel coating intended for industrial applications. It is ideal for interior or exterior applications, the refinishing of industrial, construction, and agricultural equipment, as well as a wide range of general metal applications.

**Features:**

- Interior/Exterior applications
- Fast return to service
- Formulated for fast drying and curing
- Excellent block resistance
- Fast handling times
- Suitable for use in USDA inspected facilities

For use on properly prepared:

- Steel
- Galvanized
- Aluminum

**Recommended for use in:**

- Interior/Exterior applications
- Equipment
- Machinery
- Bar joists
- Steel deck
- Piping
- Steel doors
- Farm equipment

Tinting with Maxitoner:

**Base** oz/gal **Strength**

- Extra White 0 - 4 100%
- Clear Tint Base 10 - 12 100%

Check color before using. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

**Shelf Life:** 24 months, unopened

**Finish:** 80°+@60° Gloss

**RECOMMENDED SYSTEMS**

Steel, Light Service:

- 1ct. Kem 4000 Enamel
- 2cts. Kem 4000 Enamel

Steel, Moderate Service:

- 1ct. Kem Bond HS
- 1ct. Kem Kromik Universal Metal Primer
- 1-2cts. Kem 4000 Enamel

Steel Alkyd Primer:

- 1ct. Kem Bond HS
- Or
- 1ct. Kem Kromik Universal Metal Primer
- 1-2cts. Kem 4000 Enamel

Steel Acrylic Primer:

- 1ct. Pro Industrial Pro-Cryl Universal Primer
- 1-2cts. Kem 4000 Enamel

Aluminum & Galvanize Steel Acrylic Primer:

- 1ct. Pro Industrial Pro-Cryl Universal Primer
- 1ct. Kem 4000 Enamel

Aluminum:

- 1ct. DTM Wash Primer
- 1ct. Kem 4000 Enamel

Galvanized Metal:

- 1ct. Galvite HS
- 1ct. Kem 4000 Enamel

**As of 07/25/2017. Complies with:***

- OTC No. LEED® 09 NC, CI No.
- OTC Phase II No. LEED® 09 CS
- SCAQMD No. LEED® 09 S
- CARB No. LEED® v4 FAB 4b, FAB 4c
- CARB-SCM 2007 No. LEED® v4 VOC
- Canada No. MPI

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**FINISH:**

- **Steel:** 80°+@60° Gloss

**Volume Solids:** 54 ± 2%

**Weight Solids:** 68 ± 2%

**Weight per Gallon:** 10.07 lb/gal ± .2 lb

**Flash Point:** 97°F PMCC

**As of 07/25/2017, Complies with:**

- OTC No. LEED® 09 NC, CI No.
- OTC Phase II No. LEED® 09 CS
- SCAQMD No. LEED® 09 S
- CARB No. LEED® v4 FAB 4b, FAB 4c
- CARB-SCM 2007 No. LEED® v4 VOC
- Canada No. MPI

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**STORAGE AND HANDLING:**

- Keep container closed when not in use.
- Store in a safe place out of reach of children.
- Keep away from heat, open flame, and sources of ignition.
- Do not store at temperatures above 120°F (49°C).

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**ADHESION:**

**Method:** ASTM D4541

**Result:** >1000 psi

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**SALT FOG RESISTANCE:**

**Method:** ASTM B117, 500 hours

**Result:** Rating 10 per ASTM D610 for rusting (field); Rating 8D per ASTM D714 for blistering

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**SAG TEST:**

**Method:** ASTM D4400

**Result:** 10 mils minimum

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**FINISHNESS OF GRIND:**

**Method:** Hegman

**Result:** 6 Hegman minimum

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**VISCOITY:**

**Method:** ASTM D4400

**Result:** 80-90 KU
KEM® 4000 ACRYLIC ALKYD 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). Coat any bare steel within 8 hours or before flash rusting occurs.

Aluminum (Untreated) - Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Primer with DTM Wash Primer (B71Y00001)

Galvanized Steel (Untreated) - Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Allow to weather a minimum of six months prior to coating. When weathering is not possible or the surface has been treated with chromate 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.

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.

APPLICATION PROCEDURES

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.

APPLICATION

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.

SAFETY PRECAUTIONS

Refer to the SDS sheet before use. FOR PROFESSIONAL USE ONLY

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FINISHING TIPS

Application of coating at minimum or below 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.

APPLICATION

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SAFETY PRECAUTIONS

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FINISHING 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. Do not use colorants formulated for interior use only when applying exterior. Excessive reduction of material can affect film build, appearance, and adhesion. For improved exterior color and gloss retention, faster drying, sharper gloss, and improved block resistance in stacking, 10% by volume of Acrylic Modifier V70V411 may be added to Kem 4000. For increased chemical and abrasion resistance, and better color and gloss retention, catalyze at an 8:1 ratio with Exterior Catalyst V66V1020, prior to reduction. Pot Life will be 8 hours maximum. During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. If possible, plan painting schedules to avoid these influences during the first 16-24 hours of curing. Force dry schedules may affect the color of whites because of heat. Blocking or sticking may occur when flat surfaces are stacked before adequate cure.

*Critical: A critical recoat time may occur between 2 hrs and 24 hrs when the temperature is above 50°F (10°C). Force drying, film thickness and varying humidity conditions may change critical recoat time. Recoating should be tested on small areas under actual application conditions.

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.