DIRECT-TO-METAL ALKYD ENAMEL
SEMI-GLOSS

B55W00101 PURE WHITE
B55W00113 DEEP BASE
B55T00104 ULTRADEEP BASE

SPECIFICATIONS

Color: Pure White, Deep Base and Ultradeep Base
Recommended Spread Rate per coat: Pure White B55W00101 (varies by base)
- wet mils: 7.0 – 13.0
- dry mils: 3.0 - 5.6
- coverage: 230- 125 sq ft/gal approximate

Theoretical coverage: 689 sq ft/gal @ 1 mil dry
Drying Schedule @ 7.0 mils wet, 50% RH:
- To touch: 1-3 hours @ 77°F / 1 hour @ 120°F
- To handle: 4-6 hours @ 77°F / 1.5 hours @ 120°F
- To recoat: 18 hours @ 77°F / 18 hours @ 120°F

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

RECOMMENDED SYSTEMS

Steel, Light Service:
1ct. Direct-To-Metal Enamel 3.0-5.0 mils DFT

Steel, Moderate Service:
2cts. Direct-To-Metal Enamel 3.0-5.0 mils DFT

Steel Alkyd Primer:
1ct. Kem Bond HS
1ct. Direct-To-Metal Enamel 3.0-5.0 mils DFT

Steel Acrylic Primer:
1ct. Pro Industrial Pro-Cryl Universal Primer
1ct. Direct-To-Metal Enamel 3.0-5.0 mils DFT

Aluminum & Galvanize Steel Acrylic Primer:
1ct. Pro Industrial Pro-Cryl Universal Primer
1ct. Direct-To-Metal Enamel 3.0-5.0 mils DFT

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

Accelerated Weathering:
- Method: ASTM D4587,504 hours
- Results: Passes

Biological Growth:
- Method: ASTM D3273, 4 weeks
- Results: Passes

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

Flexibility:
- Method: ASTM D522, method B
  - 180° bend, 1/8” mandrel
  - Result: Pass

Fineness of grind:
- Method: Hegman
- Result: 6 Hegman minimum

Sag Test:
- Method: ASTM D4400
- Result: 16 mils minimum

Viscosity:
- Method: ASTM D870 77°F (25°C)
- Result: Pass

As of 07/25/2017, Complies with:
- OTC No LEED® NC, CI No
- OTC Phase II No LEED® CS No
- SCAQMD No LEED® S No
- CARB No LEED® v4 Emissions No
- CARB SCM 2007 No MPI Yes

Characteristics:
DIRECT-TO-METAL ALKYD ENAMEL is a high-build alkyd coating with rust-inhibitive properties for application directly to bare steel.

Features:
- Good gloss and color retention
- Corrosion resistance and finish coat protection in one product
- Excellent application properties
- Suitable for use in USDA inspected facilities

For use on properly prepared:
- Structural Steel
- Previously painted
- Primed aluminum & galvanized steel

Recommended for use in:
- Interior / exterior
- New construction
- Railings
- Machinery
- Structural steel
- Steel doors
- Steel decking
- Steel, Light Service:
  - 1ct. Direct-To-Metal Enamel 3.0-5.0 mils DFT
- Steel, Moderate Service:
  - 2cts. Direct-To-Metal Enamel 3.0-5.0 mils DFT
- Steel Alkyd Primer:
  - 1ct. Kem Bond HS
  - 1ct. Direct-To-Metal Enamel 3.0-5.0 mils DFT

Tinting with BAC:
- Base oz/gal Strength
  - Pure White 0-5 SherColor
  - Deep Base 4-11 SherColor
  - Ultradeep Base 10-11 SherColor

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

Shelf Life:
- 50-60° @60° Semi-Gloss

Accelerated Weathering:
- Method: ASTM D4587,504 hours
- Results: Passes

Biological Growth:
- Method: ASTM D3273, 4 weeks
- Results: Passes

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

Flexibility:
- Method: ASTM D522, method B
  - 180° bend, 1/8” mandrel
  - Result: Pass

1 1ct. Direct-to-Metal Enamel, B55W00101 tin & aluminum panel, 2.5 mils
2 Standard test based on Certificate of Analysis
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. Test 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.

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.

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. 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. During the early stages of drying, the coating is sensitive to rain, dew, high humidity and moisture condensation. Plan painting schedules to avoid these influences during the first 16-24 hours of curing. Do not use colorants formulated for interior use only.

APPLICATION

Refer to the SDS sheet before use
Temperature: 40°F minimum
120°F maximum
(Air, surface, and material)
40°F minimum
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 solvent
Airless Spray
Pressure ......................... 2400 psi
Hose ............................. 3/8” ID
Tip ............................... .019”

Conventional Spray
Gun .............................. Binks 95
Fluid Nozzle ..................... 63B
Air Nozzle ...................... 63PB
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, 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.

HOTW 07/25/2017 B55W00101 42 441
HOTW 07/25/2017 B55W00113 20 445
HOTW 07/25/2017 B55T00104 36 441

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.