General Industrial Coatings

CC-B33

SHER-KEM® Fast Dry Metal Finishing Enamel

Jet Black.....F75B203
Ultra Deep Base F75C201
Extra White.....F75W200
Safety Yellow.....F75Y204

DESCRIPTION

SHER-KEM® Fast Dry Metal Finishing Enamel is an air dry enamel with premium performance providing faster drying and direct to metal, one coat protection. Excellent spray application properties provide an ultra smooth appearance. Key market applications are general metal and metal container. Specific customer types include job shops, metal fabricators, metal refurbishment, waste disposal equipment, fencing, and miscellaneous metal parts.

Advantages:

- Faster air dry for fast handling
- Ideal for small parts needing fast air dry times
- Full color range available using BAC colorants, and Maxitoners
- Very good exterior durability provides long lasting color and gloss
- Tough one coat protection
- Easy to apply by reducing 15-20%
- Addition of chromatic bases provides maximum coverage per gallon
- Quick dust-free times provide an ultra smooth finish

Not stocked - Special order only:
Machinery Red.....F75R205

* VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.PaintDocs.Com.

CHARACTERISTICS

(may vary by color)

60° Gloss: 80+

Volume Solids: 29-37 ± 2 %

Weight Solids: 38-57 ± 2 %

Viscosity (at 77° F)**:**
F75W200 25-40 secs., #3 Zahn Cup
All Others 20-35 secs., #3 Zahn Cup

Recommended Film Thickness:
Mils Wet 3.0-5.0
Mils Dry 0.9-1.2

Spreading Rate (no application loss)**:**
490-660 ft.^{2}/gal. at 0.9-1.2 mils DFT

Cure:
Air Dry or
Force Dry 20 mins. at 140° F

Drying: 0.9-1.2 mils at 77° F, 50% RH
To Touch 15-30 minutes
Tack Free 15-120 minutes
To Handle 1-2 hours
Open Time < 5 minutes
To Recoat Before 2 hours or after 18 hours
To Pack 24 hours

Critical recoat period may fluctuate depending on drying conditions, reducer and film thickness. Test small area first.

Flash Point: 40-45° F
Pensky Martens Closed Cup

Air Quality Data:
Photochemically Reactive
Volatile Organic Compounds (VOC), Less Exempts
(admixed, maximum) 4.8 lb/gal, 575 g/L

Recommended Storage: Inside, sealed container, 40-120° F, no freeze hazard. Protect from moisture.

Package Life:
F75B203 2 years, unopened
All Others 3 years, unopened

SPECIFICATIONS

General: All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

Aluminum: If untreated, prime with Industrial Wash Primer, P60G2, or Kem Aqua® Wash Primer, E61G522.

Galvanized Steel: Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

Iron or Steel: Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

Wood (interior only): Must be clean, dry, and finish sanded. Substrate should be free of grease, oil, dirt, fingerprints, and any contamination to ensure optimum adhesion and coating performance properties. Moisture content of wood should be 6-8%.

Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

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APPLICATION

Typical Setups

May be applied by: Conventional Spray
Airless Spray
Electrostatic Spray
HVLP Spray

Conventional Spray:

Air Pressure	45-60 psi
Fluid Pressure	20-25 psi
Reducer:	R2K5 (Aromatic Naphtha) R6K9 (Acetone) R2K4 (Xylene)
Reduction Rate:	As needed, up to 20% (vol.)

Airless Spray:

Pressure	2,100-3,000 psi
Tip	0.011-0.017 in.
Reducer:	R2K5 (Aromatic Naphtha) R2K4 (Xylene)

For better flow & levelling, reduce with R2KT4 (Hi Flash Naphtha 150) as needed up to 15% (vol.).

Electrostatic Spray:

Reduce with R6K24 (Diacetone Alcohol) for polarity. Reduction 10-20% (vol.). For better flow and leveling, reduce with R2KT4 (Hi Flash Naphtha 150) as needed up to 20% by volume.

HVLP Spray:

Gun	DeVilbiss DXL 520P
Atomizing Air Pressure	8-10 psi
Fluid Pressure	10-20 psi
Cap/Tip	2000/55
Reducer:	R2K5 (Aromatic Naphtha)
Reduction Rate	10-20% (vol.)

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

Cleanup: Clean tools/equipment immediately after use with R2K5 (100 Flash Naphtha), R2K4 (Xylene) or R6K9 (Acetone). Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using any solvent.

Performance Tests

Substrate:	Cold rolled steel panels
Salt Spray Test ASTM B117	Pass 150-200 hours
Humidity ASTM D2247, 100° F, 100% RH	Pass 120 hours
Impact Resistance, Direct ASTM D2794	Pass 20 in lb
Pencil Hardness ASTM D3363	2B*

*Pencil Hardness may vary depending on dry film thickness, substrate and tester.

Florida exposure Passes 60-75% gloss retention
9 months, 45° South

ADDITIONAL INFORMATION

1. A critical recoat will occur between 2 and 18 hours.
2. Blocking or sticking may occur when flat surfaces are stacked before adequate cure. Allow at least 24 hours before stacking.
3. Not recommended for use on extra-large parts due to the short open time of the wet film.
4. Apply at least 1.0 mil DFT on direct to metal applications for good film integrity and good corrosion resistance.
5. For improved corrosion resistance and to maintain high distinctness of image, use Kem® 400 Primer (E61A400 series).
6. For better corrosion resistance, prime with Kem-Flash® Prime (E61A45 series). There will be a loss of distinctness of image when using Kem-Flash Prime.
7. Drying time is dependent on film thickness, reducer and atmospheric conditions.
8. Heavier film thickness will slow drying.
9. Not recommended for dip coating applications.
10. The use of the V66V1020 hardener will not improve dry time or packaging time. However, it may enhance exterior exposure properties. Add V66V1020 at an 8:1 ratio. The use of other hardeners and catalysts is not recommended.
11. Over application of SHER-KEM Fast Dry can cause significantly slower dry times and other potential film integrity issues.
12. Compatible with the following colorants:
    a. Blend-A-Color (BAC)
    b. Color Express
    c. GIS
    d. Maxitoner
    e. Opticolor Express

BAC	8 oz/gal in:	F75C201 & F75W200
	2 oz/gal in	F75B203
Color Express	8 oz/gal in	F75C201
GIS	8 oz/gal in	all bases
Maxitoner	8 oz/gal in:	F75C201 & F75W200
	2 oz/gal in	F75B203
Opticolor Express	8 oz/gal in:	F75C201 & F75W200

13. The Ultra Deep Base must be tinted for use as a final product. It is not designed to be used as a clear coat.
14. Blending of the chromatic bases is also used to create custom colors.
15. Use of BAC colorants will slow down tack free times.
16. No loss of dry time is observed when Maxitoner colorants are used.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review the product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.PaintDocs.Com.

Please direct any questions or comments to your local Sherwin-Williams facility.

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