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WILLIAMS.**

# Product Finishes

CC-B32

**SHER-KEM<sup>®</sup>**

## High Gloss Metal Finishing Enamel

Raven Black .....F75BC14  
 Ultra Deep Base .....F75CC2  
 International Red .....F75RC7  
 Equipment Yellow .....F75YC19

Extra White Base .....F75WC7  
 Implement Orange .....F75EC9  
 Enviro Green .....F75GC19  
 Semi-Gloss Black .....F75BC17

Deep Base .....F75WC8  
 Equipment Blue .....F75LC14  
 Implement Yellow .....F75YC18  
 Low Gloss Ultra Deep Base.F75TC1

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p><b>SHER-KEM<sup>®</sup> High Gloss Metal Finishing Enamel</b> is a direct-to-metal coating designed to give a factory applied finish and provide the brilliant color and performance required by the large agricultural, construction equipment and trailer manufacturers. It can also be used in the general metal finishing market when a premium, long lasting finish is needed.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• 8 package colors provide quick hiding and color clarity needed to achieve OEM finishes</li> <li>• Excellent, long lasting color and gloss retention, adding value to the life of finished products</li> <li>• Superior distinctness of image reflecting deep color clarity and mirror-like finish</li> <li>• Full range of more than 60 pre-formulated custom colors available</li> <li>• One coat direct-to-metal protection</li> <li>• Excellent chemical resistance including engine coolant, oil, diesel fuel and unleaded gasoline</li> <li>• Easy to apply by simply reducing with a variety of readily available industrial solvents</li> <li>• Ideal for coating large components due to longer open time allowing for rewetting</li> <li>• For improved hardness, better overnight hardness use V66V1020 Hardener at an 8:1 ratio. Eliminates recoat window</li> <li>• Covers quickly due to increased volume solids</li> <li>• Easy to apply with many types of spray equipment</li> </ul> <p>*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 <a href="http://www.paintdocs.com">www.paintdocs.com</a>.</p>	<p><b>Gloss:</b></p> <p>Semi-Gloss Black 45-55 units (60°)            Low Gloss Clear 15-20 units (60°)            All Others 90+ units (60°)            80+ units (20°)</p> <p><b>Volume Solids:</b> 36-39 ± 2%            may vary by color</p> <p><b>Viscosity:</b>            20-60 seconds #5 Zahn Cup</p> <p><b>Recommended film thickness:</b></p> <p>Mils Wet 3.0 - 4.0            Mils Dry 1.0 - 1.2</p> <p><b>Spreading Rate</b> (no application loss)            480-625 sq. ft./gal @ 1.0-1.2 mils dft</p> <p><b>Drying</b> (1.0-1.2 mils dft, 77°F, 50% RH):</p> <p>To Touch: 20-40 minutes            Tack Free: 2-3 hours            To Handle 6-8 hours            Through Dry Time 19-21 hours            To Recoat apply second coat before 2 hours or after 21 hours</p> <p>Force Dry: 20-30 minutes at 140-180°F</p> <p>Critical recoat period may fluctuate depending on drying conditions and film thickness. Test a small area first.</p> <p><b>Catalyzed Product Dry Time:</b></p> <p>To Touch 30-40 minutes            Tack Free 2-4 hours            To Handle 6-8 hours            Through Dry Time 6-11 hours            Potlife: 2 hours maximum at room temperature</p> <p><b>Flash Point:</b> 80°F, Pensky-Martens Closed Cup</p> <p><b>Package Life:</b></p> <p>F75BC17 and F75TC1 18 months, unopened            All others 24 months, unopened</p> <p><b>Air Quality Data:</b></p> <ul style="list-style-type: none"> <li>• Photochemically reactive</li> <li>• Volatile Organic Compounds (VOC)* theoretical as packaged, maximum, less exempt solvents: 4.20 lb/gal, 504 g/L</li> </ul>	<p><b>General:</b> Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties. Consult Metal Preparation Brochure CC-T1 for additional details.</p> <p><b>Aluminum:</b> If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2, or Kem Aqua<sup>®</sup> Wash Primer, E61G522. Over "pre-treated" aluminum, check adhesion before use as the proprietary pre-treatment may change from supplier to supplier which may have an effect on the final adhesion.</p> <p><b>Steel or Iron:</b> Remove rust, mill scale, and oxidation products. <b>For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection. Recommended for all direct to metal applications.</b></p> <p>For improved corrosion protection, priming is recommended. Prime with Kem<sup>®</sup> 400 Primer, E61A400 series for best hold-out or Kem-Flash<sup>®</sup> Primer, E61A45 series</p> <p><b>Testing:</b> 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</p>

## APPLICATION

### Typical Setups

**Reduction:** Reduce with Xylene, R2K4, 10-20% by volume. For more flow and open time, use Aromatic Naphtha 100 Flash, R2K5. **For faster dry time use Acetone, R6K9.**

### Conventional Spray:

Air Pressure.....55 psi  
Reduction .....10-20% by volume

### Airless Spray:

Fluid Pressure ..... 2100-2700 psi  
Tip .....413"  
Reduction ..... 5-10% by Volume

### Air Assisted Airless:

Air Pressure..... 15 psi  
Fluid Pressure .....1500-1800 psi  
Air Cap ..... AA-4  
Fluid Tip.....1308  
Reduction Rate.....5-10% by volume

### HVLP:

Gun.....DeVilbiss EXL  
Pressure at the cap ..... 10 psi max.  
Fluid Pressure ..... 10-25 psi  
Air Cap .....2000  
Fluid Tip..... FF (.055)  
Reduction .....10-20% by volume

### Cleanup:

Clean tools/equipment immediately after use with 100 Flash, R2K5, Xylene, R2K4, or Acetone, R6K9.

Follow manufacturer's safety recommendations when using any solvent.

### Tintable with Following Systems:

-BAC Colorants up to 8 ounces per gallon  
-844 Colorants up to 8 ounces per gallon  
-MaxiToner Colorants up to 8 ounces per gallon

**High Hide White base tint load is up to 2 oz per gallon.**

### Performance Test Results

Product tested on Bonderite® 1000 steel (iron phosphate) panels.  
Salt Spray Test - Corrosion  
ASTM B117 ..... 200-250 hours  
Humidity - Corrosion  
ASTM D2247, 100°F, 100% RH.....Pass  
200 hours  
Conical Mandrel - Flexibility  
ASTM D633..... passes 1/8" mandrel  
Impact Resistance - Direct  
ASTM D2794..... 40 in lb  
Impact Resistance - Reverse  
ASTM D2794..... 4 in lb  
Pencil Hardness without Hardener  
ASTM D3363..... 2B  
Pencil Harness with Hardener  
ASTM D3363.....HB  
Chip Resistance ..... 5A  
1 year 45°S Florida exposure. ....Passes.  
No loss of gloss.

## ADDITIONAL INFORMATION

- Apply at least 1.0 mils DFT on direct to metal applications for good film integrity and good corrosion resistance.
- For improved corrosion resistance and to maintain high distinctness of image use Kem® 400 Primer.
- For better corrosion resistance use Kem-Flash® Prime. There will be a loss of distinctness of image when using Kem-Flash® Prime.
- Initial dry times are slightly slower when BAC colorants are used. No loss of dry time observed when 844 or MaxiToner colorants are used.
- Blocking or sticking may occur when flat surfaces are stacked before adequate drying occurs
- Apply at temperatures above 60°F.
- Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.
- Not recommended for dip application.
- For increased chemical and abrasion resistance, improved hardness and better gloss and color retention SHER-KEM® High Gloss Metal Finishing Enamel may be catalyzed at an 8 to 1 ratio with Hardener, V66V1020, prior to reduction. Dry times are slightly slower. Read label cautions before use.
- Addition of hardener, V66V1020, eliminates the critical recoat window. Hardener contains isocyanates.
- Working pot life of catalyzed product is 2 hours maximum at room temperature.
- Caution should be exercised when recoating with products containing aromatics, esters or ketone solvents as they may result in lifting or dulling of gloss.
- Maximum tint load is 8 ounces per gallon except for the High Hide White, which is 2 ounces per gallon.
- The Ultra Deep Base and Low Gloss Ultra Deep Base must be tinted for use as a final product. They are not designed for use as clear coats.
- **The Deep Base, F75WC8 and Extra White Base, F75WC7, must be tinted for use as a final product. They are not designed for use as package whites**
- To quickly obtain a hard, mar-proof finish, force dry 20 minutes at 140-180°F.
- F75EC9 and F75RC7 contain organic pigments and should not be force dried above 160°F because they tend to bronze above this temperature.

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## CAUTIONS

### FOR INDUSTRIAL SHOP APPLICATION ONLY

**Thoroughly review 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](http://www.paintdocs.com).

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

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