SHERWIN WILLIAMS.

Chemical Coatings

CC-A1

KEM-FLASH® Prime

Gray E61A45
Buff E61H6
Red Oxide E61R26
White E61W12

DESCRIPTION

KEM-FLASH® Prime metal primers are fast drying, versatile alkyd primers uniquely formulated to provide excellent corrosion resistance for a wide range of general metal applications.

Advantages:

- Excellent corrosion resistance achieved by a scientifically balanced blend of corrosion inhibiting pigments
- Fast dry to handle and recoat
- Ideal primer for production line and maintenance use on steel and iron substrates
- Excellent primer for use under a wide range of alkyd type topcoats
- Non-photochemically reactive
- Meets the performance requirements of Structural Steel Painting Council Spec 15-68T Type 1
- Compatible with a wide range of topcoats, including:
  Kem Lustral® Enamel
  Opex® Production Lacquers
  Fast Production Enamel
  Quick Dry Enamel
  Kem® 400 Enamel
- Free of lead hazards as packaged in compliance with Consumer Product Safety Commision's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303.

CHARACTERISTICS

Gloss: Flat, 2-10 units
Volume Solids: 36-38± 2%
varies by color
Viscosity:
35-40 seconds #3 Zahn Cup
Recommended film thickness:
Mils Wet 3.0 - 4.0
Mils Dry 1.0 - 1.25
Spreading Rate (no application loss)
449-626 sq ft/gal @ 1.0 -1.25 mils DFT
Drying (1.25 mils dft, 77°F, 50% RH):
To Touch: 5 minutes
To Handle: 10 minutes
Tack Free: 15-20 minutes
To Recoat: 20 minutes (spray)
Force Dry: 10 minutes at 180°F, (not generally required)
Flash Point: 50°F Pensky Martens Closed Cup
Package Life: 2 years, unopened

Air Quality Data:
Non-photochemically reactive
Volatile Organic Compounds (VOC)
as packaged, maximum
4.07 lb/gal, 488 g/L
reduced 33% with Xylene, maximum
4.85 lb/gal, 582 g/L

An Environmental Data Sheet is available from your local Sherwin-Williams facility.

SPECIFICATIONS

General: 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.
Aluminum: If untreated, prime with Industrial Wash Primer, P60G2, or Kem Aqua® Wash Primer, E61G520.
Galvanized Steel: If untreated, prime with Industrial Wash Primer, P60G2, or Kem Aqua® Wash Primer, E61G520.
Steel or Iron: 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.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.

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APPLICATION

Typical Setups

Reduction: Reduce with Xylol, R2K4. For lower HAPS application use n-butyl acetate (R6K18), MAK (R6K30), VM&P Naptha (R1K3) and/or Mineral Spirits (R1K4). When reducing with VM&P Naptha and/or Mineral Spirits be sure to add under agitation.

Conventional Spray:
Reducer ..... Xylol, R2K4
Reduction Rate ..... 25 - 33%
or to 25 seconds on a #2 Zahn Cup
for wetter spray use High Flash Naphtha, R2K5

Airless Spray:
Tip ..... .013" - .017"
Reducer ..... Xylol, R2K4
Reduction Rate ..... as needed

Electrostatic Spray:
Reducer for polarity ..... MEK, R6K10
Reduction Rate 5%
Reducer for flow ..... Xylol, R2K4
Reduction Rate ..... as needed

Dip: Small objects/short drain only
Reducer ..... Xylol, R2K4
Reduction Rate 20%
or 35 seconds on a #2 Zahn Cup
Excessive agitation or turbulence on part immersion or withdrawal may cause foaming.

Cleanup:
Clean tools/equipment immediately after use with Xylol R2K4. For lower HAPS cleanup use n-butyl acetate, MAK or acetone.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- For good corrosion resistance, Kem Flash® Prime should be applied at 1.25 mils DFT or better.
- Apply as a full wet coat, since dry spray gives poor enamel holdout and film properties.
- Do not topcoat with polyurethane enamels, catalyzed epoxies, high PVC flat wall paints, or latex coatings.
- On sandblasted surfaces, apply sufficient film thickness to fully protect the blast profile. This is typically 3-5 mils wet in several applications.
- Because it is very fast drying, do not apply by brush.
- Users should test for intercoat and system adhesion when topcoating with products containing high strength solvents.
- Reduction with VM&P Naptha or Mineral Spirits may result in skinning if pail is left overnight without agitation.
- May be tinted with 844 colorants up to 4 ounces per gallon.

Performance Tests
Substrate: Cleaned steel panels
Primer: 1.25 mils dft

Salt Spray Test
ASTM B117 ..... 250 hours
1 year 45°S Florida exposure.....Passes with no rusting or blistering

Adhesion (ASTM-3359) 5B

Humidity (ASTM-2247) ..... 350 hours

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION

Thoroughly review product label for safety and cautions prior to using this product.

A Material Safety Data Sheet is available from your local Sherwin-Williams facility. Please direct any questions or comments to your local Sherwin-Williams facility.

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.