



**SHERWIN
WILLIAMS.**

Product Finishes

CC-B26

KEM[®] 400 Enamel

Tinting White F75W420
 Gloss Black F75B401
 High Hide White.....F75W404
 Blending Clear..... F75V405

Tinting ClearF75V421
 Flat Black.....F75B412
 Silver MetallicF75S491

Custom Blend F75KX Series
 Acrylic Modifier V70V411
 KEM 400 Catalyst..... V66V1020

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>KEM[®] 400 Enamel is a general purpose, short oil alkyd, high gloss enamel. It is ideal for interior and exterior application for OEM finishing or refinishing of industrial, construction, and agricultural equipment as well as a wide array of general metal applications.</p> <p>KEM[®] 400 Acrylic Enamel For improved exterior color and gloss retention, faster drying, sharper gloss, and improved block resistance in stacking, a 10% addition of Acrylic Modifier, V70V411, may be added to KEM[®] 400 Enamel.</p> <p>KEM[®] 400 Urethane Enamel For increased chemical and abrasion resistance, improved hardness, sharper gloss, and better gloss and color retention, KEM[®] 400 Enamel may be catalyzed at an 8:1 ratio with KEM[®] 400 Exterior Catalyst, V66V1020, prior to reduction. Drying times are slightly faster. Addition of catalyst eliminates the critical recoat time. Working potlife is 8 hours maximum, at room temperature. Catalyst contains isocyanates, read label cautions on V66V1020 before use.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • High Gloss • Good exterior color and gloss retention • Good one coat protection • Fast air drying • Good flexibility and film toughness • Available in a broad range of colors. • Ideal for large components because of longer open time and wet-in of overspray • Ideal system for horse trailers, farm, garden, and construction equipment and industrial machinery and equipment 	<p>High Gloss: 85+ units (60°) Volume Solids: 27-36 ± 2% may vary by color Viscosity: 50-60 seconds #2 Zahn Cup 40-50 seconds #4 Ford Cup Blending Clear (F75V405) 82-90 KU Tinting Clear (F75V421) 82-90 KU Recommended film thickness: Mils Wet 3.5 - 5.0 Mils Dry 1.0 - 1.5 Spreading Rate (no application loss) 290-580 sq ft/gal @ 1.0-1.5 mil dft: Drying (77°F, 50% RH): To Touch: 15-30 minutes To Handle: 30-60 minutes Tack Free: 2-3 hours To Recoat: before 3 hours and after 48 hours Force Dry: 20 minutes at 140-160°F</p> <p>A critical recoat time may occur between 3 and 48 hours at room temperature. This may fluctuate depending on temperature, film thickness, and drying conditions. Test a small area first.</p> <p>Flash Point: 55-56°F Pensky-Martens Closed Cup Package Life: 2 years, unopened</p> <p>Air Quality Data:</p> <ul style="list-style-type: none"> • Photochemically Reactive • Volatile Organic Compounds (VOC)* theoretical as packaged, maximum less exempt solvents: 5.02 lb/gal, 601 g/L Reduced 15% with Xylene, R2K4: 5.30 lb/gal, 635 g/L <p>*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com.</p>	<p>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.</p> <p>Aluminum: If untreated, prime with Industrial Wash Primer, P60G2, or RoHS Compliant Wash Primer, P60G10. KEM AQUA[®] Wash Primer, E61G522 can also be used. Do not use a wash primer on pretreated aluminum.</p> <p>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.</p> <p>For improved corrosion protection, priming is recommended. Prime with KEM[®] 400 Primer or KEM-Flash[®] Ultra-Bond[™] Primer.</p> <p>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.</p>

APPLICATION

Typical Setups

Reduction: Reduce with Xylene, R2K4 as needed up to 15%. For more flow and open time, use Aromatic Naphtha 100 Flash or Aromatic Naphtha 150 Flash. Use Toluol for faster flash off and in cooler temperature.

May be applied using:

Conventional Spray:
Airless Spray
Air Assisted Airless
HVLP
Dip

Conventional Spray

Air Pressure 45-55 psi
Fluid Pressure 10-15psi
Tip055-.070"

Airless Spray:

Fluid Pressure1800-2400 psi
Tip011-.013"

Air Assisted Airless:

Assist Air 10-20 psi
Fluid Pressure1200-1800 psi
Tip011-.013"

HVLP:

Max Pressure at the Cap10 psi
Fluid Pressure 8-10 psi
Tip055-.070"

Cleanup:

Clean tools/equipment immediately after use with Aromatic Naphtha, Acetone, or Xylene, R2K4. For HAPS compliant cleanup, use n-butyl acetate, R6K18.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

- For improved corrosion resistance, priming is recommended.
- Blocking or sticking may occur when flat surfaces are stacked before adequate cure.
- 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.
- Apply at temperatures above 60°F.
- Apply at least 1.25 mils dry film thickness on direct to metal applications for good film integrity.
- Custom colors are available by blending bases with Phoenix® colorants.
- Gloss adjustments can be made using D64F100 or OK412.
- Maximum Phoenix® colorant tint load is 8 ounces per gallon in the F75W420 and 16 ounces per gallon in the F75V421.

Performance Tests

Substrate - 1.5 mils DFT on CRS Q-Panel. Air dry for 14 days.

Salt Spray (ASTM B117) 150-200 hours
Direct Impact Pass 10 pounds
Pencil Hardness (ASTM D3363) 4B

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.

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

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