



SHERWIN WILLIAMS

General Industrial Coatings

CC-B1

KEM LUSTRAL® Enamel

ASA 49 Gray.....	F65A49	Gloss Black.....	F65B1	Vermillion.....	F65R1
Gloss White.....	F65W1	Wrought Iron Flat Black.....	F65B50	Custom Blend Series.....	F65XX

DESCRIPTION

KEM LUSTRAL® Enamel is an air dry enamel with excellent film characteristics for interior and exterior use. Its ease of application makes it ideal for product finishing and maintenance use.

Advantages:

- May be applied with a wide variety of application equipment and methods.
- Good color and gloss retention on exterior exposure
- Custom color capability by tinting Phoenix® or GIS colorants.
- Full gloss range available by using Gloss Modifying Agent, D64F100
- USDA acceptance on many colors. Contact your Sherwin-Williams Representative for listing
- Ideal for plant maintenance and color coding as safety colors

CHARACTERISTICS

60° Gloss:
 F65B50 < 10
 All Other Bases High Gloss

Volume Solids: 38 ± 2 %
Varies by color

Viscosity (at 77° F): 50-60 secs., #4 Zahn Cup

Recommended Film Thickness:
 Mils Wet 3.5-4.5
 Mils Dry 1.2-1.5

Spreading Rate (no application loss):
374-548 ft.²/gal. at 1.2-1.5 mils DFT

Cure:
 Air Dry or Force Dry 60-90 mins. at 140-160° F
 see product limitations

Drying: 1.2 mils at 77° F, 50% RH
 To Touch 1.5 hours
 Tack Free 3-4 hours
 To Handle 5-6 hours
 To Recoat - Spray after 9 hours
 To Recoat - Brush after 16 hours

Flash Point: 102-105° F
(Pensky Martens Closed Cup)

Air Quality Data:
Non-Photochemically Reactive
 Volatile Organic Compounds (VOC), Less Exempts, Maximum
 As supplied 4.2 lb/gal, 501 g/L
 Reduced 25% with mineral spirits 4.6 lb/gal, 552 g/L

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

Package Life: 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 RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2 or Kem Aqua® Wash Primer, E61G522. Over "pre-treated" aluminum, check adhesion before use as the proprietary pretreatment may change from supplier to supplier which may have an effect on the final adhesion.

For exterior use, prime with Kem-Flash® Prime.

Wood: Must be clean, dry, and finish sanded. For exterior use, prime with A-100 Exterior Oil Stain Blocking Primer, Y24W20.

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.

* 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.

APPLICATION

Typical Setups

May be applied by: Brush, Dip, Roller
Conventional Spray
Airless Spray
Electrostatic Spray

Brush or Roller: Full Body, No Reduction

Conventional Spray:

Reducer R1K3 (VM&P Naphtha)
Reduction Rate up to 25% (vol.)

Airless Spray:

Fluid Pressure 2,000 psi
Tip 0.013-0.017 in.
Reducer R1K3 (VM&P Naphtha)
Reduction Rate up to 5% (vol.)

Electrostatic Spray:

Reducer For Polarity R6K10 (MEK)
Reduction Rate to 18-22 secs., #4 Zahn Cup

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

Cleanup: Clean tools/equipment immediately after use with R1K4 (Mineral Spirits).

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. Reds, Oranges, and Yellows contain bleeding pigments. Caution should be exercised when recoating with products containing aromatic, ester, or ketone solvents. Using these colors for intermixing may result in:
 - A. Color walk-out or premature fading on exposure.
 - B. Bronzing (blooming on exposure to light or heat, or if cured by force drying temperatures over 190° F).
2. Reds, Oranges, and Yellows should not be force dried at temperatures above 190° F.
3. All exterior recommendations for galvanized surfaces should be tested and approved by the customer.
4. Compatible with GIS and Phoenix® colorants.
5. Do not use Blend-A-Color (BAC) Yellow for exterior applications.

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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.

Note:

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