TECHNICAL INFORMATION

F75BT4
KEM® 400 ENAMEL
Semi-gloss BLACK

CHEMICAL COATINGS

PRODUCT DESCRIPTION

Kem® 400 Enamel Flat Black, F75BT4 is a general purpose, low gloss short oil alkyd enamel. It is ideal for interior and exterior applications for OEM finishing or refinishing of industrial construction and agricultural equipment as well as a wide array of general metal applications.

Advantages:
1. 60° gloss 15–20.
2. Good exterior color and gloss retention.
3. Good one coat protection.
4. Fast air-drying.
5. Good flexibility and film toughness.
6. Apply by conventional, airless, air assisted airless or HVLP spray methods.
7. Ideal for large components because of longer open-time and wet in of over spray.
8. Free of lead and chromate.
9. May be adjusted with Acrylic Modifier, V70V411 for improved exterior durability, sharper gloss and faster drying. See Kem® 400 Acrylic Enamel in next column.
10. May be catalyzed with Polane® catalyst V66V1020 for sharper gloss, increased hardness and improved resistance properties. See Kem® 400 Urethane in next column.
11. Ideal system for horse trailers, farm, garden, and construction equipment and industrial machinery and equipment.

CHARACTERISTICS

Gloss: 15-20 at 60°
Volume Solids: 29.5 ± 1.0%
Viscosity: Ford #4 - 40-50 seconds
Zahn #2 - 50-70 seconds
Spreading Rate:
474 ft.^{2}/gal at 1.0 mil dry film, no application loss

Package Life: 2 years
Drying: Air dry @ 77° and 50% RH
To Touch ½ - 1 Hour
To Handle 1 - 2 Hours
Tack Free 2 - 3 Hours

To Recoat Before 3 hrs and after 48 hrs
A critical recoat time may exist between 3 hrs and 48 hrs drying at room temperature. It may fluctuate depending on temperature, drying conditions and film thickness. Test on small area first.

Force Dry: 20 min. @ 140-160° F
Flash Point: 68°F Pensky-Martens Closed cup
Air Quality Data: Photochemically reactive; volatile organic compounds (VOC) as packaged 5.00 lbs/gal. (597 g/liter). VOC when reduced 15% with Xylene - 5.25 lbs/gal (630 g/liter). Free of lead and chromate hazards as packaged.

Kem® 400 Acrylic Enamel: For improved exterior color and gloss retention, faster drying, sharper gloss and improved block resistance in stacking, 10% of acrylic Modifier V70V411 may be added to Kem® 400 Enamel. **Kem® 400 Urethane:** For increased chemical and abrasion resistance, improved hardness plus sharper gloss and better color and gloss retention, Kem® 400 Enamel may be catalyzed at an 8:1 ratio with Polane® Exterior Catalyst V66V1020 prior to reduction. Drying times are slightly faster.

Product Limitations:
1. Priming is recommended for improved corrosion resistance.
2. Refer to critical recoat under Drying above.
3. Blocking or sticking may occur when flat surfaces are stacked before adequate cure.
4. Apply at temperature above 60°F.
5. Apply at least 1.25 mils dry film on DTM applications for good film integrity.

SPECIFICATIONS

Surface Preparation:
Metal: Substrate must be free of dirt, grease, rust, and other contaminants to insure good adhesion and coating performance properties. A surface chemical treatment (iron or zinc phosphate) gives better performance than untreated metal. Refer to Metal Preparation brochure CC-tl.
Iron or Steel: For improved corrosion protection, priming is recommended. Prime with Kem® 400 Primer, E61A400/E61R402, Acrylic Enamel Primer, E61A60/E61R62, or Kem Flash® Primer, E61A45/E61H6/E61R26/E61W12. Refer to Product Data Sheet for recommendations.
Aluminum and Galvanized Steel (Untreated): Prime with Industrial Wash Primer P60G2.
Wood (Interior): No Primer is required for properly prepared, previously painted surfaces. For new wood, self prime with Kem® 400 Enamel.
APPLICATION
Recommended Film Thickness:
Wet 3.5 - 5.0 mils
Dry 1.0 - 1.5 mils
Kem® 400 Enamel may be applied conventional, airless, air assisted airless or HVLP spray equipment and dipping. Reduce 10-15% with Xylol depending on application equipment. For more flow and open time, use Aromatic Naptha-100 Flash R2K5 or Aromatic Naptha-150 Flash. Use Toluol for faster flash off and cooler temperatures.

Cleanup: Use Xylol or other aromatic solvents following suppliers' recommendations.

CAUTIONS

Contents are **FLAMMABLE**. **VAPORS MAY CAUSE FLASH FIRES.** Keep away from heat, sparks, and open flame. During use and until all vapors are gone, keep area well ventilated. Do not smoke - extinguish all flames, pilot lights, and heaters. Turn off all stoves, electric tools and appliances, and any other sources of ignition.
CONTAINS ALIPHATIC AND AROMATIC HYDROCARBONS AND XYLOL**. VAPOR HARMFUL**. Use only with adequate ventilation. Wear an appropriate properly fitted vapor/particulate respirator (NIOSH/MSHA approved) during and after application unless air monitoring demonstrates vapor/mist levels are below applicable levels. Follow respirator manufacturers directions for respirator use. Avoid contact with skin and eyes. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage.
FIRST AID:
IF INHALED: If inhaled, remove from exposure. Restore breathing. Keep warm and quiet.
IF ON SKIN: Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before reuse.
IF IN EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention immediately.
SPILL AND WASTE: Remove all sources of ignition. Ventilate and remove with inert absorbent. Incinerate in approved facility. Do not incinerate closed container. Dispose of in accordance with Federal, State, and Local regulation regarding pollution.
DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE: Contains solvents, which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

CAUTIONS **(continued)**

DO NOT TAKE INTERNALLY
KEEP OUT OF REACH OF CHILDREN
FOR INDUSTRIAL USE ONLY
REFER TO MATERIAL SAFETY DATA SHEET FOR ADDITIONAL INFORMATION
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, ratings and opinions stated above 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 or guarantees as to the end results.

P.Y. Southwest Regional Lab- 11/02/04