General Industrial Coatings

KEM® 400 Black F75BL0406

DESCRIPTION

KEM® 400 Black, F75BL0406, 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.

Advantages:

- High gloss
- Good exterior color and gloss retention
- Good one coat protection
- Fast air drying
- Good flexibility and film toughness
- Apply by conventional, airless, air assisted airless, or HVLP spray methods.
- Ideal for large time and wet-in of overspray
- Free of lead and chromate hazards
- Ideal system for horse trailers, farm, garden, and construction equipment and industrial machinery and equipment.

CHARACTERISTICS

Gloss: 85+ units
Volume Solids: 30 ± 1%
Viscosity:
40 - 50 seconds #4 Ford Cup
Recommended film thickness:

Mils Wet	3.5 – 5.0
Mils Dry	1.0 – 1.5

Spreading Rate (no application loss)
482 sq ft/gal 1.0 x 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:	30 minutes at 140-160°F

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.

Flash Point: 56°F Pensky-Martens Closed Cup
Package Life: 2 years, unopened

Air Quality Data:
Photochemically reactive
Volatile Organic Compounds (VOC)
as packaged, maximum
4.7 lb/gal, 565 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 RoHS Compliant Wash Primer, P60G10. KEM AQUA® Wash Primer, E61G522 can also be used. Do not use a wash primer on pretreated aluminum.

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.
For improved corrosion protection, priming is recommended. Prime with KEM® 400 Primer or KEM-Flash® Ultra-Bond™ Primer.

Testing: The information, data, and recommendations set forth in this Prod- uct 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.application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.

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 by:

Conventional Spray
Airless Spray
Air Assisted Airless
Electrostatic Spray
HVLP
Dip

Cleanup:

Clean tools/equipment immediately after use with Aromatic Naphtha, Ace- tone, 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.

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.

Note: All purchases of products from Sherwin-Williams are exclusively subject to Sherwin-Williams' terms and conditions of sale which can be found at www.Sherwin.Com. Please review these terms and conditions prior to the purchase of the products. Sherwin-Williams warrants the product to be free of manufacturing defect in accordance with Sherwin-Williams' quality control procedures. Except for the preceding sentence, due to factors that are outside of Sherwin-Williams' control, including substrate selection, and customer handling, preparation, and application, Sherwin-Williams cannot make any other warranties related to the product or the performance of the product.
SHERWIN-WILLIAMS DISCLAIMS ALL WARRANTIES OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.
Liability for products proven to be defectively manufactured will be limited solely to replacement of the defective product or the refund of the purchase price paid for the defective product, as determined by Sherwin-Williams. Under no circumstances shall Sherwin-Williams be liable for indirect, special, incidental or consequential damages, lost profits or punitive damages arising from any cause whatsoever.

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.

Columbus
D. Kahle
Updated 7/15/22