



**SHERWIN
WILLIAMS.**

General Industrial Coatings

KEM AQUA® 1500T W/R BAKING ENAMEL

High Temp Black F83BL0520

DESCRIPTION

KEM AQUA® 1500T W/R Baking Enamel High Temp Black, F83BL0520, is a one component, water reducible thermoset baking enamel for the general finishing market.

Advantages:

- VOC of less than 2.3 lbs./gal. less water
- Excellent Adhesion
- Water can be used for clean up of spray guns and other equipment.
- One package performance – no catalyst
- Lower Odor

*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.

CHARACTERISTICS

Gloss: 30 - 35 units @ 1.0 mil DFT

Volume Solids: 28.6 +/-2%

Viscosity: 18-22 seconds #4 Zahn

Recommended film thickness:

Mils Wet 2.8 – 4.2
Mils Dry 0.8 -1.2

Spreading Rate (no application loss):
459 sq ft/gal @ 1 mil DFT

Baking Schedule:

Flash: 20-30 minutes
Bake: 30 minutes at 300°F
or 20 minutes at 325°F

Package Life: 1 year, unopened

Storage: Store indoors - protect from freezing

pH: 8.3-8.7

Flash Point: None - Seta Flash
Closed Cup

Package Life: 1 years, unopened

Air Quality Data:

Non-photochemically reactive
Volatile Organic Compounds (VOC):
Theoretical as packaged, less water and
exempt solvents <2.3 lb/gal 276g/L.

An Environmental Data Sheet is available
from your local Sherwin-Williams facility or
at www.paintdocs.com

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 or Galvanized Steel: For best results, treat the surface with a proprietary chrome phosphate metal treatment, or prime with Kem Aqua® Wash Primer, E61G522.

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 with 2.8 VOC Catalyzed Epoxy Primer, E61A280.

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.

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APPLICATION

Typical Setups

Reduction: To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction.

Conventional Spray:

Air Pressure 50-55 psi

Fluid Pressure 10-15 psi

Cap/Tip 704/FF

Electrostatic Spray:

Atomizing Air 60 psi

HVLP: DeVilbiss JGHV

Atomizing Air Pressure at the Cap . 9 psi

Fluid Pressure 10-15 psi

Cap/Tip 46MP/FF

Cleanup:

Clean tools/equipment immediately after use with water, immediately followed by a dilute blend of water and ammonia as soon as possible. A blend of water and Butyl Cellosolve®, may also be used. Follow manufacturer's safety recommendations when using any solvent. Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

- Avoid freezing. Store at temperatures of 50°F minimum to 100°F maximum. Freezing will destroy the product quality.
- Allow 15-20 minutes flash-off of basecoat before applying texture coat.
- Heavier gauge metal may require higher temperature and longer baking schedule.
- Texture patterns dependent on equipment set up, viscosity and operator technique.

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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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.

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Columbus Regional Lab
D. Kahle
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CAUTIONS

Thoroughly review product label and