



General Industrial Coatings

Kem Aqua 8400 Water Reducible Enamel

Low Gloss Blending Clear.....F82FC550
 High Gloss Blending Clear..... F82VC551
 High Gloss Blending White F82WC552
 Catalyst V66VC510

Primer Blend.....E72PG Series
 Low Gloss Topcoat BlendF82LG Series
 High Gloss Topcoat Blend ...F82HG Series

DESCRIPTION

Kem Aqua 8400 Water Reducible Enamel is an interior-exterior two component polyamine epoxy topcoat. Industrial applications include on steel, galvanized, concrete, masonry, wood, drywall, and previously painted substrates.

Advantages:

- Complies with < 1.0 *VOC solvent emissions.
- Formulated to be HAPS free.
- Free of chromate hazards.
- Suitable for use in USDA inspected facilities.

CHARACTERISTICS

60° Gloss:

Low Gloss Clear 5-15
 High Gloss Clear & White 85+

Volume Solids (varies by color):

Part A 39-42 ± 2 %
 Catalyst 29 ± 2 %
 Admixed 36-39 ± 2 %

Viscosity (at 77° F, Stormer, varies by color):

Part A 95-120 KU
 Catalyst 50-75 KU
 Admixed 85-95 KU

Recommended Film Thickness:

Mils Wet 3.7-6.0
 Mils Dry 1.5-2.5

Spreading Rate: 381-419 ft.²/gal.
 at 1.5 mil DFT
 (varies by color, no application loss)

Cure:

Air Dry, or
 Force Dry 10 mins. flash, 30 mins. at 140° F

Drying: 1.5 mils at 77° F, 50% RH

To Touch 45 minutes
 To Handle 4 hours
 Minimum Recoat 6 hours
 Maximum Recoat 30 days
 Total (Full Properties) 7-10 days

Mixing Ratio (by volume):

Part A 4.0 Parts
 Catalyst 1.0 Part
 Water (Reducer): up to 1.0 Part

Pot Life: 4-5 hours

Recoat Window: If the coating is older than 30 days, it must be sanded/scuffed prior to reapplication or top coating.

Flash Point (Pensky Martens Closed Cup):

Part A n/a
 Catalyst n/a

Air Quality Data:

Photochemically Reactive
 Volatile Organic Compounds (VOC)
 (admixed, maximum) <0.42 lb/gal, <50 g/L

Recommended Storage: Inside, sealed container, 40-120° F, freeze hazard. Protect from moisture.

Package Life:

Part A 2 years
Catalyst 3 years
 Unopened, inside storage
 Protect from freezing

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.

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.

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

Reduction: Water
Reduced (1 Part, #3 Zahn Cup) 17-25 secs.

May be applied by: Conventional Spray

Conventional Spray:
Air Pressure 45-60 psi
Fluid Pressure 8-12 psi
Tip 0.055-0.070 in.

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

Cleanup: Clean spills, spatters, hands and tools immediately after use with soap and warm water. After cleaning, flush spray equipment with compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using solvents.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. **This product must be properly catalyzed before using. DO NOT VARY CATALYST RATIO.** The catalyst ratio has been established for optimum hardness, flexibility, gloss, and chemical & solvent resistance.
2. All epoxies will chalk and fade when untopcoated in exterior environments. Apply appropriate topcoat if aesthetics are required.
3. Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.
4. If parts have been stored for longer than one week after top coating, they must be scuffed or sanded before top coating again to ensure removal of any accumulated dust/dirt.
5. On sandblasted surfaces, apply sufficient film thickness to fully protect the blast profile. This is typically 1 mil more than the blast profile.
6. Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slower drying.

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.

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