Product Finishes

Mod Kem Flash® Ultra-Bond® Buff Primer E61HL0004

DESCRIPTION

Mod Kem Flash® Ultra-Bond® Buff Primer, E61HL0004 is a high-solids one-package epoxy ester primer offering excellent performance properties and topcoatability with a wide range of topcoats including two component polyurethanes, alkyd enamels, and acrylic enamels. It is an ideal primer for the construction machinery and farm equipment.

Advantages:

- Single component – no catalyst
- Fast drying
- Excellent holdout of topcoat
- Excellent corrosion resistance
- High solids for quick film build with minimum spray passes
- May be applied using a wide array of application equipment
- Compatible with a wide range of topcoats, including:
  - Polane Polyurethane Enamels
  - Kem Fast Dry High Solids Enamel
  - Quick Dry 350 Enamel
  - Kem Aqua 280 Enamel
  - Kem Acryl HS 100 Enamel
  - Kem Aqua 400 Enamel
- Free of lead hazards as packing in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303:

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

CHARACTERISTICS

Gloss: <30 units @ 60°
Volume Solids: 47 ± 2%
Viscosity:
35-40 seconds #2 Zahn Cup (Gardner Signuature)
Recommended film thickness:
Mils Wet 2.8 – 3.8
Mils Dry 1.5 – 2.0
Spreading Rate (no application loss)
425-567 sq ft/gal @ 1.5-2.0 mils DFT
Drying (77°F, 50% RH):
To Touch: 15-30 minutes
To Handle: 60 minutes
Tack Free: 45-60 minutest
To Topcoat: after 15 minutes
Flash Point: 60°F Seta Flash
Package Life: 1 year, unopened

Air Quality Data:

- Photochemically reactive
- Volatile Organic Compounds (VOC) as packaged, maximum 3.8 lb/gal
- Volatile Hazardous Air Pollutants (VHAPS) as packaged, maximum 2.42 lb/gal of solids

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, then prime with Kem-Flash® Ultra-Bond® Primer.
Galvanized Steel: If untreated, prime with Industrial Wash Primer, P60G2, then prime with Kem-Flash® Ultra-Bond® Primer.
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 hot rolled steel, sandblasting or power tool cleaning is recommended to remove mill scale, rust, etc.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility, and performance prior to full scale application.

APPLICATION

Typical Setups

Conventional Spray:
Air Pressure..... 45-60 psi
Fluid Pressure ..... 10-15 psi
Tip ..... .055-.070
Airless Spray:
Pressure ..... 2200-2600 psi
Tip ..... .013-.015"
Air Assisted Airless:
Air Pressure..... 10-30 psi
Fluid Pressure ..... 2000-2600 psi
Fluid Tip..... .013-.015"
Electrostatic Spray:
Reducer for polarity ..... MAK
Voltage 60-85KV
HVLP:
Air Pressure ..... 10 psi max at cap
Fluid Pressure ..... 8-10 psi
Cleanup:
Clean tools/equipment immediately after use with Xylene or High Flash Naphtha – 100. For lower HAPS cleanup use Butyl Acetate, R6K18 or MAK, R6K30.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- For good corrosion resistance, apply a minimum of 1.25 mils dry film thickness. 1.5-2.0 mil dft is recommneded for optimum corrosion resistance.
- Higher film thickness may increase dry times and may cause crticial recoat with some topcoats.
- To maintain 3.5 VOC, do not reduce more than 3.5%.
- On blasted surfaces, apply sufficient dry film thicknesses to fully protect the blast profile. This is typically one mil more than the blast profile.
- For topcoating after 4 weeks or more of air drying of the primer, sand for best adhesion.
- Primer dry film thickness above the recommended range will result in raised gloss.
- Force drying this product will not shorten cure time. The primer's cure and related performance is time dependent. However, a minimum cure temperature of 60° is needed to achieve the listed performance properties in seven days.
- For applications requiring faster drying system that does not involve two component polyurethanes, Kem Flash® 500 Primer should be evaluated.

Note: Latex and Nitrocellulose Lacquers are not recommended over Kem-Flash® Ultra-Bond® Primer. Other enamels should be tested for performance before use.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION
Thoroughly review product label for safety and cautions prior to using this product.
A Material Safety Data Sheet is available from your local Sherwin-Williams facility.
Please direct any questions or comments to your local Sherwin-Williams facility.

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.

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