



**SHERWIN
WILLIAMS.**

Product Finishes

POLY-EPOXY™ Semi-Gloss Electrostatic Enamel

714-6282 Hi-Hide White Base. F64W1
714-5304 Pastel Base..... F64W2

714-5316 Deeptone Base F64W4
714-5555 Masstone (Clear) Base... F64T6

824-4725 High Flash Reducer.....R7KSC1
714-6200 Epoxy Catalyst.....V66V107

DESCRIPTION	CHARACTERISTICS	SPECIFICATIONS
<p>POLY-EPOXY™ Semi-Gloss Electrostatic Enamel is a two component catalyzed epoxy enamel offering high performance properties for the finishing and refinishing of metal office furniture. It is specifically designed for onsite electrostatic application, e.g. Ransburg #2 or similar.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Ideal for on-site refinishing - usually overnight - using electrostatic spray equipment • Provides a new look and new image by refinishing existing office and workplace furniture and equipment • Resistant to many acids, alkaline solutions, detergents, oil and hot water • Neat, clean and safe - refinish furniture in customer's carpeted offices • Extremely tough and flexible coating with excellent adhesion • Also adheres to metal, wood, plastic, glass, masonry and other surfaces • High performance two component epoxy-polyamide chemistry • Full color range available using Chroma Chem 844 colorants • Lower gloss levels available by using D64F100 Gloss Modifying Agent (consult Data Sheet CC-S10) • Fast drying - repainted furniture may be used the next day • May also be applied by conventional, airless, air assisted airless or HVLP spray methods or by brush and roller • Free of lead and chromate hazards • Free of isocyanates • No chlorinated solvents 	<p>Gloss: Semi-gloss</p> <p>Volume Solids: 38.5±1.5% catalyzed, varies by color</p> <p>Viscosity: As Packaged: 70-80 Krebs Units As Catalyzed: 15-25 seconds #3 Zahn</p> <p>Recommended film thickness: Mils Wet 3.0-4.0 Mils Dry 1.2-1.6</p> <p>Spreading Rate (no application loss) @ 1.2-1.6 mil dft: 387-516 sq ft/gal</p> <p>Drying (1.0 mils dft, 77°F, 50% RH): To Touch: 30-45 minutes To Handle: 1½ to 2 hours To Recoat: 8 hours</p> <p>Flash Point: 120°F Seta Flash Closed Cup</p> <p>Mixing Ratio: 1 part Pigmented Base 1 part Catalyst Mix thoroughly and allow 30 minutes sweat-in before use.</p> <p>Pot Life: 8 hours at room temperature</p> <p>Package Life: 2 years, unopened V66V107 1 year, unopened</p> <p>Air Quality Data: Photochemically reactive Volatile Organic Compounds (VOC) Pigmented Base, as packaged, maximum 4.4 lb/gal; 530g/L V66V107: 4.7 lb/gal; 560 g/L catalyzed 1:1, maximum 4.6 lb/gal; 545 g/L</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility.</p>	<p>Metal: Surface must be free of dirt, dust, grease, furniture wax, fingerprints, rust and other foreign matter. For repaint surfaces, a light sanding is recommended to roughen the surface for best adhesion.</p> <p>Catalyzation: Mix Pigmented Base thoroughly, then mix one part of the Pigmented Base with 1 part Epoxy Catalyst and allow to sweat-in 30 minutes before use. If necessary, reduce up to 15% with High Flash Reducer R7KSC1 (824-4725). See application section for details.</p> <p>Spray catalyzed POLY-EPOXY™ Enamel using electrostatic, conventional, airless, air assisted airless and HVLP spray methods or brush and roller. POLY-EPOXY™ Enamel is supplied at proper polarity for electrostatic spray applications.</p>

APPLICATION

Typical Setups

Conventional Spray:

Air Pressure..... 50-60 psi
Fluid Pressure 15-20 psi
Cap/Tip 765 or 797/FF
Reducer..... R7KSC1
Reduction Rate... as needed up to 15%

Airless Spray:

Pressure 2100 to 2400 psi
Tip011-.013"
Reducer..... None

Air Assisted Airless:

Air Pressure..... 20-30 psi
Fluid Pressure 2100-2400 psi
Cap/Tip..... 222-608/.011-.013
Reducer..... None

Electrostatic Spray: Ransburg #2

Reducer..... R7KSC1
Reduction Rate... as needed up to 10%
Megohms..... 0.7 to 1.8

HVLP: Binks Mach I

Air Pressure..... 65 psi
Fluid Pressure 15-20 psi
Cap/Tip..... 97P/91
Reducer..... R7KSC1
Reduction Rate..... 10-15%

Important Note: Proper ventilation is required until all coating vapors have dissipated from the work area.

Cleanup:

Clean tools/equipment immediately after use with High Flash Reducer R7KSC1 (824-4725).
Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- Old paint films which are soft, cracked or show poor adhesion to the surface may wrinkle when POLY-EPOXY™ is applied over them. In such cases the old film should be totally removed.
- Test a small inconspicuous area to determine compatibility of POLY-EPOXY™ with the old paint surface.
- POLY-EPOXY™ Enamels will continue to harden and cure for several weeks until ultimate abrasion resistance and chemical resistance is obtained.
- When blending custom colors using Chroma Chem 844 colorants, thorough agitation is required for full color development and stable color.
- Do not use High Flash Naphtha - 100 Flash for cleanup. It is not strong enough. Reducer R7K54 also may be used for cleanup but not for application.
- While working pot life is 8 hours at room temperature, higher temperatures will shorten pot life. It can be extended by refrigerating at the end of the work day. Do not catalyze excess quantity beyond that intended for use during the current day or shift.
- For interior use only.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION

Thoroughly review product label and Material Safety Data Sheet (MSDS) 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.