



**Industrial
&
Marine
Coatings**

2.16

INDUSTRIAL ENAMEL VOC-COMPLYING

B54Z SERIES

PRODUCT INFORMATION

Revised 6/06

PRODUCT DESCRIPTION		RECOMMENDED USES																				
<p>INDUSTRIAL ENAMEL VOC COMPLYING is a medium oil, alkyd, interior/exterior, all-purpose enamel. Designed for new construction and maintenance application uses.</p> <ul style="list-style-type: none"> Dries fast and allows equipment to be placed back in service quickly Chip and flake resistant High gloss/dirt resistant Apply down to 40°F 		<p>For use over prepared substrates in industrial environments:</p> <ul style="list-style-type: none"> Exterior/interior all-purpose maintenance enamel Safety and pipe marking enamel Economical machinery and equipment finish Interior wall and ceiling enamel A utility enamel for multiple uses: equipment, fixtures, conveyors, fire escapes, window frames, pumps, safety markings, wood and concrete floors, railings, steel support structures, blowers, pipe racks, pipe identification, channels and bracing. Conforms to AWWA D102-03, OCS # 1 Acceptable for use in high performance architectural applications. Suitable for use in USDA inspected facilities 																				
PRODUCT CHARACTERISTICS		PERFORMANCE CHARACTERISTICS																				
<p>Finish: Gloss</p> <p>Color: Wide range of colors available including safety colors</p> <p>Volume Solids: 47% ± 2%, may vary by color Ultra White</p> <p>Weight Solids: 64% ± 2%, may vary by color Ultra White</p> <p>VOC (EPA Method 24): <420 g/L; 3.5 lb/gal Pure White</p> <p>Recommended Spreading Rate per coat: Wet mils: 4.0 - 6.0 Dry mils: 2.0 - 3.0 Coverage: 250 - 375 sq ft/gal approximate</p> <p>NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.</p> <p>Drying Schedule @ 4.0 mils wet @ 50% RH:</p> <table border="1"> <thead> <tr> <th></th> <th>@50°F</th> <th>@77°F</th> <th>@110°F</th> </tr> </thead> <tbody> <tr> <td>To touch:</td> <td>5 hours</td> <td>1-2 hours</td> <td>45 minutes</td> </tr> <tr> <td>Tack free:</td> <td>8 hours</td> <td>4-5 hours</td> <td>2.5 hours</td> </tr> <tr> <td>To recoat:</td> <td>10 hours</td> <td>8 hours</td> <td>3 hours</td> </tr> <tr> <td>To cure:</td> <td>7 days</td> <td>7 days</td> <td>3 days</td> </tr> </tbody> </table> <p>Drying time is temperature, humidity, and film thickness dependent.</p> <p>Shelf Life: 36 months, unopened Store indoors at 40°F to 100°F.</p> <p>Flash Point: 102°F, PMCC</p> <p>Reducer: Not recommended</p> <p>Clean Up: Mineral Spirits, R1K4</p>		@50°F	@77°F	@110°F	To touch:	5 hours	1-2 hours	45 minutes	Tack free:	8 hours	4-5 hours	2.5 hours	To recoat:	10 hours	8 hours	3 hours	To cure:	7 days	7 days	3 days	<p>System Tested: (unless otherwise indicated) Substrate: Steel Surface Preparation: SSPC-SP6 1 ct. Kem Kromik Universal @ 3.0 mils dft 1 ct. Industrial Enamel VOC @ 3.0 mils dft</p> <p>Abrasion Resistance: Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load Result: 180 mg loss</p> <p>Adhesion: Method: ASTM D4541 Result: 290 psi</p> <p>Dry Heat Resistance: Method: ASTM D2485 Result: 200°F</p> <p>Flexibility: Method: ASTM D522, 180° bend, 3/16" mandrel Result: Passes</p> <p>Pencil Hardness: Method: ASTM D3363 Result: 3B</p> <p>Exterior Durability: Method: 1 year, 45° South Result: Good</p> <p>Provides performance comparable to products formulated to federal specifications: DOD-E-115C MIL-E-15090</p>	
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RECOMMENDED SYSTEMS	SURFACE PREPARATION
<p>Steel, alkyd primer: 1 ct. Kem Kromik Universal Metal Primer @ 2.5 - 3.5 mils dft 2 cts. Industrial Enamel VOC Complying @ 2.0 - 3.0 mils dft/ct</p> <p>Aluminum: 1 ct. DTM Wash Primer @ 0.7 - 1.3 mils dft 2 cts. Industrial Enamel VOC Complying @ 2.0 - 3.0 mils dft/ct</p> <p>Concrete Block: 1 ct. Heavy Duty Block Filler @ 10.0 - 18.0 mils dft 2 cts. Industrial Enamel VOC Complying @ 2.0 - 3.0 mils dft/ct</p> <p>Concrete Floors: 1 ct. Concrete and Terrazzo Sealer (reduced as needed) 2 cts. Industrial Enamel VOC Complying @ 2.0 - 3.0 mils dft/ct</p> <p>Galvanized Metal: 1 ct. Galvite HS @ 3.0 - 4.5 mils dft 2 cts. Industrial Enamel VOC Complying @ 2.0 - 3.0 mils dft/ct</p> <p>Wood (including Floors): 2 cts. Industrial Enamel VOC Complying @ 2.0 - 3.0 mils dft/ct</p> <p>Interior Plaster and Poured Concrete Walls: 1ct PrepRite Masonry Primer @ 3 mils dft/ct 2 cts. Industrial Enamel VOC Complying @ 2.0 - 3.0 mils dft/ct</p> <p>The systems listed above are representative of the product's use. Other systems may be appropriate.</p>	<p>Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.</p> <p>Refer to product Application Bulletin for detailed surface preparation information.</p> <p>Minimum recommended surface preparation:</p> <ul style="list-style-type: none"> * Iron & Steel: SSPC-SP2 * Aluminum: SSPC-SP1 * Galvanizing: SSPC-SP1 * Concrete & Masonry: SSPC-SP13/NACE 6 or ICRI 03732, CSP 1-3 <p>Wood, interior: Clean, smooth, dust free</p> <p>* Primer required</p>
	<h3 style="text-align: center;">TINTING</h3> <p>Tint with Blend-A-Color Toner or 844 Colorant at 75% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.</p>
	<h3 style="text-align: center;">APPLICATION CONDITIONS</h3> <p>Temperature: 40°F minimum, 120°F maximum (air, surface, and material) At least 5°F above dew point</p> <p>Relative humidity: 85% maximum</p> <p>Refer to product Application Bulletin for detailed application information.</p>
	<h3 style="text-align: center;">ORDERING INFORMATION</h3> <p>Packaging: 1 and 5 gallon containers</p> <p>Weight per gallon: 9.45 ± 0.2 lb, may vary with color</p>
	<h3 style="text-align: center;">SAFETY PRECAUTIONS</h3> <p>Refer to the MSDS sheet before use.</p> <p>Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.</p>
<h3 style="text-align: center;">DISCLAIMER</h3>	<h3 style="text-align: center;">WARRANTY</h3>
<p>The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.</p>	<p>The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.</p>



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APPLICATION BULLETIN

Revised 6/06

SURFACE PREPARATION	APPLICATION CONDITIONS
<p>Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.</p> <p>Iron & Steel Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Prime any bare steel within 8 hours or before flash rusting occurs.</p>	<p>Temperature: 40°F minimum, 120°F maximum (air, surface, and material) At least 5°F above dew point</p> <p>Relative humidity: 85% maximum</p>
<p>Aluminum Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Primer required.</p>	<p>APPLICATION EQUIPMENT</p>
<p>Galvanized Steel Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1 (recommended solvent is VM&P Naphtha). When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.</p>	
<p>Masonry and Concrete For surface preparation, refer to SSPC-SP13/NACE 6 or ICRI 03732, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F. Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with ArmorSeal Crack Filler. Weathered masonry and soft or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination and to get to a hard, firm surface. Laitance must be removed by etching with a 10% muriatic acid solution and thoroughly neutralized with water. Brick must be allowed to weather for one year prior to surface preparation and painting. Primer required.</p>	<p>Conventional Spray</p> <p>Gun Binks 95 Fluid Nozzle 66 Air Nozzle 63PB Atomization Pressure .. 50 psi Fluid Pressure 20-25 psi</p> <p>Brush</p> <p>Brush Natural Bristle</p>
<p>Wood Surface must be clean, dry, and sound. Paint as soon as possible. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped, sanded and spot primed. All nail holes or small openings must be properly caulked. Sand to remove any loose or deteriorated surface wood and to obtain a proper surface profile. Self priming.</p>	<p>Roller</p> <p>Cover 3/8" woven with phenolic core</p>
<p>Previously Painted Surfaces If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, or if this product attacks the previous finish, removal of the previous coating may be necessary. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.</p>	<p>If specific application equipment is not listed above, equivalent equipment may be substituted.</p>



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APPLICATION BULLETIN

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mixing Instructions: Mix paint thoroughly by boxing and stirring before use.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recommended Spreading Rate per coat:

Wet mils:	4.0 - 6.0
Dry mils:	2.0 - 3.0
Coverage:	250 - 375 sq ft/gal approximate

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 4.0 mils wet @ 50% RH:

	@50°F	@ 77°F	@110°F
To touch:	5 hours	1-2 hours	45 minutes
Tack free:	8 hours	4-5 hours	2.5 hours
To recoat:	10 hours	8 hours	3 hours
To cure:	7 days	7 days	3 days

Drying time is temperature, humidity, and film thickness dependent.

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

No reduction of material is recommended as it can affect film build, appearance, and adhesion.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Mineral Spirits, R1K4.

Deep tinted colors may exhibit burnishing characteristics.

Refer to Product Information sheet for additional performance characteristics and properties.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Mineral Spirits, R1K4. Clean tools immediately after use with Mineral Spirits, R1K4. Follow manufacturer's safety recommendations when using any solvent.

SAFETY PRECAUTIONS

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WARRANTY

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