

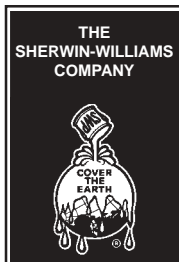


*Industrial
and
Marine
Coatings*

DIRECT-TO-METAL ENAMEL

B55 SERIES

PRODUCT INFORMATION		Revised 1/02
PRODUCT DESCRIPTION	RECOMMENDED USES	
<p>DIRECT-TO-METAL ENAMEL is a high-build alkyd coating with rust-inhibitive properties for application directly to bare steel.</p> <ul style="list-style-type: none"> • Good gloss and color retention • Corrosion resistance and finish coat protection in one coat • Outstanding long term flexibility • Suitable for use in USDA inspected facilities 	<p>For use over prepared steel in industrial environments.</p> <ul style="list-style-type: none"> • Interior / exterior • New construction • Railings • Machinery • Structural steel • Steel doors • Steel decking • Primer / finish • Repaints • Storage tanks • Bar joists • Piping • Fire escapes • Conveyors 	
PRODUCT CHARACTERISTICS	PERFORMANCE CHARACTERISTICS	
<p>Finish: Semi-Gloss</p> <p>Color: Wide range of colors available</p> <p>Volume Solids: 41% ± 2%, may vary by color</p> <p>Weight Solids: 59% ± 2%, may vary by color</p> <p>VOC (calculated): 450 g/L; 3.75 lb/gal Pure White</p> <p>Recommended Spreading Rate per coat:</p> <p>Wet mils: 7.0 - 13.0 Dry mils: 3.0 - 5.0 Coverage: 131 - 188 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 10.0 mils wet @ 50% RH: @ 77°F</p> <p>To touch: 1½ hours Tack free: 6 hours To recoat: 18 hours</p> <p>Drying time is temperature, humidity and film thickness dependent.</p> <p>Shelf Life: 36 months, unopened, at 77°F</p> <p>Flash Point: 101°F, PMCC</p> <p>Reducer: Not recommended</p> <p>Clean Up: VM&P Naphtha, R1K3</p>	<p>System Tested: (unless otherwise indicated) Substrate: Steel Surface Preparation: SSPC-SP6 Finish: 2 cts. Direct-to-Metal Enamel @ 3.0 mils dft/ct</p> <p>Abrasion Resistance: Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load Result: 200 mg loss</p> <p>Adhesion: Method: ASTM D4541 Result: 300 psi</p> <p>Direct Impact Resistance: Method: ASTM G14 Result: >30 in. lbs.</p> <p>Dry Heat Resistance: Method: ASTM D2485 Result: 200°F (discolors)</p> <p>Flexibility: Method: ASTM D522, 180° bend, 1/4" mandrel Result: Passes</p> <p>Moisture Condensation Resistance: Method: ASTM D4585, 100°F, 500 hours Result: Passes</p> <p>Pencil Hardness: Method: ASTM D3363 Result: 3B</p> <p>Salt Fog Resistance: Method: ASTM B117, 500 hours Result: Passes</p> <p>Exterior Durability: Method: 1 year, 45° South Result: Very good</p> <p>Thermal Shock: Method: ASTM D2246, 5 cycles Result: Passes</p> <p>Provides performance comparable to products formulated to federal specifications: MIL-E-15090, TT-E-485F</p>	



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PRODUCT INFORMATION

RECOMMENDED SYSTEMS

Steel, Light Service:

1 ct. Direct-To-Metal Enamel @ 3.0 - 5.0 mils dft

Steel, Moderate Service:

2 cts. Direct-To-Metal Enamel @ 3.0 - 5.0 mils dft/ct

The systems listed above are representative of the product's use. Other systems may be appropriate.

SURFACE PREPARATION

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.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:
Iron & Steel: SSPC-SP2

TINTING

Tint with Blend-A-Color Toner at 75% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

APPLICATION CONDITIONS

Temperature: 40°F minimum, 120°F maximum
(air, surface, and material)
At least 5°F above dew point
Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

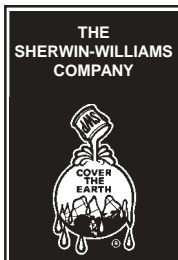
ORDERING INFORMATION

Packaging: 1 and 5 gallon containers
Weight per gallon: 9.2 ± 0.2 lb, may vary with color

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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APPLICATION BULLETIN

Revised 1/02

SURFACE PREPARATION

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.

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). Coat any bare steel within 8 hours or before flash rusting occurs.

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.

APPLICATION CONDITIONS

Temperature: 40°F minimum, 120°F maximum
(air, surface, and material)
At least 5°F above dew point

Relative humidity: 85% maximum

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.

Reducer Not recommended

Clean Up VM&P Naphtha, R1K3

Airless Spray

Pressure 2000 psi
Hose 3/8" ID
Tip019"

Conventional Spray

Gun Binks 95
Fluid Nozzle 63B
Air Nozzle 63PB
Atomization Pressure .. 50 psi
Fluid Pressure 20-25 psi

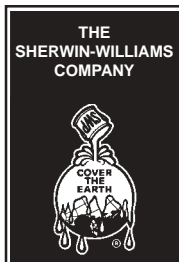
Brush

Brush Natural Bristle

Roller

Cover 3/8" woven with phenolic core

If specific application equipment is listed above, equivalent equipment may be substituted.



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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:	7.0 - 13.0
Dry mils:	3.0 - 5.0
Coverage:	131 - 188 sq ft/gal approximate

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

Drying Schedule @ 10.0 mils wet @ 50% RH:

@ 77°F

To touch:	1½ hours
Tack free:	6 hours
To recoat:	18 hours

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 VM&P Naphtha, R1K3.

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

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with VM&P Naphtha, R1K3. Clean tools immediately after use with VM&P Naphtha, R1K3. Follow manufacturer's safety recommendations when using any solvent.

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