



INDUSTRIAL ENAMEL

B54W00101 PURE WHITE
 B54W00113 DEEP BASE
 B54T00104 ULTRADEEP BASE
 B54B00011 BLACK
 B54E00039 SAFETY ORANGE
 B54R00038 SAFETY RED
 B54Y00037 SAFETY YELLOW

As of 07/25/2017, Complies with:

OTC	No	LEED® 09 NC, CI	No
OTC Phase II	No	LEED® 09 CS	No
SCAQMD	No	LEED® 09 S	No
CARB	No	LEED® v4 Emissions	No
CARB SCM 2007	No	LEED® v4 VOC	No
Canada	No	MPI	

CHARACTERISTICS

INDUSTRIAL ENAMEL is a medium oil/alkyd all-purpose enamel. Designed for interior and exterior use.

Features:

- Good exterior durability
- High gloss coating
- Excellent application properties
- Exterior/interior all-purpose enamel
- Suitable for use in USDA inspected facilities

For use on properly prepared:

- Steel
- Concrete
- Wood
- Plaster
- Primed aluminum & galvanized steel
- Previously painted

Recommended for use in:

- Interior / exterior
- New construction
- Railings/frames
- Machinery
- Structural steel
- Steel doors
- Steel supports
- Equipment
- Repaints
- Storage tanks
- Bar joists
- Pipe marking
- Fire escapes
- Conveyors

Tinting with BAC or Maxitoner:

Base	oz/gal	Strength
Pure White	0 - 5	SherColor
Deep Base	4 - 11	SherColor
Ultra-deep Base	10 - 11	SherColor

Check color before using. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

Shelf Life: 36 months, unopened
Finish: 80°+@60° Gloss

Pure White B54W00101

(may vary by base)

VOC (less exempt solvents) 441 g/L - 3.68lb/gal
 (as per 40 CFR 59.406 and SOR/2009-264, s. 12)
Volume Solids: 43 ± 2%
Weight Solids: 58 ± 2%
Weight per Gallon: 8.78 lb/gal ± .2 lb
Flash Point: 101°F TCC

SPECIFICATIONS

Color: Pure White, Deep Base, Ultra-deep Base, Black, Safety Red/Orange & Yellow

Recommended Spread Rate per coat: Pure White B54W00101 (varies by base)

wet mils: 4.5 - 9.0
 dry mils: 1.9 - 3.9
 coverage: 360- 175 sq ft/gal approximate

Theoretical coverage: 689 sq ft/gal @ 1 mil dry

Drying Schedule @ 4.6 mils wet, 50% RH:

	@ 50°F/10°C	@ 77°F/25°C	@ 110°F/43°C
To touch:	3 hours	1-3hours	30 minutes
Tack free:	8 hours	4-6 hours	4 hours
To recoat:	12 hours	8 hours	3 hours
To cure:	7 days	7 days	3 days

Drying and recoat times are temperature, humidity, and film thickness dependent.

RECOMMENDED SYSTEMS

Steel & Rusted Galvanized, acrylic primer:

1ct. Pro Industrial Pro-Cryl Primer
 2cts. Industrial Enamel

Steel alkyd primer:

1ct. Kem Bond HS
 Or
 1ct. Kem Kromik Universal Metal Primer
 2cts. Industrial Enamel

Aluminum/Galvanized waterbased primer:

1ct. DTM Wash Primer
 2cts. Industrial Enamel

Concrete Block:

1ct. Pro Industrial Heavy Duty Block Filler
 2cts. Industrial Enamel

Plaster & Poured Concrete Walls, Interior:

1ct. Loxon Concrete and Masonry Primer
 2cts. Industrial Enamel

Wood, Exterior:

1ct. Exterior Oil-Based Wood Primer
 2cts. Industrial Enamel

Wood, Interior:

1ct. Premium Wall & Wood Primer
 2cts. Industrial Enamel

Wood, floors:

2cts. Industrial Enamel

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

System: (unless otherwise indicated)

Substrate: Steel
 Surface Preparation: SSPC-SP6/NACE 3
 Finish: 1ct. Kem Kromik Universal Metal Primer, @ 3.0 - 4.0 mils dft/ct.
 1ct. Industrial Enamel, B54W00101 @ 3.0 mils dft/ct.

*unless otherwise noted below

Abrasion Resistance¹:

Method: ASTM D4060, CS17 wheel 500 cycles 1 kg load
 Results: 58 mg loss

Dry Heat Resistance:

Method: ASTM D2485
 Result: 200°F (discolors)

Flexibility:

Method: ASTM D522, 180° bend, 3/16" mandrel
 Result: Pass

Fineness of grind²:

Method: Hegman
 Result: 6 Hegman minimum

Pencil Hardness:

Method: ASTM D3363
 Result: 3B

Sag Test²:

Method: ASTM D4400
 Result: 6 mils minimum

Viscosity²: 77-83 KU

¹ 1ct. Industrial Enamel, B54W00101 2.8 mils ² Standard test based on Certificate of Analysis



INDUSTRIAL ENAMEL

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority.

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/NACE 3, 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.

Aluminum - Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Primer required.

Galvanized Steel - Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. When 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-SP16 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. Primer required.

Concrete Block - Surface should be thoroughly clean and dry. Air, material and surface temperatures must be at least 50°F (10°C) before filling. Use Pro Industrial Heavy Duty Block Filler or Loxon Block Surfer. The filler must be thoroughly dry before topcoating.

Masonry - All masonry must be free of dirt, oil, grease, loose paint, mortar, masonry dust, etc. Clean per SSPC-SP13/Nace 6/ ICRI No. 310.2R, CSP 1-3. Poured, troweled, or tilt-up concrete, plaster, mortar, etc. must be thoroughly cured at least 30 days at 75°F(23.9°C). Form release compounds and curing membranes must be removed by brush blasting. Brick must be allowed to weather for one year prior to surface preparation and painting. 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. Apply one coat alkali resistant primer, following label recommendations. Primer required.

Wood - Surface must be clean, dry and sound. Prime with recommended primer. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped, sanded and spot primed before full coat of primer is applied. All nail holes or small openings must be properly caulked.

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, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Other substrates may or may not be appropriate. If a specific substrate is not listed above, consult your Sherwin-Williams representative for more information.

APPLICATION PROCEDURES

Apply paint at the recommended film thickness and spreading rate as indicated on front page. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. 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, over thinning, climatic conditions, and excessive film build.

SAFETY PRECAUTIONS

Refer to the SDS sheets before use. **FOR PROFESSIONAL USE ONLY**
Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

PERFORMANCE TIPS

Mix paint thoroughly to a uniform consistency with slow speed power agitation prior to use. Stripe coat 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. Deep tinted colors may exhibit burnishing characteristics. Do not use colorants formulated for interior use only when applying exterior.

APPLICATION

Refer to the SDS sheet before use

Temperature: 40°F(4.5°C) minimum
120°F(49°C) maximum
(Air, surface, and material)
At least 5°F above dew point
Relative humidity: 85% maximum

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..... Compliant Mineral Spirits

Airless Spray
Pressure2500 psi
Hose1/4" ID
Tip015"
Filter100 mesh

Conventional Spray
Gun.....Binks 95
Fluid Nozzle.....66
Air Nozzle63PB
Atomization Pressure50 PSI
Fluid Pressure20-25 PSI

Brush..... Natural Bristle

Roll.... 3/8" woven with solvent resistant core

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with compliant solvent.

CLEANUP INFORMATION

Clean spills, splatters & tools with compliant cleanup solvent. After cleaning, flush spray equipment with compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using solvents.

DANGER: Rags, steel wool, other waste soaked with this product, and sanding residue may spontaneously catch fire if improperly discarded. Immediately place rags, steel wool, other waste soaked with this product, and sanding residue in a sealed, water-filled, metal container. Dispose of in accordance with local fire regulations.

HOTW	07/25/2017	B54W00101	48 441
HOTW	07/25/2017	B54W00113	12 443
HOTW	07/25/2017	B54T00104	33 444