



# INDUSTRIAL ENAMEL HS

B54WZ0401 PURE WHITE  
 B54WZ0413 DEEP BASE  
 B54TZ0404 ULTRADEEP BASE  
 B54BZ0411 BLACK  
 B54EZ0439 SAFETY ORANGE  
 B54RZ0438 SAFETY RED  
 B54YZ0437 SAFETY YELLOW

As of 07/25/2017, Complies with:			
OTC	Yes	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	Yes	MPI	Yes

## CHARACTERISTICS

**INDUSTRIAL ENAMEL HS** is a higher solids, alkyd, gloss topcoat. It is easy to apply by brush, roll, or spray and is intended for interior/exterior use in industrial environments.

### Features:

- Interior/Exterior applications
- High gloss coating
- Easy application properties
- Low temperature application 40°F
- 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 - 14	SherColor
Ultra-deep Base	10 - 14	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:** 75°+@60° Gloss

### Pure White B54WZ0401 (may vary by base)

**VOC(less exempt solvent)** 320 g/L - 2.67lb/gal  
 (as per 40 CFR 59.406 and SOR/2009-264, s. 12)  
**Volume Solids:** 59 ± 2%  
**Weight Solids:** 72 ± 2%  
**Weight per Gallon:** 9.70 lb/gal ± .2 lb  
**Flash Point:** 103°F TCC

## SPECIFICATIONS

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

**Recommended Spread Rate per coat: Pure White B54WZ0401 (varies by base)**

wet mils: 3.5 - 7.0  
 dry mils: 2.0 - 4.1  
 coverage: 473- 230 sq ft/gal approximate

**Theoretical coverage:** 946 sq ft/gal @ 1 mil dry

**Drying Schedule @ 4.0 mils wet, 50% RH:**

	@ 45°F/7°C	@ 77°F/25°C	@ 120°F/49°C
<b>To touch:</b>	6 hours	4 hours	2 hours
<b>To Handle:</b>	14 hours	10 hours	6 hours
<b>To recoat:</b>	24 hours	16 hours	12 hours
<b>To cure:</b>	14 days	7 days	4 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 HS

### Steel alkyd primer:

1ct. Kem Bond HS

Or

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

### Aluminum/Galvanized waterbased primer:

1ct. DTM Wash Primer

Or

1ct. Galvite HS  
 2cts. Industrial Enamel HS

### Concrete Block:

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

### Drywall Interior:

1ct. ProMar 200 Zero VOC Primer  
 2cts. Industrial Enamel HS

### Plaster & Poured Concrete Walls, Interior:

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

### Wood, Exterior:

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

### Wood, Interior:

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

### Wood, floors:

2cts. Industrial Enamel HS

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-SP2

**Finish:** Industrial Enamel, B54WZ0401 @ 2.0 mils dft/ct.

\*unless otherwise noted below

### Dry Heat Resistance:

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

### Flexibility:

Method: ASTM D522, method B,  
 180° bend, 1/4" mandrel  
 Result: Pass

### Fineness of grind<sup>1</sup>:

Method: Hegman  
 Result: 6 Hegman minimum

### Pencil Hardness:

Method: ASTM D3363  
 Result: B

### Sag Test<sup>1</sup>:

Method: ASTM D4400  
 Result: 8 mils minimum

### Viscosity<sup>1</sup>:

84-90 KU

### Water Resistance:

Method: ASTM D870

Result: Pass

<sup>1</sup> Standard test based on Certificate of Analysis



# INDUSTRIAL ENAMEL HS

## 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/Clean Up** .....Xylene,R2K4

### **Airless Spray**

Pressure ..... 1800 psi  
Hose .....3/8" ID  
Tip ..... .017-.019"  
Filter ..... 60-100 mesh  
Reduction .....As needed up to 3% by volume

**Brush** ..... Natural Bristle  
**Roll**..... 1/4-3/8" lambswool or synthetic cover  
Reduction .....not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.

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, spatters & 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	B54WZ0401	21 320
HOTW	07/25/2017	B54WZ0413	14 328
HOTW	07/25/2017	B54TZ0404	13 316
FRC			