

**Protective
&
Marine
Coatings**

**STEEL SPEC™
FAST DRY ALKYD TOPCOAT**

B55-800 SERIES

APPLICATION BULLETIN

2.19

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mixing Instructions: Mix paint thoroughly to a uniform consistency with low speed power agitation prior to use.

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

Recommended Spreading Rate per coat:

	Minimum		Maximum	
Wet mils (microns)	4.5	112	7.5	188
Dry mils (microns)	3.0	75	5.0	125
~Coverage sq ft/gal (m ² /L)	217	5.3	361	8.8
Theoretical coverage sq ft/gal (m ² /L) @ 1 mil / 25 microns dft	1080	26.5		

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

Drying Schedule @ 5.0 mils wet (125 microns):

	@ 40°F/4.5°C	@ 77°F/25°C 50% RH	@ 100°F/38°C
To touch:	30 minutes	20 minutes	10 minutes
To handle:	15 hours	3-4 hours	2.5 hours
To recoat:	4 hours	1 hour	45 minutes
To cure:	14 days	7 days	4 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.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Xylene, R2K4. Clean tools immediately after use with Xylene, R2K4. Follow manufacturer's safety recommendations when using any solvent.

DISCLAIMER

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.

PERFORMANCE TIPS

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

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.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Xylene, R2K4.

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

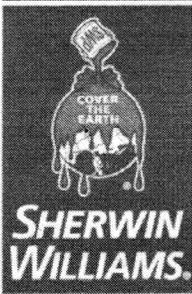
SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

WARRANTY

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.



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Revised 9/12

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SURFACE PREPARATIONS

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.

General 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 good 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/NACE 3, blast clean all surfaces to a nominal profile (2 mils / 50 microns). Remove all weld spatter and round all sharp edges by grinding. Prime 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 (4.5°C) minimum
120°F (49°C) maximum
(air, surface, and material)
At least 5°F (2.8°C) 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 compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up:

Below 80°F (27°C) Xylene, R2K4
Above 80°F (27°C)..... Aromatic Naphtha, R2K5

Airless Spray

Pressure.....3000 psi
Hose.....1/4" ID
Tip.....0.015" – 0.019"
Filter.....60 mesh
Reduction.....Not recommended

Conventional Spray

Gun.....Binks 95
Fluid Nozzle.....63C
Air Nozzle.....63PB
Atomization Pressure.....50 psi
Fluid Pressure.....15-20 psi
Reduction.....As needed up to 10% by volume

Brush

Brush.....Nylon/Polyester or Natural Bristle
Reduction.....Not recommended

Roller

Cover.....3/8" woven with solvent resistant core
Reduction.....Not recommended

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

Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	St 2	St 2	SP 2	-
Rusted	St 3	St 3	SP 3	-
Pitted & Rusted	St 3	St 3	SP 3	-
Power Tool Cleaning	St 3	St 3	SP 3	-
Rusted	St 3	St 3	SP 3	-
Pitted & Rusted	St 3	St 3	SP 3	-

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