



KEM TRANSPORT® ENAMEL

PRODUCT DESCRIPTION

KEM TRANSPORT® Synthetic Enamel was developed specifically to be used as a color coat on all passenger cars and commercial vehicles. KEM TRANSPORT's versatility permits it to be used on all properly prepared substrates used in the manufacture of motor vehicles such as aluminum, fiberglass, steel and zinc-coated surfaces. Where an economical high-gloss finish is a requirement, KEM TRANSPORT® Enamel should be specified. KEM TRANSPORT® meets U.S. National Rule Requirement of 5.0 lbs/gal (599.0 g/l) VOC (volatile organic compound).

TECHNICAL DATA

- | | | | | |
|---|--------------|-------------------------|--|-------------------------------------|
| • Maximum VOC as applied @ 8:2:1 or 4:1 | | | • Spreading rate (unreduced) @ 1 mil dry | 590 sq ft/gal |
| VOC total | 4.80 lbs/gal | 575 g/l | • Flash Point (TOC) | 55-100°F |
| VOC less exempt | 4.99 lbs/gal | 598 g/l | • Pencil hardness after 30 days | B |
| • Viscosity as applied | | | • Salt spray - 200 hours | Less than 1/8" creepage from scribe |
| #4 Ford @ 8:2:1 | | 17-23 seconds | • Humidity - 100 hours | No effect |
| • Air pressure at gun | | 50 psi for solids | • Dielectric Strength (White) | 1780 volts per 1 mil over steel |
| | | 50-70 psi for metallics | • Flexibility after 1 week air dry over a 1/8" conical mandrel | No effect |
| • Recommended dry film thickness | | 2.0-3.0 mils | • Volume Solids sprayable 8:2:1 | 33% |
| • Gloss | 60° | 95 | | |
| | 20° | 90 | | |
| • DOI | | 85 | | |

SURFACE PREPARATION

Bare Substrates: Steel, Galvanized Steel*, Aluminum, or Fiberglass

Note: With the inconsistencies of galvanized steel, consult your local SHERWIN-WILLIAMS Representative for system recommendations and substrate testing.

1. Solvent clean with SHER-WILL-CLEAN® Solvent Cleaner R7-K156 or AQUA-MATE™ Low VOC Surface Cleaner W4-K157 and wipe dry with a clean, dry cloth.
2. Apply 2 - 3 medium coats of G.B.P.® Etching Filler E2-G980/E2-G983 or one double coat of Corrosion Shield™ E2-G973.
3. Apply ULTRA-FILL® Primer-Surfacer P2-A43/P2-N44 as needed. Follow with 4.6 Epoxy Primer PSE-4600/PSE-4601 or JET SEAL® Primer-Sealer E2-A26/E2-R27/E2-A28.

Prepainted Substrates:

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
2. Solvent clean lacquer surfaces with AQUA-MATE™ Low VOC Surface Cleaner W4-K157 or UltraClean® Surface Cleaner R7-K158. Solvent clean enamel surfaces with UltraClean™ Surface Cleaner R7-K158, SHER-WILL-CLEAN® Solvent Cleaner R7-K156, or AQUA-MATE™ Low VOC Surface Cleaner W4-K157. Wipe dry with a clean, dry cloth.
3. Grind off paint and remove all rust. Fill as needed using an appropriate body filler. Allow body filler to tack up and shape as needed.
4. Sand repair area and featheredge using 80, 180, 280, and finish with 320 grit treated sandpaper on a random orbital sander. Use AQUA-MATE™ or UltraClean® to remove sanding residue.
5. Apply 2-3 medium coats of G.B.P.® Etching Filler E2-G980/E2-G983 to bare metal and body filler. *Optional*, treat bare steel areas with MET-L-ETCH® Steel Cleaner W4-K288 followed by MET-L-MATE® Phosphate Conversion Coating W4-K289. Treat bare aluminum with DUAL-ETCH® Metal Cleaner and Conditioner W4-K263.
6. Apply ULTRA-FILL® Primer-Surfacer P2-A43/P2-N44 as needed and block sand with 180 followed by 280 grit treated sandpaper.
7. Finish sand repair area with 320 grit treated sandpaper on a random orbital sander.
8. If sealing is required, use 4.6 Epoxy Primer or JET SEAL® Sealer.

(For the above products refer to the appropriate product label or data page for complete information.)

MIXING

1. Stir or shake KEM TRANSPORT® Enamel color thoroughly before mixing.
2. **With Hardener:**
Mix by volume **8** parts KEM TRANSPORT® Enamel color to **2** parts Reducer R4-K179, R4-K6179, R4-K183, R4-K6183, stir, then add **1** part Hardener V6-V252.
Without Hardener:
Mix by volume **4** parts KEM TRANSPORT® Enamel color to **1** part Reducer R4-K179, R4-K6179, R4-K183, or R4-K6183.

APPLICATION

1. Adjust air pressure at the gun to 50-70 psi (5-10 psi pot pressure).
2. Apply 2-3 medium wet coats at a gun distance of 8-10 inches, allowing each coat to become hand slick before next coat. To uniform metallic colors, immediately apply a mist coat by increasing the gun distance to **10 - 12** inches.

DRYING SCHEDULE

Air Dry Times @ 77°F, 50% RH

	With Hardener	Without Hardener
Tack Free	4 hours	6 hours
Tape Free	12 hours	16 hours

Force Dry Times (metal temperature)

120°F	3 1/2 hours	5 hours
140°F	2 hours	3 hours
160°F	1 1/4 hours	2 hours

Note: Refer to the vehicle manufacturer for maximum allowable force dry temperature of vehicle.

RECOATING

KEM TRANSPORT Enamel when used with V6-V252 hardener can be recoated after 24 to 36 hours. When KEM TRANSPORT Enamel is used without hardener, it must be thoroughly dried and cured before recoating.

NOTES

1. Pressure-sensitive decals may be applied after overnight drying to 72 hours. After 72 hours, for proper adhesion, scuff sand with 320 grit or fine treated sandpaper or a nylon scuff pad.

PRODUCT AT-A-GLANCE

PRODUCT

KEM TRANSPORT® ENAMEL

USE

- For use as a color coat on all passenger cars and commercial vehicle.
- For an economical high gloss finish.

SUITABLE SUBSTRATES

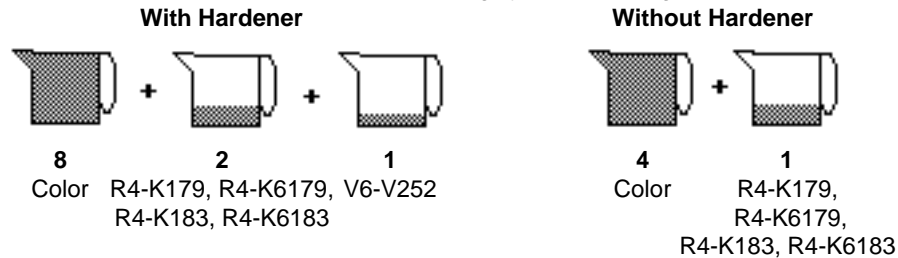
- OEM Enamels
- OEM Lacquers
- Refinish Enamels
- Refinish Lacquers
- G.B.P.® Etching Filler
- SuperCOMBO® Primer-Surfacer
- 4.6 Epoxy Primer
- ULTRA-FILL® Primer-Surfacer
- JET-SEAL Primer-Sealer

SURFACE PREPARATION

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- Solvent clean with the appropriate solvent cleaner, and wipe dry with a clean cloth.
- Grind repair area to remove paint and all rust as needed.
- Apply body filler to clean bare metal as needed.
- Sand all areas to be refinished and feather edge all broken film areas.
- Treat bare metal with an appropriate metal conditioner or etching primer.
- Surface with ULTRA-FILL® Primer-Surfacer. Finish sand with 320 grit sandpaper.
- Seal with JET SEAL® Primer-Sealer.

MIXING

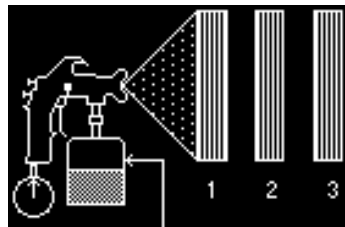
Stir or shake KEM TRANSPORT® color thoroughly before mixing:



APPLICATION

Siphon Feed

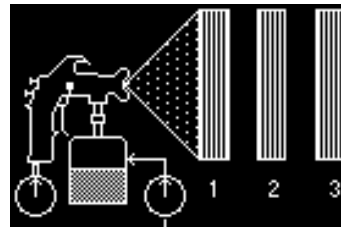
Apply 2-3 medium wet double coats.
Allow each coat to become hand slick.



50-70 psi
pot life: **6** hours with hardener

Pressure Feed

Apply 2-3 medium wet double coats.



50-70 psi
pot pressure - **5-10 psi**
pot life: **6** hours with hardener

Time to Recoat

Anytime



RECOAT

- Pressure-sensitive decals may be applied after overnight drying to 72 hours. After 72 hours, for proper adhesion, scuff sand with 320 grit or fine treated sandpaper or a nylon scuff pad.

NOTES

- Use V6-V252 Hardener to prevent wrinkling in hot/humid conditions.
- To improve flow and leveling, add up to 2 ounces of Universal Retarder R7-K6251 per sprayable quart.
- If fisheyes are a problem, add up to 1/2 ounce of The LEVELER® Silicone Additive V3-K780 per sprayable gallon of KEM TRANSPORT® color with hardener or 1-2 drops of SILA-CHECK® Silicone Additive V3-K265 per sprayable gallon of color without hardener.

PERSONAL PROTECTION J3

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety goggles, coveralls, and latex gloves when using product.

To learn more about Sherwin-Williams Automotive products, visit our Web site at www.sherwin-automotive.com.