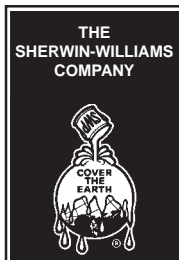


*Industrial
and
Marine
Coatings*

METALASTIC® DTM
ACRYLIC MODIFIED ENAMEL

B55Z-600 SERIES

INDUSTRIAL & MARINE COATINGS		PRODUCT INFORMATION		Revised 7/03																				
PRODUCT DESCRIPTION		RECOMMENDED USES																						
<p>METALASTIC DTM is a VOC compliant, high-build acrylic modified enamel with rust-inhibitive properties for application directly to bare steel. Provides an economical alternative to many maintenance and new construction projects.</p> <ul style="list-style-type: none"> • VOC compliant • Good gloss and color retention • Corrosion resistance and finish coat protection in one coat • Outstanding long term performance • 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 • Machinery • Structural steel • Steel doors • Steel decking • Primer / finish • Repaints • Storage tank exteriors • Bar joists • Piping • Conveyors 																						
PRODUCT CHARACTERISTICS		PERFORMANCE CHARACTERISTICS																						
<p>Finish: Semi-Gloss</p> <p>Color: Wide range of colors available</p> <p>Volume Solids: 59% ± 2%, may vary by color Ultra White</p> <p>Weight Solids: 76% ± 2%, may vary by color Ultra White</p> <p>VOC (EPA Method 24): Unreduced: 321 g/L; 2.67 lb/gal Ultra White Reduced 3½%: 340 g/L; 2.8 lb/gal</p> <p>Recommended Spreading Rate per coat: Wet mils: 5.0 - 8.0 Dry mils: 3.0 - 5.0 Coverage: 190 - 315 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 @ 7.0 mils wet @ 50% RH:</p> <table border="1"> <thead> <tr> <th></th> <th>@ 40°F</th> <th>@ 77°F</th> <th>@ 120°F</th> </tr> </thead> <tbody> <tr> <td>To touch:</td> <td>3 hours</td> <td>1½ hours</td> <td>45 minutes</td> </tr> <tr> <td>To handle:</td> <td>10 hours</td> <td>6 hours</td> <td>1 hour</td> </tr> <tr> <td>To recoat:</td> <td>36 hours</td> <td>18 hours</td> <td>6 hours</td> </tr> <tr> <td>To cure:</td> <td>14 days</td> <td>7 days</td> <td>7 days</td> </tr> </tbody> </table> <p>Drying time is temperature, humidity and film thickness dependent.</p> <p>Shelf Life: 36 months, unopened Store indoors at 40°F to 100°F.</p> <p>Flash Point: 120°F, PMCC</p> <p>Reducer/Clean Up: Below 80°F: VM&P Naphtha, R1K3 Above 80°F: Hi-Flash Naphtha, R2K5</p>			@ 40°F	@ 77°F	@ 120°F	To touch:	3 hours	1½ hours	45 minutes	To handle:	10 hours	6 hours	1 hour	To recoat:	36 hours	18 hours	6 hours	To cure:	14 days	7 days	7 days	<p>System Tested: (unless otherwise indicated) Substrate: Steel Surface Preparation: SSPC-SP6 Finish: 2 cts. Metalastic DTM @ 3.0 mils dft/ct</p> <p>Abrasion Resistance: Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load Result: 50 mg loss</p> <p>Adhesion: Method: ASTM D4541 Result: 420 psi Method: ASTM D3359 Result: 5B</p> <p>Corrosion Weathering: Method: ASTM D5894, 2 cycles, 672 hours Result: Rating 10 per ASTM D610 for rusting</p> <p>Direct Impact Resistance: Method: ASTM D2794 Result: 50 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, 1000 hours Result: Rating 10 per ASTM D610 for rusting</p> <p>Pencil Hardness: Method: ASTM D3363 Result: 3B</p> <p>Salt Fog Resistance: Method: ASTM B117, 1000 hours Result: Rating 10 per ASTM D610 for rusting</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. Metalastic DTM @ 3.0 - 5.0 mils dft

Steel, Moderate Service:

2 cts. Metalastic DTM @ 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 844 colorants at 100% 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: 11.5 ± 0.2 lb, may vary with color

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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APPLICATION BULLETIN

Revised 7/03

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/Clean Up

Below 80°F VM&P Naphtha, R1K3
Above 80°F Hi-Flash Naphtha, R2K5

Airless Spray

Pressure 2400 psi
Hose 3/8" ID
Tip015"
Filter 60 mesh
Reduction Not recommended

Conventional Spray

Gun Binks 95
Fluid Nozzle 63B
Air Nozzle 63PB
Atomization Pressure ... 50 psi
Fluid Pressure 20-25 psi
Reduction As needed, up to 3½% by volume

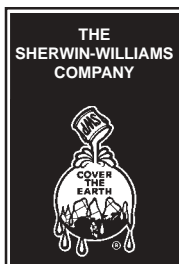
Brush

Brush Natural Bristle
Reduction As needed, up to 3½% by volume

Roller

Cover 3/8" woven with phenolic core
Reduction As needed, up to 3½% by volume

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:	5.0 - 8.0
Dry mils:	3.0 - 5.0
Coverage:	190 - 315 sq ft/gal approximate

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

Drying Schedule @ 7.0 mils wet @ 50% RH:

	@ 40°F	@ 77°F	@ 120°F
To touch:	3 hours	1½ hours	45 minutes
To handle:	10 hours	6 hours	1 hour
To recoat:	36 hours	18 hours	6 hours
To cure:	14 days	7 days	7 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.

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.

Excessive reduction of material 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.

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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