



# Protective & Marine Coatings

# KEM-KROMIK™ 255 ALKYD PROTECTIVE GLOSS FINISH

FORMERLY KNOWN AS SHERWIN M255

Revised 03/2020 Issue 2

## PRODUCT INFORMATION

### PRODUCT DESCRIPTION

A single pack quick drying acrylic modified alkyd anti-corrosive protective gloss finish.

### RECOMMENDED USE

As a single coat shop applied protective finish for structural steel that will not normally require further site coats. Suitable for use as a single coat system on internal or external steel.

### RECOMMENDED APPLICATION METHODS

Airless Spray  
Brush ( for small areas and touch up only )

Recommended Cleanser/Thinner: No 2

### PRODUCT CHARACTERISTICS

Flash Point: 25°C

% Solids by Volume: 54 ± 3% ASTM-D2697-03(2014)

Colour Availability: Full range

#### VOC

412 gms/litre determined practically in accordance with UK Regulations PG6/23  
433 gms/litre calculated from formulation to satisfy EC Solvent Emissions Directive  
347 gms/kilo content by weight from formulation, to satisfy EC Solvent Emissions Directive

### TYPICAL THICKNESS

Dry film thickness	Wet film thickness	Theoretical coverage
100 microns	185 microns	5.4 m <sup>2</sup> /ltr*

\* This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

### PRACTICAL APPLICATION RATES - MICRONS PER COAT

	Airless Spray	Brush
Dry	100*	100
Wet	185	185

\* Maximum sag tolerance with overlap typically 231µm wet (125µm dry) by airless spray

### AVERAGE DRYING TIMES

	@ 5°C	@ 15°C	@ 23°C
To touch:	90 minutes	1 hour	30 minutes
To handle:	30 hours	24 hours	8 hours

*These figures are given as a guide only. Factors such as air movement and humidity must also be considered.*

### RECOMMENDED PRIMERS / TOPCOATS

Not normally required but may be overcoated with a wide range of materials - refer to notes on overcoating overleaf.

For self overcoating, a minimum period of 24 hours is recommended between coats of Kem-Kromik 255.

### PACKAGE

Single component material

Pack Size: 200 litre, 20 litre and 5 litre units

Weight: 1.26 kg/litre (may vary with shade).

Shelf Life: 2 years from date of manufacture or 'Use By' date where specified.



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### **SURFACE PREPARATION**

Blast clean to Sa2½ BS EN ISO 8501-1:2007. Average surface profile in the range 50-75 microns. Ensure surfaces to be coated are clean, dry and free from all surface contamination.

### **APPLICATION EQUIPMENT**

#### **Airless Spray**

Nozzle Size: 0.38mm (13 thou)  
Fan Angle: 60°  
Operating Pressure: 170kg/cm<sup>2</sup>  
(2400 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent with satisfactory atomisation. As conditions will vary from job to job, it is the applicators' responsibility to ensure that the equipment in use has been set up to give the best results. If in doubt Sherwin-Williams should be consulted.

#### **Brush**

The material is suitable for brush application to small areas only.

### **APPLICATION CONDITIONS AND OVERCOATING**

**The material has a critical overcoating time and wrinkling could occur when overcoated in the time interval of 6 - 24 hours after the first coat, depending on film thickness and ambient conditions.**

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, ie 80-85% good ventilation conditions are essential. Substrate temperature shall be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

Application at ambient air temperatures below 5°C is not recommended.

If it is desired to overcoat outside the times stated on the data sheet, please seek advice of Sherwin-Williams.

### **ADDITIONAL NOTES**

Any skin that may form on the surface of the paint in the container should be removed carefully to avoid the necessity of sieving the paint.

Numerical values quoted for physical data may vary slightly from batch to batch.

Certain shades for example, yellows, oranges and reds may require additional coats to achieve full opacity.

### **HEALTH AND SAFETY**

Consult Product Health and Safety Data Sheet for information on safe storage, handling and application of this product.

### **WARRANTY**

Any person or company using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk, and Sherwin-Williams can accept no liability for the performance of the product, or for any loss or damage arising out of such use.

The information detailed in this Data Sheet is liable to modification from time to time in the light of experience and of normal product development, and before using, customers are advised to check with Sherwin-Williams, quoting the reference number, to ensure that they possess the latest issue.