



KEM-KROMIK™ 6630 PRIMER

1-PACK SURFACE TOLERANT SYNTHETIC RESIN PRIMER

Revised 09/2023 Issue 2

PRODUCT DESCRIPTION

A surface tolerant oxidative drying high build alkyd primer pigmented with zinc phosphate.
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

- Excellent corrosion protection even in chemically aggressive atmosphere
- Good corrosion protection even on manually prepared surfaces
- No brittleness due to an unique binder combination

RECOMMENDED USE

Can be used as a weather resistant, high build primer on steel and manually prepared surfaces in rural, industrial and marine atmosphere e.g. pipelines, bridges, metal claddings, roofs, lattice masts, street lights, wall- and ceiling cladding, outside protection of silos.
Not suitable for windows and doors.

PRODUCT TECHNICAL DATA

Volume Solids:	62 ± 2% (ISO 3233-3)
Weight Solids:	79 ± 2%
VOC:	315 g/l determined practically in accordance with Protective Coatings Directive of German Paint Industry Association (VdL-RL 04). 328 g/l calculated from formulation to satisfy EC Solvent Emissions Directive. 219 g/kg calculated from formulation to satisfy EC Solvent Emissions Directive (UK).
Colours:	Sand-yellow, redbrown.
Flash Point:	40°C.
Cleaner/Thinner:	Thinner B (for cleaning). Thinner B for thinning with max. 3% to adapt the viscosity. Thinning will affect VOC compliance, sag tolerance and dry film thicknesses.
Pack Size:	Single component material: 15 kg (10 litre). Volume will vary with colours and density.
Density:	1.5 kg/l (may vary with colours).
Shelf Life:	2 years from date of manufacture, stored in originally sealed containers in a cool and dry environment.

Recommended Application Methods:
Airless Spray, Conventional Spray, Brush and Roller

Typical Thickness:

	Recommended Spreading Rate Per Coat	
	Typical	Maximum Sag
Dry	80 µm	240 µm
Wet	129 µm	387 µm
Theoretical Consumption*	0.194 kg/m ² 0.129 l/m ²	
Theoretical Coverage*	5.17 m ² /kg 7.75 m ² /l	

* 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.

Apart from small areas the dry film thickness of Kem-Kromik™ 6630 Primer should not exceed 240 µm per coat.



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AVERAGE DRYING TIMES

For 80 µm Dry Film Thickness:

	+ 20°C
Dust-dry	4-5 hours
Dry to touch	8-10 hours
To Recoat	24 hours

Maximum recoat time is 6 months. Prior to further applications all contamination must be removed. In the case of extended recoating times consult Sherwin Williams customer service.

Final cure: 1 week, depending on film thickness and temperature.

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

SURFACE PREPARATION

Ensure surfaces to be coated are clean, dry and free from all surface contamination such as oil, grease, dirt and corrosion products to achieve satisfactory adhesion.

For contaminated and weathered surfaces e.g. primed areas we recommend to clean with Cleaner Wash.

Steel surfaces shall be blast-cleaned to Sa 2½ according to ISO 8501-1 (ISO 12944-4)

Manually prepared surfaces shall be prepared by wire brush, trowel, power tool to surface preparation grade St 2 resp. St 3 according to ISO 8501-1 (ISO 12944-4).

Maintenance coatings: In case of well adhering old coating systems, careful cleaning is sufficient. Loose particles must be removed, corroded and defective areas must be prepared to PSa 2½, PMa or PSt 2 and patch-primed with Kem-Kromik™ 6630 Primer.

MIXING

The material is supplied ready for use; stir thoroughly with a mechanical paint mixer prior to application.

During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothings.

APPLICATION CONDITIONS

Substrate temperature shall be above + 5°C and at least 3°C above the dew point.

Material temperature shall be above + 5°C.

Relative air humidity shall be below 85%.

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for satisfactory application characteristics. Always purge spray equipment before use with listed cleaner. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Airless Spray

Tip Size: 0.38 – 0.53 mm (0.015 – 0.021 inch)

Fan Angle: 65° - 80°

Operating Pressure: min. 180 bar (2600 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 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 consult Sherwin-Williams customer service.

Conventional Spray

Atomising Pressure: 3 - 5 bar (43 - 72 psi)

Tip Size: 1.7 – 2.5 mm (0.06 – 0.10 inch)

Brush and Roller

Brush and roller application is suitable.

As a good wetting and penetration into the substrate is essential for the efficiency of the priming coat, the best result is achieved by using a distemper brush or similar.



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RECOMMENDED SYSTEMS

Steel, blast-cleaned to Sa 2½

1 x Kem-Kromik™ 6630 Primer
1-2 x Kem-Kromik™ 6630 High Solid

Steel, manually prepared

1 x Kem-Kromik™ 6630 Primer or Kem-Kromik™ Aktivprimer Rapid
2 x Kem-Kromik™ 6630 High Solid

Maintenance coating on steel

Touch up with Kem-Kromik™ 6630 Primer or Kem-Kromik™ Aktivprimer Rapid
2 x Kem-Kromik™ 6630 High Solid

ADDITIONAL NOTES

Drying times and curing times should be considered as a guide only.

Chemical resistance:

Resistance to rural, urban, industrial and marine atmosphere and temporarily exposure to neutral salts.

Not resistant to continuous exposure to diluted acids and alkalis, fatty oils, fuels, mineral oils etc. Temporarily short-term exposure does not harm. Not suitable for continuous exposure to liquids (including water).

Temperature resistance:

Dry heat up to + 80°C.

In case of higher temperatures consult Sherwin-Williams customer service.

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

HEALTH & SAFETY

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

WARRANTY

Whilst all statements made about our products (whether in this data sheet or otherwise) are correct and accurate to the best of our knowledge, we have no control over the quality or the condition of the substrate, the application conditions or the many other factors affecting your use and application of our product.

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