Protective & Marine Coatings
PRODUCT DATA SHEET

KEM-KROMIK™ 6630 M

1-PACK HIGH BUILD SYNTHETIC RESIN COAT

Revised 07/2023 Issue 1

PRODUCT DESCRIPTION

A low solvent containing coating material based on a synthetic resin combination binder with active pigments and micaceous iron oxide pigments.
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

- Good wetting ability resulting in good adhesion to metal surfaces and old coatings
- Good covering of edges, no additional stripe coats necessary
- Highly resistant to chalking, colour fast
- Excellent resistance to weather and aggressive industrial atmosphere
- Resistant to rain and dew after few hours

RECOMMENDED USE

Can be used as a weather resistant, robust, high build coating on steel and galvanized steel, for corrosion protection of lattice masts, transformer stations and similar structures.
Particularly suited as refresher coat on old 1-pack paints.

PRODUCT TECHNICAL DATA

Volume Solids: 60 ± 2% (ISO 3233-3)

Weight Solids: 78 ± 2%

VOC: 330 g/l determined practically in accordance with Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).
384 g/l calculated from formulation to satisfy EC Solvent Emissions Directive.
256 g/kg calculated from formulation to satisfy EC Solvent Emissions Directive (UK).

Colours: DB 601 (MIO), DB 701 (MIO), olive green.
Slight colour deviations are possible due to raw material characteristics.

Flash Point: 40°C.

Cleaner/Thinner: Thinner B (for cleaning).
Thinner B for thinning with max. 5% 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	120 µm	240 µm
Wet	200 µm	400 µm
Theoretical Consumption*	0.300 kg/m² 0.200 l/m²	
Theoretical Coverage*	3.33 m²/kg 5.00 m²/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.

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AVERAGE DRYING TIMES

Recoat intervals (at + 20°C):

Minimum: 1 day.

In the case of overcoating with paint containing aromatic solvents minimum recoat time is 3 weeks.

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.

Hot-dip galvanized surfaces shall be prepared by degreasing. Rusty areas must be thoroughly prepared and patch primed with Kem-Kromik™ 6630 M.

Maintenance coatings: Thorough cleaning of well adhering paint coats is sufficient.

All loose particles must be removed.

Corroded steel to be wire-brushed to St 2 according to ISO 8501-1 (ISO 12944-4) 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 – 0.66 mm (0.015 – 0.025 inch)

Fan Angle: 40° - 60°

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 - 4 bar (43 - 58 psi)

Tip Size: 1.7 – 2.5 mm (0.06 – 0.08 inch)

Brush and Roller

Brush and roller application is suitable.

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RECOMMENDED SYSTEMS

Hot-dip galvanized surfaces
1-2 x Kem-Kromik™ 6630 M

Maintenance coating for galvanized surfaces
Patch up with Kem-Kromik™ 6630 M
1 x Kem-Kromik™ 6630 M

Maintenance coating for steel
Patch up with Kem-Kromik™ 6630 Primer
2 x Kem-Kromik™ 6630 M

ADDITIONAL NOTES

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

Chemical resistance:
Resistant to all types of weather, acidic and alkaline industrial atmospheres.
Short-term exposure to seawater, sodium chloride, diluted acids and alkalis, like hydrochloric acid, formic acid, acetic acid and caustic soda.

Not resistant to permanent exposure to alcohol, fatty oils, fuels, mineral oils etc. Occasional splashes or spillage, however, are harmless.
In case of permanent exposure to liquids (also water), the product may not be used.

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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