



Protective & Marine Coatings

SHERWIN™ M671 ALKYD UNDERCOAT

FORMERLY KNOWN AS LEIGHS M671

Revised 04/2016 Issue 11

PRODUCT INFORMATION

PRODUCT DESCRIPTION

A conventional quick drying undercoat/tiecoat

RECOMMENDED USE

A high quality undercoat/tiecoat developed for marine use on above waterline areas but also suitable for normal interior and exterior use.
May also be used as a wood primer for interior or exterior use (see Additional Notes overleaf).

ENDORSEMENTS

BS476 Part 7 - Surface Spread of Flame Material - for details of substrate/scheme, consult Sherwin-Williams.

RECOMMENDED APPLICATION METHODS

Airless Spray
Conventional Spray
Brush
Roller

Recommended Cleanser/Thinner: No 1

PRODUCT CHARACTERISTICS

Flash Point: 39°C

% Solids by Volume: 52 ± 3% (ASTM-D2697-91)

Colour Availability: White and suitable range of undercoat shades

VOC

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

TYPICAL THICKNESS

Dry film thickness	Wet film thickness	Theoretical coverage
35 microns	67 microns	14.9 m ² /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	Conventional Spray	Brush	Roller
Dry	55	50	35	35
Wet	105	101	67	67

* Maximum sag tolerance typically 163µm wet (85µm dry) by airless spray. The conventional spray details relate to the paint after 5% thinning with Cleanser/Thinner No. 1

AVERAGE DRYING TIMES

	@ 15°C	@ 23°C
To touch:	2½ hours	1½ hours
To recoat:	7 hours	4 hours
To handle:	24 hours	16 hours

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

RECOMMENDED PRIMERS / TOPCOATS

Sherwin M155 Alkyd Primer
Sherwin M671 Undercoat can be overcoated with a wide range of white spirit based finishes.

PACKAGE

Single component material

Pack Size: 20 litre and 5 litre units

Weight: 1.59 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

Ensure surfaces to be coated are clean, dry and free from all surface contamination.

APPLICATION EQUIPMENT

Airless Spray

Nozzle Size: 0.38-0.46mm (15-18 thou)

Fan Angle: 80°

Operating Pressure: 140kg/cm² (2000 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.

Conventional Spray

Nozzle Size 1.27mm (0.050 thou)

Atomising Pressure 3.5kg/cm² (50 psi)

Fluid Pressure 0.7kg/cm² (10 psi)

The details of atomising pressure, fluid pressure and nozzle size are given as a guide. It may be found that slight variations of pressure will provide optimum atomisation in some circumstances according to the set up in use. Atomising air pressure depends on the air cap in use and the fluid pressure depends on the length of line and direction of feed i.e. horizontal or vertical.

Brush

The material is suitable for brush application. Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.

Roller

The material is suitable for roller application. Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.

APPLICATION CONDITIONS AND OVERCOATING

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.

When used as a primer onto bare wood, the product should be thinned 10% with Cleanser Thinner No. 1 to improve surface wetting and penetration.

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

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.