

FLEETtech®

Water Reducible Enamel

PRODUCT CODES: KB15-44734 – Mega White | KB95-40573 – Gloss Black

DESCRIPTION: A premium high quality Water Reducible enamel coating. This product exhibits excellent gloss retention, weathering, adhesion, corrosion, and water-resistant properties. This product can be used to coat properly prepared ferrous and some non-ferrous metals. Designed for the Waste Equipment market and Tank manufacturers. These products offer very good one coat protection with proper metal cleaning.

PHYSICAL PROPERTIES: General System – see TDS/SDS for specific values per product

Weight Solids: 25%-40%
Volume Solids: 22% to 32%
Resin Type: W/R Alkyd
Gloss 60°: 90+
Theoretical Coverage: 350-520 square feet at 1.0 mil
Weight per Gallon: 8.3-10 pounds
Viscosity @ 77°F: 75-95 KU / 700-1290 Centipoise
EPA VOC: 2.8 - 3.5 pounds per gallon
Actual VOC: 1.1 – 1.7 pounds per gallon
Flash Point °F: > 200°F

SURFACE PREPARATION: Product can be applied direct to metal or over a primer. Service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminants, including salt deposits.

For optimum adhesion and corrosion resistance, Water Reducible Enamels may be spray applied over steel and other properly prepared substrates. Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing. Aluminum and galvanized should be cleaned with appropriate metal cleaners and conditioners, including a vinyl wash primer like LE-6245 Wash Primer. For optimum adhesion hot rolled steel should have the mill scale removed by an abrasive blast to SSPC-SP-6 (To an average profile of 1.5 mils) and then coated before flash rusting occurs. For long-term corrosion protection, a primer is recommended.

PRIMERS: QB Series primers as well as coordinating QL series primers are available.

APPLICATION: This product has been formulated to be applied directly without reduction. If, however, reducer is needed because of low temperatures or for final viscosity adjustments, water of up to 10% by volume is recommended. Always start with the minimum amount of reducer approximately 5% by volume and add more if needed. Do NOT apply if air or metal temperatures are below 45°F.

For Hot or Humid conditions, Use up to 10% of N-8001 or a blend of 50/50 N-8001 and N-8004 reducers.

Conventional Air: Tank Air 10-40 psi, fluid air 10-20 psi
Airless: 30 psi air = 900psi fluid pressure, 60 psi air = 1800psi fluid pressure. Tip size 011" = .013
Air Assisted Airless: 400 – 800 psi fluid - atomizing air 15-40 psi, tip size .011" = .013"

Dry Film Thickness: For best results, dry film thicknesses should be 1.0 to 3.0 mils above surface profile. This will require wet film thicknesses of about 4.0 to 6.0 mils. Apply in two medium build coats. Second coat at tack free or up to approximately 8 hours. After 8 hours apply a small test patch to check for evidence of lifting before proceeding with a full recoat. After 24-72 hrs. Do not scuff or sand the top coated surface, just clean the painted surface, and apply a tack coat of primer, let flash until dry to touch, then topcoat as usual. Sag resistance: 6+ mils WFT (topcoat only) or 8+ WFT over primer

DRY TIMES: FLEETtech will typically dry to set to touch in 30-45 minutes and to tack free in 90-120 minutes. Dry Through times typically 2-3 hours. FLEETtech can be recoated at tack free and up to 8 hours. When recoating after **force drying**, scuff sanding may be required to ensure inter-coat adhesion. FLEETtech may be force dried 10 – 20 minutes @ 150-165°F

CLEAN UP: Use Water or water mixed with N-8001 solvent to flush lines. Dried paint may require MEK or stronger flush solvents, do not use to flush guns and lines without first using water/ N-8001 mix.

PERFORMANCE: Typical, tested on B-1000 panels .
 Salt Spray: ASTM B117 200 hours <4 mm creepage DTM
 ASTM B117 500 hours <3 mm creepage over primer
 QUV A: 1000 hours >85% retention @ 60°
 Adhesion: ASTM D3059 4B

SAFETY PRECAUTIONS: Use proper NIOSH respiratory protection. Refer to SDS for specific information. All information subject to change without notice