

FLEETdry® ICS Fleet Dry Alkyd Enamel Tint Bases

PRODUCT CODES: IB-0562 – Clear Base | IB-1560 – White Base | IB-1561 – Deep Base | IB-2563 – Metallic Base

DESCRIPTION: ICS Fleet Dry Alkyd Enamel was developed as a fast drying, versatile, industrial finishing enamel for manufacturers of metal products. This enamel offers a quick dry time, high gloss, and good color and gloss retention. ICS Fleet Dry Alkyd Enamel is ideal for industrial OEM uses, including agricultural and construction equipment.

PHYSICAL PROPERTIES:

Weight Solids: 39%
Volume Solids: 33%
Resin Type: Alkyd
Gloss: 90+ at 60°
Theoretical Coverage: 523 square feet at 1.0 mil
Weight per Gallon: 8.0 pounds
Viscosity: #2 Zahn – 47 to 52 seconds – 60 KU at 77°F
#3 Zahn – 18 to 21 seconds – 60 KU at 77°F
EPA VOC: 4.8 pounds per gallon

SURFACE PREPARATION: The 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, 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.

Steel: ICS Fleet Dry Alkyd Enamel may be applied over steel and other properly prepared substrates. Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing.
Aluminum/Galvanized: Aluminum and galvanized should be treated with appropriate metal cleaners and conditioners, including a vinyl wash primer or acrylic latex primer.

REDUCTION: ICS Fleet Dry Alkyd Enamel may be reduced with most aromatic solvents. Xylene (N-3023) is the recommended “fast” reducer for application in cooler temperatures. D-100 (N-3065) can be used as a “slow” reducer to help the applied coating flow during warmer conditions.

APPLICATION: ICS Fleet Dry Alkyd Enamel may be used for one-coat, direct to metal applications; however a primer is required for long term corrosion protection. N-7019 Urethane Hardener can be used 8A:1B for enhanced cure, gloss, and abrasion resistance. A 15 minute induction period is required before thinning. The pot life will be approximately 24 hours. If a hardener is used, ICS Fleet Dry Alkyd Enamel must be applied over a primer.

Airless: For airless or air-assist airless application, apply ICS Fleet Dry Enamel without reduction or reduced up to 15% by volume. Airless tip sizes should be in the .011 to .015 range.
Conventional Air: For air spray or conventional reduce approximately 20% to 30% by volume. Viscosity should be in the 18 to 30 second range - #2 Zahn cup.
Dry Film Thickness: Dry film thicknesses required are 1.0 to 3.0 mils above profile in a minimum of two full wet coats. Recoat 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.

- DRY TIMES:** ICS Fleet Dry Alkyd Enamel will dry to handle in about 30 to 60 minutes depending on film thickness, humidity, temperature, and air movement. Dry through times may take several days or more. Full adhesion may be gained after 4 to 7 days drying time. Always check for evidence of lifting before proceeding with a full recoat. Lifting will typically occur between 8 to 48 hours.
- CLEAN UP:** Use xylol to flush paint lines. N-9000 Gun Cleaner can be used for removing dried coatings.
- PERFORMANCE:** Typical, tested on B-1000 panels at 1.0 to 1.5 mils DFT (white or black)
- Iowa Exposure: After one year facing south at a 60° angle - less than 10% loss of gloss at 60°.
- SAFETY PRECAUTIONS:** Contains aromatic solvents. Vapor and spray mist harmful. Use proper respiratory protection. Refer to SDS for specific information. All information subject to change without notice