Diamond Vogel | INDUSTRIAL COATINGS

TECHNICAL DATA SHEET

Product Description: ICS Fleet Acrylic Enamel Tint Bases

PRODUCT CODES: **IC-0535 – Clear Base | IC-1531 – White Base | IC-1533 – Deep Base | IC-2537 – Metallic Base IC-3532 – Yellow Base | IC-5529 – Red Base**

DESCRIPTION: ICS Fleet Acrylic Enamel was specifically developed for original equipment manufacturers that desire a single component acrylic coating system. It offer good long term color and gloss retention. Application benefits include very quick dry times and high initial gloss. There are a wide range of stock colors available along with complete color flexibility in the Industrial Color System.

PHYSICAL PROPERTIES:

Weight Solids:	40% to 52%
Volume Solids:	34% to 36%
Resin Type:	Acrylic Modified Alkyd
Gloss:	Full
Theoretical Coverage:	575 square feet at 1.0 mil
Weight per Gallon:	8.0 to 9.6 pounds
Viscosity:	#2 Zahn – 45 to 48 seconds – 60 KU at 77ºF #3 Zahn – 17 to 19 seconds – 60 KU at 77ºF
EPA VOC:	4.8 pounds per gallon

SURFACE PREPARATION: The service expectancy of a coating system 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. Fleet acrylic enamels should always be applied over a primed substrate. Recommended primer systems would be the single component EPEC or the two component Stratum urethane primer system. 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 be coated before flash rusting occurs.

Steel: Bare steel areas should be treated with iron phosphate conversion coatings with adequate rinsing.

Aluminum/Galvanized: Aluminum or galvanizing should be treated with appropriate metal cleaners and conditioners, including a vinyl wash primer.

REDUCTION: Three Fleet Acrylic reducers are available; N-9059 Fast Reducer for use when temperatures are below 70°F, N-9070 Medium Reducer 70° to 90° F, and N-9090 90°+ F. When painting large equipment, always start with N-9090 to reduce the chance of dry overspray. ICS Fleet Acrylic Enamel can be used with or without a urethane hardener. For enhanced cure, gloss and abrasion resistance the use of N-7019 Urethane Hardener is recommended at an 8A:1B ratio, or one pint per gallon. A 15 minute induction time is required before thinning. The pot life will be approximately 24 hours. Always use over a primed surface.

APPLICATION:

Airless: Airless tip sizes should be in range of .011 to .015 max. A minimum of two full wet coats at 5.0 to 6.0 mils will be required to reach the recommended dry film thickness of 1.0 to 2.0 mils. Adjust pressures accordingly for best atomization and transfer efficiencies.

Conventional Air: Air-assist airless pressures will need to be set in the 800 to 1,000 pound range for fluid, and 30 to 50 pound range for atomizing air. Keep the atomizing air as low as possible to prevent air entrapment and pinholing. In-line paint heaters should be set around 120°F.

DRY TIMES: Recoat at tack free 15 to 30 minutes. Dry through times will be about 8 hours. ICS Fleet Acrylic Enamel can be force dried for 30 minutes at 140°F. Check for evidence of lifting between 8 to 72 hours. Surface should be sanded for recoating after 3 days. Do not apply at temperatures below 40° F.

ICS Fleet Acrylic Enamel Tint Bases

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.
QUV: ASTM D4587 – 500+ hours – Good

SAFETY PRECAUTIONS: Contains aromatic solvents. Vapor and spray mist harmful. Use proper respiratory protection. Important: Product may be mixed with other components. Mixture will have hazards of both components, so please follow all precautions. All information subject to change without notice. Refer to SDS for specific information.

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