

**Product Description: ICS Water Reducible Acrylic Enamel Tint Bases**

**PRODUCT CODES:** KC-0636 – Clear Base | KC-1634 – White Base | KC-1635 – Deep Base

**DESCRIPTION:** ICS Water Reducible Acrylic Enamel is a fast drying, versatile, water reducible industrial finishing enamel for manufacturers of metal products. It offers a quick dry time and good color and gloss retention

**PHYSICAL PROPERTIES:**

Weight Solids: 36% to 45%  
Volume Solids: 32% to 35%  
Resin Type: Acrylic Emulsion  
Gloss: 80+ at 60°  
Theoretical Coverage: 520 to 560 square feet at 1.0 mil  
Weight per Gallon: 8.0 to 10.0 pounds  
Viscosity: 65 KU at 77°F  
EPA VOC: 2.9 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. QB-0505, QB-5506, or acrylic primers are the recommended primers. Quantum primers may also be used. Always use a white primer under yellow, oranges, and reds. Primers must be dry before topcoating.

**Steel:** ICS Water Reducible Acrylic Enamels 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 Water Reducible Acrylic Enamels may be reduced with water sparingly. Do not exceed 5% reduction by volume. Product will atomize easily without reducing.

**APPLICATION:** These ICS Water Reducible Acrylic Enamels may be used for one-coat, direct to metal applications for interior use; however a primer is required for long term corrosion protection  
**Airless:** For airless or air-assist airless application, apply ICS Water Reducible Acrylic Enamels without reduction. Airless tip sizes should be in the .011 to .015 range.  
**Conventional Air:** For air spray or conventional reduce approximately 5% by volume maximum. Viscosity should be in the 25 to 40 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.

**DRY TIMES:** ICS Water Reducible Acrylic Enamels will dry to handle in about 20 minutes depending on film thickness, humidity, temperature, and air movement. Dry through times may take 24 hours or more depending on temperature and humidity. Full adhesion may be gained after 2 to 3 days drying time.

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**CLEAN UP:** Use hot water to flush paint lines

**SAFETY PRECAUTIONS:** Refer to SDS for specific information. All information subject to change without notice