

Water Reducible Alkyd Enamel Series**PRODUCT CODES: KB05-40927**

DESCRIPTION: A premium high quality Water Reducible enamel coating that exhibits excellent gloss retention, weathering, adhesion, corrosion and water resistant properties. Water Reducible Alkyd Enamel Series 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:

Weight Solids: 25% to 40%
Volume Solids: 22% to 32%
Resin Type: Water Reducible Alkyd
Gloss: 90+
Theoretical Coverage: 350 to 520 square feet at 1.0 mil
Weight Per Gallon: 8.30 to 9.50 pounds
Viscosity: #3 Zahn – 30 to 40 seconds at 77°F
EPA VOC: 3.5 pounds per gallon
Actual VOC: 1.6 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. Water Reducible Alkyd Enamels may be spray applied over steel and other properly prepared substrates. 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: Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing.
Aluminum/Galvanized: Aluminum and galvanized should be cleaned with appropriate metal cleaners and conditioners, including a vinyl wash primer like LE-6245 Wash Primer.

PRIMERS:

Recommended primers for this system:

Gray SLX2734-03
Red Oxide SLX2800-01
QL series Epoxy Ester Primers:
New Flash Point Gray Primer
QB05-40745

REDUCTION: Reduction as needed: Up to 5-10% / Vol. if needed.

APPLICATION: This Water Reducible Alkyd Enamel 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** Hot and Humid application, use up to 10% of: N-8001 or a blend of 50/50 N-8001 and N- 8004 Reducers.

Dry Film Thickness:	1.0 to 3.0 mils above profile in a minimum of one or 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.
Conventional Spray: Tank air 10 to 40 psi Fluid air 10 to 20 psi	Airless Spray 30:1 Pump 30 psi air = 900 psi fluid pressure 60 psi air = 1800 psi fluid pressure
Air Assisted Airless: Same as Airless Atomizing Air 15 to 40 psi Tip size .011" to .013"	HVLP Graco Delta Gun Atomizing air 8 to 15 psi Fluid Pressure 15 to 30 psi Cap/Tip 192 to 322/.070
Sag Resistance: 6.0+ mils WFT: (topcoat only) 8.0+ mils WFT (primer/topcoat)	Pass no slump Pass no slump
DRY TIMES: Wet Film Thickness: Dry Film Thickness: Air Dry to Touch: Tack Free: Air Dry to Handle: Recoat:	4.0 to 5.0 mils 1.0 to 1.5 mils 30 to 45 minutes 90 to 120 minutes 60 to 90 minutes 30 minutes
CLEAN UP:	Water if wet / MEK or Butyl Cellosolve if dried.
PERFORMANCE: DFT QUV-UVA: 200 Hour Salt Spray: (w/o primer) 500 Hour Salt Spray: (primed) Pencil Hardness:	Water Reducible Enamel series with and without a primer, tested on B-1000 panels at 1.5 to 2.0 mils > 85% on 60° Gloss < 125° - 3.17 mils scribe creepage Pass over primer – 3.0 mils DFT 4B
SAFETY PRECAUTIONS:	Use proper NIOSH respiratory protection Refer to SDS for specific information.