



### 3.5 VOC Workhorse Finishing Enamel

**PRODUCT CODES:** IB15-41392 White Base | IB15-41393 Deep Base | IB05-41394 Clear Base | IB25-41395 Coarse Metallic Base | IB35-41403 Yellow Base | IB55-41401 Red Base

**DESCRIPTION:** This 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. It is ideal for industrial OEM uses, including agricultural and construction equipment. Regulatory benefits include very low levels of VOC and Hazardous Air Pollutant Solvents.

**PHYSICAL PROPERTIES:**

Weight Solids: 52% to 61%  
Volume Solids: 43% to 45%  
Resin Type: Modified Alkyd  
Gloss: 90+ at 60°  
Theoretical Coverage: 700 to 730 square feet at 1.0 mil  
Weight per Gallon: 8.1 to 10.0 pounds  
Viscosity: #3 Zahn – 20 to 30 seconds, at 77° F  
EPA VOC: 3.5 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. They may be applied over steel and other properly prepared substrates.

Steel: Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing.  
Aluminum: Aluminum should be treated with appropriate metal cleaners and conditioners, including a vinyl 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 protection a primer is recommended

**REDUCTION:** Do not reduce in order to maintain 3.5 VOC. If reduction is necessary, this enamel may be reduced with most aromatic solvents. Butyl Acetate would be the recommended “fast” reducer for application in cooler temperatures. D-150 or MAK can be used as a “slow” reducer to help the applied coating flow during warmer conditions.

**APPLICATION:** Workhorse Finishing Enamel may be used for one-coat, direct to metal applications: however a primer is required for long term corrosion protection.

Airless: Apply without reduction or reduced up to 10% by volume. Airless tip sizes should be in the .011 to .015 range.  
Conventional Air: Reduce approximately 10% by volume. Viscosity should be in the 18 - 30 second range #2 Zahn cup.  
In-Line Heat: In-line heaters should be set at 120°F.  
Dry Film Thickness: 1 - 3 mils above profile in a minimum of two full wet coats.

**DRY TIMES:** This enamel will dry to touch in about 30-60 minutes depending on film thickness, humidity, temperature, and air movement. Dry through times may take overnight. Full adhesion may be gained after 4 - 7 days

**Workhorse Finishing Enamel 3.5 Topcoat System**

drying time. Always check for evidence of lifting before proceeding with a full recoat. Lifting may occur between 8 - 48 hours.

**CLEAN UP:** Use Butyl Acetate to flush paint lines. N-9000 Gun Cleaner can be used for removing dried coatings.

**PERFORMANCE:** Typical, tested on B-1000 panels at 1.5 to 2.0 mils DFT  
 Gravelometer: ASTM D3170 – 2A  
 Crosshatch Adhesion: ASTM D3359 – 5B  
 336 hour Salt Spray: Pass  
 165 hour Wet Adhesion: Pass  
 Xenon (White & Black): 1155 hours <5% loss of gloss  
 168 hour Humidity: Pass

**SAFETY PRECAUTIONS:** Contains Aliphatic solvents. Vapor and spray mist harmful. Use proper respiratory protection. Refer to SDS for specific information. All information subject to change without notice.