

5000 Line

Alkyd Enamel

5000 Line enamels are specially formulated to provide good exterior durability in a single component alkyd system. It is intended for use on farm, construction and material handling equipment as well as light to moderate service environments and trailer refurbishing.

SPECIFICATION

**1-GP-88, 1-GP-135,
TT-E-529 Type I, TT-E-527 Type I**

OUTSTANDING CHARACTERISTICS

- Tough, Hard, Flexible Films
- Very Good Oil Resistance
- Very Good Gasoline Resistance
- Good Colour and Gloss Retention

PHYSICAL DATA

Finish:	Full Gloss Range
Colour:	Full Range of Industrial and Fed. Std. Colours
Weight Solids:	37 - 55%
Volume Solids:	33% ± 2%
V.O.C.	550 g/L ±

RECOMMENDED PRIMER SYSTEMS

- P-35HB (steel)
- D-90Y,G (aluminum)

Note: all physical and chemical resistance tests conducted after one week cure time at 20-25°C (70-75°F) on properly cleaned substrate.



SURFACE PREPARATION

Ferrous (Steel): Must be clean and free from dirt, oil, grease, rust or other contaminants. Sandblasting to SSPC SP-6 or better is recommended along with an appropriate primer system. Proper surface preparation will enhance the performance of the coating system. Galvanized or Satin Cote substrates may require a vinyl wash primer to ensure good adhesion and coating performance.

Aluminum: Clean using an appropriate conversion treatment then prime with vinyl wash primer or D-90Y.



INSTRUCTIONS FOR USE

Components:	One
Cure:	N/A
Mix Ratio:	N/A
Induction Time:	N/A
Pot Life:	N/A
Reducer:	20-4000, 20-4001



MIXING INSTRUCTIONS

Mix thoroughly. Reduce as necessary for spray.



SPRAYING VISCOSITY

See application method.



APPLICATION METHOD

Allow for application loss and surface irregularities.

Conventional Air Spray:	Up to 30% reduction to 20-25 seconds #2 Zahn Cup
Airless Spray	Up to 15% reduction to appropriate viscosity to suit the equipment in use
Air Assist Airless	Up to 20% reduction to appropriate viscosity to suit the equipment in use
Electrostatic Spray	Some adjustment for polarity may be necessary.
Brush or Roller	Use as supplied



RECOMMENDED FILM BUILD THICKNESS & COVER RATE

Total Dry Film Recommendation 1.0 – 1.5 Mils (25 - 37.5 microns)

Calculated Coverage at:

1.0 Mils:	481 ft ² /USG
25 Microns:	45 m ² /USG



ENVIRONMENTAL CONDITIONS

Temperature: 15 - 35°C (59 - 95°F)

Relative Humidity: 35 - 75%

Note: Substrate and air temperature must be a minimum of 3°C (5°F) above the Dew Point



DRY TIME

Dry time at 24°C ± 3°C (75°F), 50% relative humidity.

To Touch:	45 mins
Tack Free:	60 mins
To Recoat:	30 - 60 mins
Dry Through:	16 hours
Dry Hard:	24 - 48 hours



CLEAN UP

Cleaner: 20-4100



STORAGE & SHIPPING

Flash Point: 24°C

Shelf Life: 12 months unmixed for unopened cans



SAFETY PRECAUTIONS

Please refer to the Material Safety Data Sheet (MSDS) for information regarding health, physical and environmental hazards, handling precautions and recommended first aid procedures. For industrial and automotive use only.