



TOUGH COAT[®] ALKYD ENAMEL

K0053 Series

Krylon[®] Industrial Tough Coat Alkyd Enamel is a general maintenance, alkyd gloss enamel designed for industrial maintenance applications. This all purpose, durable utility enamel is easy to brush, roll or spray and is intended for use in normal industrial environments.

- ✓ Single component
- ✓ Corrosion and chemical resistant
- ✓ Chip and flake resistant
- ✓ Good exterior gloss and color retention
- ✓ Interior/Exterior use
- ✓ Suitable for use in USDA inspected facilities

INDUSTRIAL USE ONLY! AS OF 01/01/2017 COMPLIES WITH:

- | | |
|---|---|
| <input checked="" type="checkbox"/> OTC | <input type="checkbox"/> CARB |
| <input checked="" type="checkbox"/> EC | <input checked="" type="checkbox"/> LADCO |
| <input type="checkbox"/> SCAQMD | <input type="checkbox"/> UTAH |

krylonindustrial.com
1-800-247-3266

Revised January 2017

RECOMMENDED USES

- Machinery & equipment
- Doors
- Railings
- Fixtures
- Safety markings
- Pipe markings

RECOMMENDED SYSTEMS

IRON & STEEL

- 1 coat Iron Guard[®] Primer (K000Z6631) @ 2.0 mils dft
- OR
- 1 coat Industrial Primer (K0002000) @ 2.0 mils dft
- OR
- 1 coat Fast Dry Primer (K00020200, K00020300) @ 1.0 - 2.0 mils dft
- 2 coats Tough Coat Alkyd Enamel @ 2.0 - 4.0 mils dft/ct.

ALUMINUM

- 1 coat 1 coat Iron Guard Primer @ 0.7 - 1.3 mils dft
- 2 coats Tough Coat @ 2.0 - 4.0 mils dft/ct

GALVANIZED STEEL

- 1 coat 1 coat Iron Guard Primer @ 0.7 - 1.3 mils dft
- 2 coats Tough Coat @ 2.0 - 4.0 mils dft/ct

CONCRETE & MASONRY

- 1 coat Acrylic Block Filler (K000Z8465) @ 10.0 - 15.0 mils dft
- 2 coats Tough Coat Alkyd Enamel @ 2.0 - 4.0 mils dft/ct

WOOD

- 2 coats Tough Coat Alkyd Enamel @ 2.0 - 4.0 mils dft/ct

PREVIOUSLY PAINTED SURFACES

- 2 coats Tough Coat Alkyd Enamel @ 2.0 - 4.0 mils dft/ct

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority.

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion. Systems listed below are representative of the product's use however other systems can be used.

IRON & STEEL

Hand tool clean for minimum surface preparation per SSPC-SP2. Remove oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3. Prime bare steel within 8 hours or before flash rusting occurs.

ALUMINUM

Remove oil, grease, dirt, oxide and other foreign matter by Solvent Cleaning per SSPC-SP1, followed by priming.

GALVANIZED STEEL

Allow surface to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1 (recommended solvent is VM&P Naphtha). If weathering is not possible or the surface has been treated, first Solvent Clean per SSPC-SP1 and then apply a test patch of paint. Allow to dry at least one week and then test for adhesion. If adhesion is not successful try brush blasting per SSPC-SP7 to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.

SURFACE PREPARATION *CONTINUED*

CONCRETE & MASONRY

For surface preparation, refer to SSPC-SP13/NACE 6 or ICRI 03732, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign matter. Surface must be free of concrete dust, dirt, forming release agents, moisture curing membranes, loose cement and hardeners. Fill holes, air pockets and other voids with Krylon® Industrial Acrylic Block Filler. Weathered masonry and soft or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination. Brick must be allowed to weather for one year prior to surface preparation and painting. Primer required.

WOOD

Surface must be clean, dry, and sound. Paint as soon as possible. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped, sanded and spot primed. All nail holes or small openings must be properly caulked.

PREVIOUSLY PAINTED SURFACES

If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface.

CLEAN-UP

Clean spills and spatters immediately with Xylene. Follow manufacturer's safety recommendations when using Xylene solvents.

TECHNICAL DATA

Vehicle	Alkyd
Finish	Gloss (75+ units @ 60°)
Flash Point	103°F, PMCC
Volume Solids	59 ± 2%
VOC	320 g/L - 2.67 lb/gal as per 40 CFR 59.406
Weight Solids	73 ± 2%
Weight/Gallon	9.7 lb/gal
Rec. Film Thickness	3.5 - 7.0 mils wet 2.0 - 4.0 mils dry
Spread Rate	241-482 sq. ft. per gallon
Shelf Life	36 months, unopened
Application	Apply by airless spray, conventional spray, brush or roller
Drying Time	@ 4.0 mils wet, 50% R.H. Note: Drying times are temperature, humidity and film thickness dependant.
	@ 45°F @ 77°F @ 120°F
To Touch:	6 hours 4 hours 2 hours
To Handle:	14 hours 10 hours 5 hour
To Recoat:	24 hours 16 hours 12 hours
To Cure:	14 days 7 days 4 days
Reduction	Xylene
Clean-up	Xylene

PHYSICAL TEST DATA

System Tested	
Substrate	Steel Surface
Preparation	SSPC-SP10
Primer	1 coat Iron Guard Primer
Finish	1 coat Tough Coat Alkyd Enamel
Adhesion	
Method	ASTM D4541
Result	392 psi
Exterior Durability	
Method	1 year at 45° South
Result	Excellent
Direct Impact Resistance (topcoat only):	
Method	ASTM D2794
Result	30 in. lb.
Dry Heat Resistance	
Method	ASTM D2485
Result	200°F (discolors)
Flexibility	
Method	ASTM D522, 180° bend, 1/4" mandrel
Result	Passes
Moisture Condensation Resistance:	
Method	ASTM D4585, 100°F, 500 hours
Result	No rust, delamination, or creepage at scribe
Pencil Hardness	
Method	ASTM D3363
Result	B
Salt Fog Resistance	
Method	ASTM B117, 500 hours
Result	No cracking, softening, or delamination; No more than 1/32" rust creepage at scribe



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The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of Krylon Industrial. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Krylon Industrial dealer or representative to obtain the most recent Product Data Sheet.

APPLICATIONS

Temperature (air, surface and material)
40°F minimum, 120°F maximum. At least 5°F above dew point

Relative Humidity 85% maximum

Airless Spray

Pressure 1800 psi

Tip 017" - .021"

Filter 60-100 mesh

Reduction As needed up to 3% by volume

Brush

Brush Nylon/polyester or natural bristle

Reduction Not recommended

Roller

Cover 1/4" - 3/8" lambswool or synthetic cover

Reduction Not recommended

CAUTION

Thoroughly review product label and SDS for safety and cautions prior to using this product. Please direct any questions or comments to your local Krylon Industrial Representative.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, Krylon Products Group cannot make any warranties as to the end result. Please direct any questions or comments to 1-800-247-3266.



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