**DESCRIPTION**

Water-Reducible Alkyd Enamel is a 2.8 VOC fast drying, water-reducible, acrylic modified, alkyd coating intended for industrial product finishing and refinishing applications. Its low VOC, the reduced hazards of water-reducible technology and versatility of application, make it an ideal coating for a wide array of general metal applications.

**ADVANTAGES**

- HAPS Complying
- VOC complying - less than 2.8 lb/gal at application
- Low volatile organic emissions - under 1.3 lb/gal
- Fast air drying
- No flash point - reduced fire hazards and possible lower insurance costs
- Good one coat protection—much better corrosion resistance than latex coatings in typical OEM applications
- Good adhesion and early water resistance
- Full gloss
- Low odor - improved working conditions
- Reduces with water - means considerable cost savings in solvents
- Very good exterior color and gloss retention
- Application by conventional, airless, air assisted airless, HVLP, and electrostatic spray methods and by dipping
- No critical recoat time
- Broad color and gloss range available through custom color mixing
- Free of lead and chromate hazards
- Use water to clean-up spray guns and equipment
- Good flexibility and mar resistance

**LIMITATIONS:**

- Multiple passes to obtain film build are recommended rather than a single heavy pass.
- Higher relative humidity will increase drying time.
- Do not spray at temperatures below 45°F.
- Indoor storage at 35-95°F is recommended. Protect from freezing.
- For longer term exterior applications, priming with Water-reducible Alkyd Primer or Shopcoat Primer is strongly recommended. Priming gives increased corrosion protection and film integrity. Examples of such application are construction equipment, farm equipment, machinery, and trailers.
- Do not over-reduce Water-reducible Alkyd Enamel. It should be applied at as high a viscosity as practical.
- Do not exceed 150°F. Force drying temperature as coatings (especially whites) may yellow at higher temperature.
- Water-reducible enamels must be applied at higher viscosities than solvent-based enamels. They do apply and atomize easily at higher viscosities.

**SPECIFICATIONS**

**Steel or Iron:**
1 ct. Water-Reducible Alkyd Primer @ 1.0 - 1.3 mils dft/ct
1-2 cts. Water-Reducible Alkyd (K0096 Series) @ 1.0 - 1.25 mils dft/ct.

**Galvanizing/Aluminum (new):**
1 ct. Water-Reducible Wash Primer (K00021000) @ 0.3 mils dft/ct
1-2 cts. Water-Reducible Alkyd (K0096 Series) @ 1.0 - 1.25 mils dft/ct.

**APPLICATION**

**Typical Setups**

**Conventional Spray:**
- Air Pressure: 45-50 psi
- Fluid Pressure: 15-20 psi
- Cap/Tip: 63P13/63
- Reducer: Water
- Reduction Rate: As needed up to 10%

**Airless Spray:**
- Pressure: 1800-2300 psi
- TIP: .011"
- Reducer: Water
- Reduction Rate: As needed, up to 10%. Enamel may be heated up to 120°F for application.
## APPLICATION

**Air Assisted Airless:**
- Atomizing Air: 20-30 psi
- Fluid Pressure: 500-900 psi
- Tip: .011"
- Reducer: Water
- Reduction Rate: As needed, up to 10%.

**Electrostatic Spray:**
- Equipment must be isolated. Contact your Krylon Industrial Coatings representative for proper set-up.
- **HVLP:** Binks Mach 1
  - Air Pressure: 75 psi
  - Fluid Pressure: 4-6 psi
  - Cap/Tip: 97P/97
  - Reducer: Water
  - Reduction Rate: As needed, up to 15%.

**Dip (Small Tanks Only)**
- Reducer: Water
- Reduction Rate: As needed, up to 15%.
- A 3:1 blend of water and Butyl Cellosolve is necessary for tank maintenance.

Excessive agitation or turbulence on part immersion or withdrawal may cause foaming. Tanks must be monitored for viscosity, pH range of 8.5-8.9, and stability. Adjust pH daily using triethylamine. Do not use ammonia. Organic solvent addition will raise VOC.

**CLEAN-UP**
- Clean tools/equipment immediately after use with water when paint is wet. When dry, use Butyl Cellosolve or MIBK.

Follow manufacturer’s safety recommendations when using any solvent.

## CHARACTERISTICS

### Gloss:
- Full Gloss 80+ units

### Tinting:
- Tint only with Blend-A-Color® Colorants. Shake mechanically for five minutes for complete mixing of color.

### VOLUME SOLIDS:
- 30.5% average, may vary by color

### VISCOITY:
- 40-60 seconds #5 Zahn Cup
- 85-95 Krebs Units
- Reduced 10-15% with water
- 20-30 seconds #2 Zahn Cup

### VOC:
- <2.8 lb/gal (336 g/l)

### SHELF LIFE:
- 36 months, unopened, at 77°F

### RECOMMENDED FILM THICKNESS
- Mils wet: 4.0 - 5.0
- Mils dry: 1.0 - 1.25

### RECOMMENDED SPREADING RATE (no application loss)
- 489-391 sq ft/gal

### DRYING SCHEDULE @ 1.0 mils dft, 77°F, 50% RH:
- To Touch: 20-30 minutes
- To Handle: 60-75 minutes
- To Tack Free: 30-45 minutes
- To Tape: 60-75 minutes
- To Recoat: 30 minutes
- To Pack: overnight
- Force Dry: 15-20 minutes at 150°F

## CHARACTERISTICS cont.

**Note:** Good air movement and humidity control is necessary for proper drying of water-reducible coatings.

### FLASH POINT:
- None (Seta Flash Closed Cup)

### pH:
- 8.5-8.9

### PERFORMANCE TESTS
- **Substrate:** Untreated, cold-rolled steel panels with 1.2 mils dft
- **Salt Spray Test:**
  - ASTM B117: 100 hours, passes with no face rust
  - Humidity:
  - ASTM D2247, 100°F, 100% RH: 100 hours, passes
  - Freeze Thaw: Passes 4 cycles

### CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings™ Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings™ Distributor.

**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 1-800-777-2966.

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