



Alkyd Enamel Factory Pack

ALK-FP

CPC 106

Component A		CHEMICAL RESISTANCE		
ALK-FP101	Alkyd Enamel - Ford Blue	10% Sulfuric Acid		Good
ALK-FP301	Alkyd Enamel - Ice Gray	10% Ammonia		Very Good
ALK-FP401	Alkyd Enamel - John Deere Green	Xylene		Fair
ALK-FP601	Alkyd Enamel - Kubota Orange	Oil		Very Good
ALK-FP701	Alkyd Enamel - Case IH Red	500 hours salt spray		Fair
ALK-FP801	Alkyd Enamel - Bright Yellow	10% Hydrochloric Acid		Good
ALK-FP827	Alkyd Enamel - New Cat Yellow	10% Sodium Hydroxide		Good
ALK-FP901	Alkyd Enamel - Black	Isopropyl Alcohol		Good
ALK-FP951	Alkyd Enamel - White	Gasoline		Fair
RECOMMENDED USE		SURFACE PREPARATION		
<p>Type: Alkyd Enamel</p> <p>The ALK-FP series of topcoats are fast drying alkyd enamels that produce a durable, chemical resistant finish. They are intended for industrial use on primed or un-primed surfaces. Suitable application include agricultural and construction equipment, metal fabrication, castings, cabinets and machinery.</p>		<p>The surface to be coated must be sanded, free of all contamination, including dust, dirt, oil, grease and oxidation. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the finished coat.</p>		
PHYSICAL CONSTANTS (varies by color)		Metal	Recommended Primers	Direct To Properly Treated Substrate
Mixed VOC	4.68 lbs./gal.	Cold Rolled Steel	EPX-900, HBA-3035, HSP-900/902, PLC-900, VAP-9XX	Very Good
Percent Solids by Weight	48.0 ± 8%	Hot Rolled Steel	EPX-900, HBA-3035, HSP-900/902, PLC-900, VAP-9XX	Very Good
Percent Solids by Volume	35 ± 5%	Galvanized	EPX-900, HSP-900/902, PLC-900	Not Recommended
Weight Per U.S. Gallon	7.89 – 9.95 lbs/gal	Galvaneal	EPX-900, HSP-900/902, PLC-900	Not Recommended
Flash Points (Penskey Martins)	71°F (22°C)	Aluminum	EPX-900, HBA-3035, HSP-900/902, PLC-900, VAP-9XX	Fair
Ready To Spray Viscosity	#2 Zahn = N/A #3 Zahn = 12 – 20 seconds	Plastic/Fiberglass	Surface should be free of all contamination. Because of the variability of plastic/fiberglass substrates, coating performance should be confirmed on the actual plastic/fiberglass substrate being used.	
PERFORMANCE FEATURES				
Pencil Hardness	HB-H			
Flexibility	Excellent			
Fade Resistance	Good			
96 hour Humidity	Good			
Sheen	Gloss @ 60° angle - 90+			
Adhesion	Excellent			
Water Resistance	Resistance to intermittent exposure. Not recommended for immersion service			
In Service Temperature Limitations	200°F (93°C)			

Note: As you approach 200°F, depending on the pigmentation, the color may change, but film integrity will be maintained until 200°F.

APPLICATION DATA	SAFETY
Mixing Directions Ready-To-Spray. Stir thoroughly before and occasionally during use.	These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public. Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.
Thinning Thinning is not normally required; however, under adverse conditions, small amounts (10% or less) of xylene or aromatic 100 may be added.	
Pot Life N/A	
Application Equipment Conventional Spray: 30-40 psi at the gun.	
Airless: 1400 – 2000 psi. Tip = .009" - .013"	
Air Assisted: 850-psi min. at the tip, 30-60 psi. Tip = .009" - .013"	
<i>Note: As needed, 5% slow Aromatic solvent may be required to eliminate popping.</i>	
Drying Times* 77°F (25°C) and 50% relative humidity.	
To Touch: 10 to 20 minutes	
To Handle: 45 Minutes*	
To Tape:	
To Dry: 4 hours**	PRECAUTIONARY INFORMATION
To Recoat: Before 4 hours or after 72 hours ***	Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. KEEP OUT OF THE REACH OF CHILDREN
Force Dry: (Allow 10 minutes air dry)	
Bake: 30 minutes @ 160°F	
* This condition does not mean that the paint film has reached full cure. It is a stage where handling can be achieved without loosening, wrinkling or otherwise marring the film under minimal pressure from fingers or hands. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.	MEDICAL RESPONSE
** Paint film is not fully cured for 7 days.	Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645 - 1320 Have label information available.
*** IMPORTANT! If this product is recoated between 4 hours and 72 hours, lifting of the previous finish will occur. Before 4 hours, the coating is adequately solubilized to prevent lifting, while after 72 hours, cure has progressed to a point where solvent resistance is achieved.	
Application of film thickness in excess of that recommended for this product will substantially extend dry time and lengthen the recoat window.	MATERIAL SAFETY DATA SHEET
<i>Recommended Wet Film Build (Unreduced): 4.0 – 5.0 mils</i>	Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.
<i>Recommended Dry Film Build: 1.4 – 2.0 mils</i>	
Film in excess or below these recommended film builds may cause problems such as, adhesion failure, pigment floatation, solvent popping, slow cure, and accelerated gloss and color failure.	
Recommended Spreading Rate 561 sq. ft. at 1.0 mil dry film per U.S. gallon (varies by color). Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularities or porosity.	To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.
Clean Up Toluene or Xylene	
Application Precautions and Limitations Apply only when air, product or surface temperature is above 60°F (16°C) and when surface temperature is at least 5°F (3°C) above the dew point. Brush and roller application is not recommended. Brush and roller application is not recommended.	

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