



Alkyd Enamel Factory Pack with Polyurethane Enhancer

ALK-FP / ALK-201

CPC 157

Component A	Component B	CHEMICAL RESISTANCE																													
ALK-FP	ALK-201 Catalyst for ALK-FP	10% Sulfuric Acid	Very Good																												
<p align="center">RECOMMENDED USE</p> <p>Type: Alkyd Enamel</p> <p>ALK-FP with Polyurethane Enhancer is a fast drying interior/exterior enamel intended for industrial use on properly prepared and/or primed metal surfaces. Suitable applications include metal fabrication, castings, cabinets, machinery, and heavy equipment.</p> <p>ALK-FP/ALK-201 Acrylic Modified Alkyd Enamel with Polyurethane Enhancer provides a wide balance of performance properties, including excellent flow and leveling, film hardness and good exterior durability.</p> <p align="center">PHYSICAL CONSTANTS (varies by color)</p> <table border="1"> <tr> <td>Mixed VOC (Maximum)</td> <td>4.49 lbs./gal.</td> </tr> <tr> <td>Percent Solids by Weight</td> <td>50.0 ± 8%</td> </tr> <tr> <td>Percent Solids by Volume</td> <td>38 ± 5%</td> </tr> <tr> <td>Weight Per U.S. Gallon</td> <td>7.97 – 9.91 lbs/gal</td> </tr> <tr> <td>Flash Points (Penskey Martins)</td> <td>71°F (22°C)</td> </tr> <tr> <td>Ready To Spray Viscosity</td> <td>#2 Zahn = N/A #3 Zahn = 20 - 30 seconds</td> </tr> </table> <p align="center">PERFORMANCE FEATURES</p> <table border="1"> <tr> <td>Pencil Hardness</td> <td>HB-H (Varies by color)</td> </tr> <tr> <td>Flexibility</td> <td>Pass (Conical Mandrel)</td> </tr> <tr> <td>Fade Resistance</td> <td>Very Good</td> </tr> <tr> <td>96 hour Humidity</td> <td>Excellent</td> </tr> <tr> <td>Sheen</td> <td>Gloss @ 60° angle - 90+</td> </tr> <tr> <td>Adhesion</td> <td>Excellent</td> </tr> <tr> <td>Water Resistance</td> <td>Resistance to intermittent exposure. Not recommended for immersion service</td> </tr> <tr> <td>In Service Temperature Limitations</td> <td>200F (115°C)</td> </tr> </table> <p>Note: As you approach 200°F, depending on the pigmentation, the color may change, but film integrity will be maintained until 200°F.</p>		Mixed VOC (Maximum)	4.49 lbs./gal.	Percent Solids by Weight	50.0 ± 8%	Percent Solids by Volume	38 ± 5%	Weight Per U.S. Gallon	7.97 – 9.91 lbs/gal	Flash Points (Penskey Martins)	71°F (22°C)	Ready To Spray Viscosity	#2 Zahn = N/A #3 Zahn = 20 - 30 seconds	Pencil Hardness	HB-H (Varies by color)	Flexibility	Pass (Conical Mandrel)	Fade Resistance	Very Good	96 hour Humidity	Excellent	Sheen	Gloss @ 60° angle - 90+	Adhesion	Excellent	Water Resistance	Resistance to intermittent exposure. Not recommended for immersion service	In Service Temperature Limitations	200F (115°C)	10% Ammonia	Very Good
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In Service Temperature Limitations	200F (115°C)																														
Xylene	Good																														
Oil	Very Good																														
500 hours salt spray	Good																														
10% Hydrochloric Acid	Very Good																														
10% Sodium Hydroxide	Very Good																														
Isopropyl Alcohol	Very Good																														
Gasoline	Good																														
		SURFACE PREPARATION																													
		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.																													
Metal	Recommended Primers	Direct To Properly Treated Substrate																													
Cold Rolled Steel	EPX-900, HBE-400, HBA-3035, HSP-900/902, PLC-900, VAP-9XX	Very Good																													
Hot Rolled Steel	EPX-900, HBE-400, HBA-3035, HSP-900/902, PLC-900, VAP-9XX	Very Good																													
Galvanized	EPX-900, HBE-400, HSP-900/902, PLC-900	Not Recommended																													
Galvaneal	EPX-900, HBE-400, HSP-900/902, PLC-900	Not Recommended																													
Aluminum	EPX-900, HBE-400, HBA-3035, HSP-900/902, PLC-900, VAP-9XX	Fair-Good																													
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.																														

APPLICATION DATA	SAFETY
<p>Mixing Directions Stir thoroughly before and occasionally during use. To each gallon of ALK-FP Component A (7.5 pints), add the entire contents of 1/2 pint of ALK-201, Component B (clear enhancer). Mix ratio is 15 parts Component A to one part Component B by volume. Each 5-gallon container of ALK-FP, Component A (15 quarts), will require the addition of a one quart container of ALK-201, Component B, resulting in a 4-gallon material mix in a 5-gallon container. Agitate thoroughly and allow it to digest 15 minutes before using. NOTE: Moisture contamination in components will result in poor properties of applied films or gelling of the material. Do not open until ready to use.</p>	<p>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.</p>
<p>Thinning Thinning up to 10% with xylene or aromatic 100 will improve drying characteristics and can reduce solvent "popping".</p>	
<p>Pot Life 77°F (25°C) 8 Hours after mixing</p>	
<p>Application Equipment <u>Conventional Spray:</u> 30-40 psi at the gun. <u>Airless:</u> 1400 – 2000 psi. Tip = .009" - .013" <u>Air Assisted:</u> 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></p>	
<p>Drying Times 77°F (25°C) and 50% relative humidity.</p>	<p>PRECAUTIONARY INFORMATION</p>
<p>To Touch: 45 minutes to 2 hours</p>	<p>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</p>
<p>To Handle: 2 to 3 hours*</p>	<p>MEDICAL RESPONSE</p>
<p>To Dry: 10 hours**</p>	<p>Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645-1320 Have label information available.</p>
<p>To Recoat: 3 hours to 4 days</p>	<p>MATERIAL SAFETY DATA SHEET</p>
<p>Force Dry: (Allow 10 minutes air dry)</p>	<p>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.</p>
<p>Bake: 30 minutes @ 180°F</p>	<p>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.</p>
<p>* 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.</p>	
<p>** Paint film is not fully cured for 7 days.</p>	
<p>Application of film thickness in excess of that recommended for this product will substantially extend dry time and lengthen the recoat window.</p>	
<p><u>Recommended Wet Film Build (Unreduced):</u> 3.75 – 4.75 mils</p>	
<p><u>Recommended Dry Film Build:</u> 1.4 – 2.0 mils</p>	
<p>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.</p>	
<p>Recommended Spreading Rate 602 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.</p>	
<p>Clean Up Toluene or Xylene</p>	
<p>Application Precautions and Limitations Apply only when air, product or surface temperature is above 50°F (10°C) and when surface temperature is at least 5°F (3°C) above the dew point. Brush and roller application is not recommended.</p>	
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PPG Industries
19699 Progress Drive
Strongsville, OH 44149
1-800-647-6050

PPG Canada Inc.
2301 Royal Windsor Drive
Mississauga, Ontario L5J 1K5
1-888-310-4767

