

ALK-300ELG

CPC 40

Low VOC Acrylic Modified Alkyd Enamel - LG

PRODUCT DESCRIPTION	
Component A ALK-300ELG Low Voc Acrylic Modified Alkyd Enamel – LG (Pigmented)	Component B ALK-31 Drier
TYPE Acrylic Modified Alkyd Enamel	
RECOMMENDED USE ALK-300ELG Low Gloss 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. ALK-300ELG Low Gloss provides a wide balance of performance properties including excellent flow, leveling, and film hardness.	
COLORS Virtually any new or existing color standard can be quickly and precisely matched using PPG's COLOR ACCURATE™ instrument matching and dispensing system. Once formulated, batches as small as one gallon can be reproduced time after time without the color drift problems associated with manual small batch methods. All colors supplied from the COLOR ACCURATE™ system will be formulated to meet Federal standards concerning the amount of lead in the dried film.	

PHYSICAL CONSTANTS	
Voc (Mixed) <3.5 lbs/gal (varies by color)	Flash Points (Pensky-Martens) ALK-300ELG 101°F (38°C) ALK-31 115°F (46°C)
Percent Solids By Weight (Mixed) 58.6 – 70.9%	Ready To Spray Viscosity (Varies By Color) #3 Zahn = 18 - 28 Seconds #2 Zahn = N/A
Percent Solids By Volume (Varies By Color) 51.8 – 58.2%	
Weight Per U.S. Gallon (Varies By Color) 8.46 – 10.2 Lbs./Gallon	

PERFORMANCE FEATURES													
Pencil Hardness (Varies By Color) HB-H	Fade Resistance Exposure studies confirm that the fade resistance of the ALK-300ELG Low Gloss finish is comparable @ 3.5 Voc to most interior/exterior alkyd enamels.												
Flexibility (Conical Mandrel) Pass	Sheen ALK-300ELG Low Gloss is supplied as a gloss finish (20-30 on a 60° gloss meter). ALK-300ELG Low Gloss may be mixed with VISSTAR™ Full Gloss to obtain various gloss levels. Approximate mix ratios by volume for various gloss levels are as follows:												
96 Hour Humidity Resistance Excellent													
In Service Temperature Limitations 150° F													
Adhesion Good													
Water Resistance Although Resistant To Intermittent Exposure, <i>Not Recommended For Immersion.</i>	<table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 33%;">ALK-300E</th> <th style="width: 33%;">ALK-300ELG</th> <th style="width: 33%;">% Gloss (60°)</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> <td style="text-align: center;">60-70</td> </tr> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">2</td> <td style="text-align: center;">40-50</td> </tr> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">3</td> <td style="text-align: center;">30-40</td> </tr> </tbody> </table>	ALK-300E	ALK-300ELG	% Gloss (60°)	1	1	60-70	1	2	40-50	1	3	30-40
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1	1	60-70											
1	2	40-50											
1	3	30-40											
<i>Note: As you approach 150°F, depending on the pigmentation, the color may change, but film integrity will be maintained until 150°F.</i>													

CHEMICAL/SOLVENT RESISTANCE			
10% Sulfuric Acid	Very Good	10% Hydrochloric Acid	Very Good
10% Ammonia	Fair	10% Sodium Hydroxide	Fair
Xylene	Fair	Isopropyl Alcohol	Very Good
Oil	Very Good	Gasoline	Fair
500 Hours Salt Spray	Fair		

SURFACE PREPARATION

The surface to be coated must be sanded, free of all contamination, including dust, dirt, oil, grease and oxidation.

Metal	Recommended Topcoat	Direct To Properly Treated Substrate
Cold Rolled Steel	HBA-CT/4035, CRE-CT/904, HSP-900/902, HSP-2128, EPX-900, EEP-435	Good
Hot Rolled Steel	HBA-CT/4035, CRE-CT/904, HSP-900/902, HSP-2128, EPX-900, EEP-435	Good
Galvanized	HSP-900/902, HSP-2128, EPX-900, CRE-CT/904	Not Recommended
Galvaneal	HSP-900/902, HSP-2128, EPX-900, CRE-CT/904	Not Recommended
Aluminum	HBA-CT/4035, CRE-CT/904, HSP-900/902, HSP-2128, EPX-900, EEP-435	Fair
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

MIXING DIRECTIONS

Stir thoroughly before and occasionally during use. To improve dry times, add exactly 4 oz. of ALK-31 drier per full gallon of mixed color. ALK-31 is very dark color and care should be taken when used in light /clean colors as they may darken or appear dirty.

NOTE: ALK-31 must be added to the resin prior to mixing with the color.

POT LIFE

N/A

THINNING

Thinning is recommended to a 3.5 lbs./gallon VOC with aromatic 100

APPLICATION EQUIPMENT

Conventional Spray: 60 psi at the gun.

DRYING TIME

3 mils wet @ 77°F (25°C) and 50% relative humidity. **Note:** Dry times below are when full drier (ALK-31) load is added.

To Touch: 30 minutes

To Handle: 2 hours*

To Dry: 24 hours**

Recoat: 2 – 6 hours or after 24 hours to 4 days***

Force Dry: 30 minutes @ 120°F
(Allow 10 minutes air dry)

Recommended Wet Film Build (Mixed): 2.8 – 3.7 mils

Recommended Dry Film Build: 1.5 – 2.0 mils

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.

* 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.

** Paint film is not fully cured for 7 days.

*** IMPORTANT! If this product is recoated between 6 and 24 hours, lifting of the previous finish will occur. Between 2-6 hours, the coating is adequately solubilized to prevent lifting, while after 24 hours to 4 days, 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.

RECOMMENDED SPREADING RATE

830-933 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.

CLEAN UP

Toluene, Xylene or Lacquer Thinner

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.

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.

SAFETY

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.

PRECAUTIONARY INFORMATION

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

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645 - 1320 Have label information available. **MATERIAL SAFETY DATA SHEET 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.**

PPG Industries
Commercial Coatings
We're Everywhere You Look

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

