

2605 Low VOC Satin Alkyd

Updated: January 2015

Specification Data

Generic Type: High Solids Alkyd

Description: High solids, fast drying, thin film, low VOC coating. Provides tight barrier protection to properly prepared steel surfaces. High solids formulation and use of exempt solvents results in lower VOC emissions. Economical way to comply with stricter air quality regulations. Attractive satin finish helps hide imperfections in the surface.

Features:

- Satin Finish
- High solids, VOC complaint
- Fast Drying
- Can be applied Direct-to-Metal
- Available in a full range of colors

Solids Content: 49% by Volume

Theoretical Coverage:

- 785 mil ft²
- 261 ft² @ 3 mil DFT

Allow for loss during mixing & application.

VOC Value:

- 2.5 lbs/gal per EPA Method 24

Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

Immersion Carbon Steel: Not Recommended

Non-Immersion Carbon Steel: Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 1.5-3.0 Mil.

Galvanized Steel: Not recommended

Previously painted surfaces: Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

Primer: APCO 245FP Universal Primer, APCO 265Z, 351 Epoxy Primer

Application Equipment

Spray Application:

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2001 Gun w/66 series nozzles and 565 needle.
- **Airless:** Graco 36:1 Min. 1/4" material line. Tip size .013. Output PSI- 3000-3600

Brush & Roller: Touch up only

- **Brush:** Natural Bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

Mixing & Thinning

Components: One

Mixing: Power mix to uniform color & consistency

Thinning:

- **Spray:** Up to 12 oz/gal with S100

Application

Pre-application: Flush all equipment with thinner S100

Temperature: Application range from 40°F-110°F surface temperature. Do not apply below 40°F.

Method: Apply one coat maintaining a wet edge to achieve a WFT of 4-6 Mils. Maximum performance will be achieved with two coats totaling 4-6 mils DFT.

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Application Continued

Inspection: Visually inspect film to ensure adequate coverage.

Clean up & disposal: After use immediately flush all equipment with thinner S108 or M.E.K. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

Curing schedule:

Times based upon 75°F

Dry to touch: 6 hours

Dry through: 18 hours

Dry to cure: 48 hours

A critical recoat time may occur between 2 and 48 hours at room temperature. This may fluctuate depending on temperature and film thickness. Test small inconspicuous area first.

Dry times are greatly affected by weather conditions and film thickness.

Packaging & Handling:

Unit sizes: One and Five gallon units

Shipping Weight: 11.5 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII