

## 220M OEM Matte Finish Enamel

Updated: January 2015

### Specification Data

**Generic Type:** Chain stop alkyd

**Description:** APCO 220M is a proven, fast drying, thin film, economical coating. Provides tight barrier protection to properly prepared steel surfaces. Quick dry time ensure high production rates and limited bottlenecks in the paint booth.

**Features:**

- Attractive Matte Finish
- Fast Drying
- Can be applied Direct-to-Metal

**Solids Content:** 42% by Volume

**Theoretical Coverage:**

- 673 mil ft<sup>2</sup>
- 269 ft<sup>2</sup> @ 2.5 mil DFT

Allow for loss during mixing & application.

**VOC Value:**

- 4.12 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 215QP Quick Dry Primer, 245FP Universal Primer, 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 S100 or xylene. 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: 20 minutes

Dry through: 48 hours

**A critical re-coat 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: Ones, Fives and Drums

Shipping Weight: 11 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII