Commercial Performance Coatings

CPCPB021

Alkyd Enamel Factory Pack

ALK-FP

ALK-FP101	Ford Blue	ALK-FP801	Bright Yellow
ALK-FP301	Ice Gray	ALK-FP827	New CAT Yellow
ALK-FP401	John Deere Green	ALK-FP901	Black
ALK-FP601	Kubota Orange	ALK-FP951	White
ALK-FP701	Case IH Red		

ALK-FP is a fast drying interior/exterior enamel intended for industrial use on properly prepared and/or primed metal surfaces. Example applications include metal fabrication, castings, cabinets, machinery, and heavy equipment.

ALK-FP can be catalyzed with ALK-201 Polyurethane Enhancer to enhance durability and chemical resistance properties.

Features and benefits:

- Available in common industrial colors (size 01 and 05)
- Can be catalyzed at low catalyst amount
- Provides excellent hiding

Associated Products:

- ALK-FP Various Alkyd Factory Pack Enamels
- ALK-201 Polyurethane Enhancer (optional)

Physical Constants:

All values are theoretical, depend on color and are Ready-to-Spray. Actual values could vary slightly due to manufacturing variability.

	Without ALK-201	With ALK-201
Weight per gallon (US)	7.95 – 9.55 lbs/gal	8.04 – 9.54 lbs/gal
Percent solids (by weight	38.9 – 52.9%	41.7 - 54.8%
Percent solids (by volume)	32.3 - 36.3%	34.3 - 39.0%
VOC	4.51 – 4.85 lbs/gal	4.39 – 4.94 lbs/gal
HAPs	2.9 – 4.2 lbs/gal	2.7 – 3.94 lbs/gal
Photo-chemically reactive	Yes	Yes
Flashpoint ALK-FP alone - 71°F AKL-201 alone - 113° F		

Directions for Use:

Substrate Preparation:

The surface to be coated must be sanded and free of all contamination (including dust, dirt, oil, grease, and oxidation). Chemical treatment and the use of a conversion coating will improve the performance properties of the coating system. We recommend that adhesion and system compatibility be checked prior to full application.

Substrate	Direct to properly treated substrate
Cold Rolled Steel	Very good
Hot Rolled Steel	Very good
Galvaneal	Not Recommended
Galvanized	Not Recommended
Aluminum	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.

Note: *For improved performance between this topcoat and CPC primers please see the CPC Primer/Topcoat compatibility chart (CPCTB01).*

PPG

ALK-FP

Directions for Use (continued)

Mix Directions:

Mix Directions:	Stir thoroughly before and occasionally during use. When adding ALK-201, agitate mixture thoroughly and allow it to digest 15 minutes before using. Do not open until ready to use.
Thinning:	Can be thinned up to 10% with Q80 (Xylene) or Q50 (Aromatic 100).

Blend Ratio:	ALK-FP	ALK-FP with ALK-201
	N/A	ALK-FP : ALK-201 15 : 1

Pot Life @ 77°F (25°C):	N/A	8 hours after mixing

Spray Viscosity Range:	#3 Zahn - 12 – 20 seconds	#3 Zahn - 20 – 30 seconds
Unopened Shelf Life: (each component)	2 years	

Application Equipment:

Conventional (with or without Pressure Pot):	1.3 – 1.6 mm needle/nozzle with 30-40 psi at the gun
HVLP (with or without Pressure Pot):	1.3 – 1.5 mm needle/nozzle with 10 psi output at the gun
Airless:	0.009 – 0.013 tip at 1400 – 2000 psi fluid pressure
Air-Assistd Airless:	0.009 – 0.013 tip at 850 psi fluid pressure
Brush or Roll:	Not Recommended
Electrostatic:	Not Recommended

Application:

Apply:	1 – 2 medium coats with 10 – 15 minute flash. 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.

	ALK-FP	ALK-FP with ALK-201
Recommended Wet Film Build:	4 – 5 mils	3.75 – 4.75 mils
Recommended Dry Film Build:	1.4 – 2.0 mils	1.4 – 2.0 mils
Square Foot Coverage @ 1.0 mil no loss:	519 – 581 sq. ft.	550 – 624 sq. ft.

Dry Times:

Air Dry: @ 77°F 50% RH:	ALK-FP	ALK-FP with ALK-201
Dry to Touch:	10 – 20 minutes	1 – 2 hours
Dry to Handle:	45 minutes*	2 – 3 hours*
To Recoat:	Before 4 hours or after 3 days**	3 hours – 4 days

Force Dry: 30 minutes after 15 minute flash (with and without ALK-201)

** Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.*

*** IMPORTANT! If recoated between 4 hours and 3 days, lifting of the previous finish will occur. Before 4 hours, the coating is adequately solubilized to prevent lifting, while after 3 days, the cure has progressed to a point where solvent resistance is achieved.*

ALK-FP

Technical Data*

Performance Properties:

System Tested:
BONDERITE®*1000*
ALK-FP901 & ALK-FP951

Test	ASTM Method	ALK-FP	ALK-FP / ALK-201
Gloss @ 60° Angle	D523	85 – 95	85 - 95
Pencil Hardness	D3363	HB – B	HB
Gravelometer	D3170	8	8
Adhesion	D3359	5B	5B
In Service Temperature Limit**		200°F	200°F

** *As you approach the In Service Temperature Limit, depending on the pigmentation, the color may change, but the film integrity will be maintained until the limit is reached.*

Chemical Resistance:

Chemical ASTM D1308	ALK-FP	ALK-FP / ALK-201
Toluene	Slight Ring, Blister	Slight Ring
10% NaOH (Sodium Hydroxide)	Fail	Pass
10% HCl (Hydrochloric acid)	Pass	Pass
10% H_2SO_4 (Sulphuric acid)	Pass	Pass
Gasoline	Slight Ring, Yellowing	Slight Ring, Yellowing
Isopropyl Alcohol	Ring, Blister	Slight Ring, Softening
Water†	Pass	Pass

† *Although resistant to intermittent exposure, not recommended for immersion.*

Weather Resistance:

System Tested:
Bonderite 1000
ALK-FP901 & ALK-FP951

	ASTM Method	ALK-FP	ALK-FP / ALK-201
Salt Spray – 100 hours	B117		
Corrosion Creep	D1654	7A	7A
Scribe Blisters	D714	8D	8D
Face Blisters	D714	None	None
Humidity – 100 hours	D2247		
5 Minute Recovery Adhesion	D3359	5B	5B
1 Hour Recovery Adhesion	D3359	5B	5B
24 Hour Recovery Adhesion	D3359	5B	5B
QUV-UVA: 60° angle	D4587		
250 hour retention	D523	79 – 93%	96 – 100%
500 hour retention	D523	79 – 92%	95 – 100%

All tests results assume proper cure and preparation of test substrates. Unless otherwise stated, all results were obtained spraying product direct to metal on *Bonderite* 1000.

* The application and performance property data above are believed to be reliable based on laboratory findings. It is for the buyer to satisfy itself on the suitability of the product for its particular use. Variation in environment, procedures of use, or extrapolation of data may cause unsatisfactory results.

Miscellaneous:

This product should not be applied to Zinc substrates.

ALK-FP

Alkyd Enamel Factory Pack

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 and in MEXICO 01-800-00-21-400. Have label information available.

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.

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