

Equipment Enamel

Technical Data Sheet (TDS)

Product Description

Crown Equipment Enamel is one-component medium oil alkyd all-purpose industrial enamel intended for interior/exterior use. Corrosion properties may be enhanced with P-Series Metal Primers. Crown Quick Dry Enamel may also be catalyzed with Polyurethane Convertor to create a hard, solvent and chemical resistant finish

Product features:

- Interior/Exterior use
- Good Gloss retention
- Good color retention
- Good corrosion resistance
- Low to No HAPS
- Brush, roll, spray application
- Lead, chromate, and heavy metal free
- Available in various colors

Recommended Uses

Crown Equipment Enamel is intended for industrial applications; either new build or maintenance.

Crown Equipment Enamel is recommended used on a wide variety of general metal and wood applications.

Industries:

- Oilfield & Energy Service
- Industrial Equipment
- Construction Equipment
- Agricultural equipment
- General Metal applications

Mixing

Crown Equipment Enamel: Used as Single Component

Stir each container thoroughly prior to use.

Material is packaged at a viscosity requiring little or no reduction for application by airless spray equipment. For other spray methods, refer to Spray Gun Setup section.

Equipment Enamel used as a Two Component Catalyzed Product.

Mix:

8 parts by volume of **Crown Equipment Enamel**
1part by volume of Polyurethane convertor (BX015)

Note: Due to limited potlife, never leave catalyzed paint in spray equipment. Clean immediately.

Product Characteristics

Typical Physical Properties

Gloss: High 85+ GU at 60°

Volume Solids (Single Component): 44% +/- 2%

VOC Mixed (Single Component): TS401 White Enamel
(EPA Method 24): 423 g/l (3.53 lb/gal)

Note: The VOC level will vary per color.

Weight Gallon: 9.3 lb/gal ± 0.2 lb/gal

Pot Life: 10 Hours at 77°F (25°C) w/BX015 (optional)

Shelf Life: 2 years at 77°F (25°C)

Note: For unopened product

Surface Prep

Surfaces to be finished must be clean, dry and free of dirt, oil or any contamination that would adversely affect adhesion, protective properties or appearance of the coating.

Prepare metal surfaces to SSPC-SP2, SSPC-SP3 for normal requirements.

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Note: for optimal corrosion resistance and adhesion, iron phosphate treatment is recommended and/or P300 Series Metal Primer.

All other substrates contact your Crown representative

Application Method

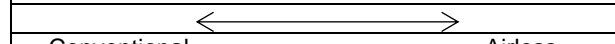
Crown Equipment Enamel can be applied by brush, roller, conventional air, air-assist airless, airless, electrostatic and/or heated equipment.

Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-1.8 mm	30-40 psi	
Pressure Feed	1.4-1.8 mm	50-60 psi	10-14 oz/min
Air Assist Airless	0.009-0.017"	1,000-1,800 psi	
Airless	0.011-0.015"	1,700-3,000 psi	

Note: Do not spray catalyzed material with heated spray equipment.

Spray Viscosity

70-75KU at 77°F	Reduce as necessary*
	
Conventional	Airless

Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish.

Note: Material is packaged at a viscosity requiring little or no reduction for application by airless spray equipment.

IF THINNING IS REQUIRED:

Cool Weather: Below 65°F (18 °C)
Use: Toluol/TS100

Normal Weather: Below 65°F- 80°F (18 °C-27 °C)
Use: Xylol /TS105

Hot Weather: Above 80°F (27 °C)
Use: Xylol /TS105
 SC-100 or SC-150 can be used as a retarder solvent to reduce dry spray and increase flow and leveling. Limit the level of SC-150 to 5% as a retarder solvent.

Note: VM&P Naphtha or Mineral Spirits may be used.

Film Build

Crown Equipment Enamel has a recommended film build thickness of:

Wet (unreduced): 3-6 mils wet (75-150 microns)

Dry: 1.3-2.5 mils dry (32-65 microns)

Theoretical coverage at 1.0 mil (25 microns)
 DFT: 705 ft² per gallon at 100% transfer efficiency.

Dry Times

	70°F (21°C)
To Touch	2 Hour
To Handle	6 Hours
To Recoat	8 Hours
Through Dry	18 Hours

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Optimum drying conditions are 60°F to 90°F (16°C to 32°C) at 50% R.H.

Lower temperatures and high humidity will slow dry.

Surface must be dry and at least 5°F above the dew point.

Note: Product may also be force cured to enhance dry. Force cure temperatures in the range of 110-180°F may be utilized to accelerate solvent evaporation and speed oxidation.

Clean Up

Clean all equipment immediately after use with xylol, aromatic solvent, acetone, or MEK for spray guns and line, pots and other equipment

Follow manufacturer's safety recommendations when using any solvent.

Ordering Information (sizing)

Available in Aerosol, Gallon, 5-gallon, 55-gallon drum, and 300 gallon tote.

Custom colors and sizes may be available.

Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be above 50°F (10°C). To prevent condensation during application the surface temperature must be 5°F (3°C) or more above the dew point at all times.

Note: For use outside this range please contact your Crown Representative.

Specifications

Test	Method	Result
Salt Spray / Corrosion	ASTM B117	240 hours. no field rusting, less than 1/8" creep from scribe 336 hours w/P315
Adhesion:	ASTM D3359	5A; 100% B-1000 panel
Impact resistance	ASTM D2794	20 lbs direct 10 lbs reverse
Flexibility	ASTM D522	1/8 mandrel bend: Pass

Storage Conditions

Storing partially used container:

Pour a small amount of the recommended thinner over the surface.

Do not stir. Replace lid securely.

Store away from heat or open flame

Mix thoroughly before reusing.

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be obtained by contacting Crown Paint.