

Corral Coat Enamel

Stock Colors

Technical Data Sheet (TDS)

Product Description

Crown Corral Coat is a single component medium oil alkyd all-purpose exterior use industrial enamel. Corral Coat may also be catalyzed with Polyurethane Converter to create a hard, solvent, and chemical resistant finish. Corrosion properties may be enhanced with P-Series Metal Primers.

Product features:

- Good color retention
- Good gloss retention
- Good Corrosion resistance
- Low to No HAPS
- Brush, roll, spray application
- Lead, chromate, and heavy metal free
- Available in various colors

Recommended Uses

Corral Coat is intended for industrial applications, either new build or maintenance. Corral Coat is ideal for exterior metal pipe and fence coating

Industries:

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

Mixing

Corral Coat: Used as Single Component
Stir each container thoroughly prior to use.

Corral Coat
Used as a Two Component Catalyzed Product
Mix:

8 parts by volume of Corral Coat [XXXXX]
 1 part by volume of Urethane Converter [BX015]

Note: Due to limited potlife, never leave catalyzed paint in spray equipment. Clean immediately. Do not spray catalyzed material with heated spray equipment.

Product Characteristics

Typical Physical Properties Single Component	
Gloss:	Semi: 40-70 GU at 60°
Volume Solids: (Single Component Unreduced) E527- White	55% ± 2%
Volume solids will vary by color	
VOC (Unreduced): EPA Method 24 E527- White	367 g/l 3.059 lb /gal
VOC content will vary with each color	
Shelf Life:	
Corral Coat Enamel	2 years
For unopened product (77°F (25°C))	
Weight Gallon: E527- White	10.63 ± 0.2lb/gal
Used as a Two Component Catalyzed Product	
Pot Life: (77°F (25°C) and 50% RH) With Optional BX015	10 Hours

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.

Note: for optimal corrosion resistance and adhesion, iron phosphate treatment is recommended and/or P300 Series Metal Primer. For rusty surfaces Pre-Prime Rust Converter may be used.

For questions regarding other substrates contact your Crown Representative.

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Application Method

Corral Coat is best applied by painter's mitt, or pipe paint roller.

Corral Coat can be sprayed if required with conventional air, air-assist airless, airless, electrostatic, and/or heated equipment, however, it will require thinning to achieve sprayable viscosity

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	9 -17 Thou	1,000-1,800 psi	
Airless	11-15 Thou	1,700-3,000 psi	

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

Spray Viscosity

Supplied Viscosity- [77°F (25°C)]	
Stormer Viscometer	90 – 100 KU

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

IF THINNING IS REQUIRED:	
Temperature Range	Recommended Thinner
Below 65° F (18° C)	Toluol /TS100
65° F- 80° F (18-27° C)	Xylol /TS105
Above 80°F	Xylol /TS105
Above 80°F: 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 should never be used.	

Film Build

Corral Coat has a recommended film build thickness of:

Wet: WFT Unreduced	3.0 – 5.5 mils	75 – 140 microns
Dry: DFT	1.5 – 3.0 mils	37 – 75 microns

Theoretical coverage at 1.0 mil (25 microns) DFT: 882 ft² per gallon at 100% transfer efficiency.

Dry Times

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

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 time. Surface must be dry and at least 5°F(3°C) above the dew point.

Note: Product may also be force cured to enhance dry. Force cure temperatures in the range of 110-180°F (43 - 82 °C) 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.

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Ordering Information (sizing)

Package sizes available:
Aerosol, 1 gallon, 5 gallons, 55 gallon drum,
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.

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.