

Equipment Enamel

Stock Colors

Technical Data Sheet (TDS)

Product Description

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

Corrosion properties may be enhanced with P-Series Metal Primers.

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

Equipment Enamel is intended for industrial applications, either new build or maintenance. Equipment Enamel is recommended for use on a wide variety of metal substrates and wood applications.

Industries:

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

Mixing

Equipment Enamel: Used as Single Component
 Stir each container thoroughly prior to use.

Equipment Enamel used as a Two Component Catalyzed Product.

Mix:

8 parts by volume of Equipment Enamel [XXXXX]
 1part by volume of Polyurethane convertor [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:	High: 85 +GU at 60°
Volume Solids: (Single Component Unreduced) TS401- White	47% ± 2%
Volume solids will vary by color	
VOC (Unreduced): EPA Method 24 TS401- White	422 g/l 3.526 lb /gal
VOC content will vary with each color	
Shelf Life:	
Equipment Enamel	2 years
For unopened product (77°F (25°C))	
Weight Gallon: TS401- White	9.3 ± 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 questions regarding other substrates contact your Crown Representative

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Application Method

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	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	70 – 75 KU

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

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

Equipment Enamel has a recommended film build thickness of:

Wet: WFT Unreduced	3.0 – 5.5 mils	75 – 140 microns
Dry: DFT	1.3 – 2.5 mils	33 – 64 microns

Theoretical coverage at 1.0 mil (25 microns)
 DFT: 753 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.

Safety Precautions

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