PPG TrueFinish
Industrial Coatings

SPECTRACRON® 100 SERIES ACRYLIC MODIFIED ALKYD ENAMEL

DESCRIPTION:

SPECTRACRON® 100 SERIES Acrylic Modified Alkyd Enamel is recommended for industrial use on pretreated or primed metal surfaces. Suitable applications include metal fabrication, castings, machinery and heavy equipment.

HIGHLIGHTS:

- Fast drying
- Contain no heavy metals
- Available in a wide range of colors and gloss
- Optional enhancer provides wider recoat window

TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT*
Color		Custom Colors
Gloss @ 60° Angle	ASTM D523	20 - 90
Pencil Hardness	ASTM D3363	HB - H
Conical Mandrel	ASTM D522	Pass
Adhesion	ASTM D3359	5B – Excellent
Humidity Resistance – 100 Hrs.	ASTM D2247	Good
Salt Spray Resistance – 200 Hrs.	ASTM B117	Good
Chemical Resistance		Good
Substrates		CRS, HRS, Aluminum
Recommended Primer(s)		SPECTRACRON: 111, 135, 501, 531, 560, 701, W43181A

*These results were obtained over iron phosphated CRS panels.

PHYSICAL PROPERTIES:

PROPERTY	VALUE*	BLENDED VALUE**
Weight per gallon	8.5 ± 1.0 lbs./gal.	8.0 ± 1.0 lbs./gal.
Weight Solids (%)	45.2 ± 6.0	46.3 ± 6.0
Volume Solids (%)	36.0 ± 3.0	39.0 ± 3.0
VOC (less exempts)	5.0 lbs./gal. (max.)	5.0 lbs./gal. (max.)
VOE (actual)	5.0 lbs./gal. (max.)	5.0 lbs./gal. (max.)
Coverage (@ 1 mil, no loss)	525 – 600 sq. ft./gal.	525 – 600 sq. ft./gal.
Flash Points:	79°F (26°C)	79°F (26°C)
SPECTRACRON 3501		355°F (179°C)
Shelf Life - unopened container	2 years	2 years QT100, 1 year Q3501

*Values listed will be color dependent.
** Values Blended 19:1 with optional Q3501 enhancer

Revision Date: 2/2011

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SURFACE PREPARATION:

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating will improve the performance properties of the coating system. See your PPG Representative for recommendations.

APPLICATION DATA:

Mixing Instructions:	Stir thoroughly before and during use
Optional Enhancer:	19 parts SPECTRACRON 100 (QT100) : 1 part SPECTRACRON 3501 (Q3501) By volume. Mix thoroughly.
Wet Film Thickness:	2.5 – 5.5 mils
Dry Film Thickness:	1.0 – 2.0 mils
Thinner:	Up to 10% Xylene (Q80), Aromatic 100 (Q50), or MAK (Q70)
Application Viscosity:	25 - 35" #2 EZ Zahn
Clean up:	Q60 (MEK) or Q30 (acetone)
Pot Life (@77°F):	With optional enhancer, 10 hours after mixing

SPRAY APPLICATION ++	SPRAY EQUIPMENT*	FLUID PRESSURE (psi)	ATOMIZATION PRESSURE (psi)	FLUID NOZZLE	AIR NOZZLE
Conventional	Binks 2001	20 - 25	50	66SS (0.070", 1.8mm)	67PB
Conventional	DeVilbiss MBC-510	20 - 25	50	E (0.070", 1.8mm)	92
Air Assisted Airless	Graco G-15	900 - 1300	20 - 40	0.017 - 0.019"	249596
HVLP	DeVilbiss JGHV	20 - 25	50 - 55**	E (0.070", 1.8mm)	83MP
Airless	Graco G-40	1400 - 2000	n/a	0.017 - 0.019"	n/a

*or equivalent

**atomization pressure should read <10 psi @ the cap

++ Addition of 5% MAK (Q70) will help pattern, atomization, and wrap when applying electrostatically.

CURE SCHEDULE:

Air-dry (assumes 77°F & 50% Relative Humidity)

	Without Enhancer	With Enhancer
To Touch:	30 min.	2 hrs.
To Handle:	1.5 – 2 hrs.	3 hrs.
To Recoat:	Before 6 or after 30 hrs.	3 hrs. up to 4 days

Bake / Force Cure

Flash Time:	10 min. (ambient)
Substrate Temp:	180°F
Bake Time:	20 – 30 min.

ADDITIONAL INFORMATION:

- Do not apply at temperatures below 50°F
- Higher gloss will result if force dried (gloss will also be higher if optional enhancer is used)
- Excess film thickness will retard dry times and affect the recoat window
- Paint film is not fully cured for 7 days.
- In-Service Temperature: 220°F
- Not recommended for use on galvanized, galvaneal or zinc rich surfaces

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