



Technical Data Sheet

Allcolour Paint Ltd.. Tel: 905-827-4173 Fax: 905-827-6487

01-Line

Alkyd Air Dry Equipment Enamel

Allcolour 01 Line equipment enamels are specially formulated to provide excellent exterior colour and gloss retention in a single component alkyd system.

- Farm equipment
- Construction equipment
- Material handling equipment
- Light to moderate service environments
- Trailer Refurbishing

Outstanding Characteristics

- Tough, hard flexible films
- Excellent exterior durability

Physical Data

Finish:	Full Gloss
Colour:	Full range of industrial colours, see colour card*
Weight	37.0% - 55.0%
Solids:	
Volume	30.0% - 35.0%
Solids:	
VOC:	550 gms/ltr

Resistance Table –

- Very good oil resistance
- Very good gasoline resistance
- Excellent colour and gloss retention

Recommended Primer Systems

- 03-1025 White AC PM Primer LF
- 03-3061 Yellow AC PM Primer LF
- 03-4038 Grey AC PM Primer
- 03-5039 Red Oxide AC PM Primer
- 03-9026 Black AC PM LF Primer

*Allcolour standard enamels are manufactured using modern lead-free pigment systems. Allcolour enamels are used in a wide variety of applications. A general-purpose pigment system has been selected to give a reasonable balance of cost and performance. Please note certain colours (notably bright reds, oranges, and yellows) are inherently less colour fast than systems based on leaded pigments. If outdoor colour permanence is important, these colours can be formulated using leaded pigment systems or alternatively (at an increased cost) improved permanence lead-free pigments. If you have any questions regarding the performance of a particular colour, please ask your sales representative.



Surface Preparation

Ferrous (Steel)	Must be clean and free from dirt, oil, grease, rust or other contaminants. Sandblasting to SSPC SP-6 or better is recommended. Proper surface preparation will enhance the performance of the coating system.
Aluminum	Clean using an appropriate conversion treatment then prime with Allcolour 36-6001 or 36-6018 Vinyl Wash primer.
Wood	Must be dry and sealed with appropriate primer such as Allcolour 03-5071 Red Oxide LF Primer



Instructions for Use

Application...
Application
Instructions....

Can be custom formulated to meet a wide variety of application requirements.



Mixing Instructions

Components:	One
Reducer:	20-4000 or 20-4001 (see reverse)
Shelf Life...	1 year from shipment date



Viscosity

Viscosity... 85" +/- 5" #4 Ford Cup

Application Method

- Conventional Air Spray** Reduce up to 30% with 20-4000 or 20-4001 to 20-25 seconds #2 Zahn Cup.
- Air Assisted Airless** Reduce up to 20% with 20-4000 or 20-4001 to appropriate viscosity to suit the particular spray equipment, tip size and pressure.
- Airless** Reduce up to 15% with 20-4000 or 20-4001 to appropriate viscosity to suit the equipment in use, tip size and pressure.
- Electrostatic Spray** Some adjustment for polarity may be necessary. If adjusting with alcohol going below 2 mohms may result in low gloss.
- Dip** Adjust reduction to allow appropriate run off based on part configuration.
- Brush or Roller** Use as supplied.

Do not paint unless the temperature is a minimum of 5°F (3°C) above the dew point.

Recommended Film Build Thickness & Cover Rate

Allow for application loss and surface irregularities.
 Total Dry Film Recommendation..2.0-3.0 mils dry
 Calculated Coverage

1.0 Mil...	480 - 560 ft ² /usg
25 microns DFT	11.7 - 13.7 m ² /L

Dry Time

Dry time @25°C, 77°F 50% Rel. Humidity

To Touch:	1-2 Hours
Tack Free:	2-4 Hours
To Recoat:	2 Hours
Hard:	24-48 Hours

Clean Up

Cleaner: 204100

Storage & Shipping

Flash Point... 24°C Setaflash CC 75°F

Safety Precautions

Please refer to the Material Safety Data Sheet (MSDS) for information regarding health, physical and environmental hazards, handling precautions and recommended first aid procedures. For industrial and automotive use only

Other

01-Line enamels may be reduced with a variety of solvents, however different solvents will affect the reduction rate, set times and recoatability. We recommend aliphatic solvents to allow for better recoatability..

Temperature range at application:
 50-65°F (10-20°C) Allcolour 20-4000, 20-4100*, 20-4101*
 65-85°F (20-30°C) Allcolour 20-4001, 20-4000, 20-4100*, 20-4102*
 85-110F (30-40°C) Allcolour 20-4001, 20-4102*

*may cause recoat problems with itself if touchup is necessary.**20-4100 may lower gloss in some cases.