

220 OEM Quick Dry Alkyd

Updated: January 2015

Specification Data

Generic Type: Chain stop alkyd

Description: APCO 220 is a proven, fast drying, thin film, economical coating. Provides tight barrier protection to properly prepared steel surfaces. Quick dry time ensure high production rates and limited bottlenecks in the paint booth. Available in a wide range of factory colors and almost limitless range of tinted colors.

Features:

- High Gloss
- Fast Drying
- Can be applied Direct-to-Metal
- Available in a full range of colors

Solids Content: 40% by Volume

Theoretical Coverage:

- 641 mil ft²
- 256 ft² @ 2.5 mil DFT

Allow for loss during mixing & application.

VOC Value:

- 4.3 lbs/gal per EPA Method 24
- VOC value is average. For color specific see Product SDS

Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

Immersion Carbon Steel: Not Recommended

Non-Immersion Carbon Steel: Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 1.5-3.0 Mil.

Galvanized Steel: Not recommended

Previously painted surfaces: Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

Primer: APCO 215QP Quick Dry Primer, 245FP Universal Primer, 351 Epoxy Primer

Application Equipment

Spray Application:

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2001 Gun w/66 series nozzles and 565 needle.
- **Airless:** Graco 36:1 Min. 1/4" material line. Tip size .013. Output PSI- 3000-3600

Brush & Roller: Touch up only

- **Brush:** Natural Bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

Mixing & Thinning

Components: One

Mixing: Power mix to uniform color & consistency

Thinning:

- **Spray:** Up to 12 oz/gal with S100

Application

Pre-application: Flush all equipment with thinner S100

Temperature: Application range from 40°F-110°F surface temperature. Do not apply below 40°F.

Method: Apply one coat maintaining a wet edge to achieve a WFT of 4-6 Mils. Maximum performance will be achieved with two coats totaling 4-6 mils DFT.

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Application Continued

Inspection: Visually inspect film to ensure adequate coverage.

Clean up & disposal: After use immediately flush all equipment with thinner S108 or M.E.K. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

Curing schedule:

Times based upon 75°F

Dry to touch: 20 minutes

Dry through: 48 hours

A critical re-coat time may occur between 2 and 48 hours at room temperature. This may fluctuate depending on temperature and film thickness. Test small inconspicuous area first.

Dry times are greatly affected by weather conditions and film thickness.

Packaging & Handling:

Unit sizes: Ones, Fives and Drums

Shipping Weight: 10 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII