

**DESCRIPTION** Modified synthetic alkyd fast dry enamel

**USE** This product is a fast drying, abrasion resistant gloss enamel. It is designed for spray application, but can be dipped as well. 28 Series' principal use is as a finish coat for equipment and fabricated metal. It is recommended for machinery, construction, transportation and material handling equipment, and ornamental and architectural metals. Its dry film is resistant to alkali, oil, grease, and corrosive fumes.

**APPLICATION** Stir thoroughly before and during use. Apply when the air, product, and surface temperature are above 50°F (10°C) and at least 5°F (3°C) above the dew point.

Spray Type	Material Supply	Spray Gun	Tip/Fluid Nozzle	Air Cap
Airless	Pump .75 gpm or greater	Airless	.013-.015" tip	N/A
HVLP	Pressure tank	Binks HVLP MACH 1	94 (.055") nozzle	Pressure type
Conventional	Pressure tank	Conventional	.040-.046" nozzle	Pressure type
Conventional	Siphon Cup	Conventional	.070" nozzle	Siphon type

**REDUCERS** For spray, use T-4 VM&P Naphtha, T-9 Xylol, T-23 Toluol, T-3 Mineral Spirits, or T-83 Lacquer Thinner. For dipping, T-12 Dipping Thinner or T-9 Xylol are suitable. For brushing, use as received. For spray, reduce to 25-35" #2 Zahn Cup. For dipping, reduce to 18- 25" #2 Zahn Cup, depending on part size and configuration.

	Normal 77°F (25°C), 50% R. H.,	As Supplied	With 12C6 Hardener (8 oz./gallon)
Dust Free		5 min.	5 min.
To Touch		35 min.	25 min.
To Handle		45 min.	35 min.
Hardness @ 24 hours		HB	F

**HARDENER** Use 8 oz/gal of 12C6 Hardener to reduce cure time, and increase hardness. Pot life: 8 hrs when mixed.

**FORCE DRY** Force dry 20 min. @ 250°F (121°C). Force drying 12C6 Hardener above 100°F (38°C) may cause some lighter colors to yellow.

**PREPARATION** The surface to be painted must be free of dirt, grease, oil, rust, water, mill scale, soap residue, wax, and loose paint. Clean bare, unprimed metal in accordance with Steel Structures Painting Council SSPC-SP2, Hand Tool Cleaning or SSPC-SP3, Power Tool Cleaning, minimum. Surfaces previously painted should be abraded for proper adhesion.

**PRIMERS** Ferrous Metal: 3R17 Red, 3R25 Red, 3E11 Gray, and 3E19 Gray. Nonferrous Metal: 5G1 Metal Pretreatment.

**CLEAN UP** Clean equipment with T-4 VM&P Naphtha, or any of the above reducers.

**SAFETY** Danger! Flammable Liquid and Vapor. Harmful or Fatal If Swallowed. Vapor Harmful. Contains: VM&P Naphtha and Mineral Spirits. See product label and MSDS for additional safety and health information.

PRODUCT NO/COLOR	Industrial Color Card	FLASH POINT	55°F, Setaflash
GLOSS	90 min. (60° Head)	PACKAGING	5 gal, 1 gal, 12 oz. aerosol
SOLIDS BY WEIGHT	58% (28W1)	THEORETICAL COVERAGE	657 ft2/gal @ 1.0 mils dry
SOLIDS BY VOLUME	41% (28W1)		(2.44 mils wet) (28W1)
VISCOSITY	68-72 Krebs Units	RECMN'D COVERAGE*	439 ft2/gal @ 1.5 mils dry
WT/GALLON	8.9 ± .1 lbs (28W1)		(3.65 mils wet) (28W1)
VOC	448 g/l, 3.74 lbs/gal (28W1)	SHELF LIFE	1 Yr. Subject to reinspection thereafter