

DESCRIPTION	Water Reducible Acrylic Modified Alkyd
USE	324 Series product is a direct-to-metal coating recommended as a one coat finish system for fabricated metal when exterior exposure with good gloss retention is required. The product is low in VOC and nonflammable. For additional corrosion protection, a rust inhibiting metal primer is recommended.
APPLICATION	Stir thoroughly, but excessive agitation may cause bubbling and reduce viscosity. Apply when the air, product, and surface temperatures are above 50°F (10°C) and at least 5°F (3°C) above the dew point. AIRLESS SPRAY: TIP SIZE: .019"-.021". HVLP SPRAY: FLUID NOZZLE: .070". CONVENTIONAL SPRAY: FLUID NOZZLE: .070".
THINNING	AIRLESS SPRAY: Use as received. HVLP SPRAY: Use as received.
PREPARATION	Surface must be free of dust, grease, oil, rust, mill scale, soap residue, and other surface contaminants. Remove surface contaminants by mechanical or chemical means. Steam cleaning, high pressure hot water detergent cleaning, and phosphate stage cleaning are acceptable. Water-based detergent cleaners must be thoroughly rinsed to remove soap residue. Aluminum must be primed with 5G1 Metal Pretreatment or 305A1 Waterborne Wash Primer for adhesion.
DRYING TIME	Normal 77°F (25°C), 50% R. H. TO TOUCH: 30 min. TO HANDLE: 1 hr. FORCE DRY: 10-20 min. @ 150°F part metal temperature. Drying times will be extended by high humidity, cold temperatures, increased film thickness, and metal mass.
PRIMERS	Universal primers 3R17, 3R25 Red; 3E11, 3E19 Gray.
CLEAN UP	Clean equipment immediately after use with hot water. Clean fluid lines by rinsing with hot water until water rinses clear. Store water or paint in lines for brief periods to keep air from drying paint residue in lines. For longer periods, flush with water until clean, rinse with lacquer thinner to dry lines. DO NOT rinse lines with solvent first. Soak spray nozzles and gun tips with water.
SAFETY	DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN. FOR INDUSTRIAL USE ONLY. Keep from freezing. Observe all precautionary information on product label. See Product Material Safety Data Sheet for additional health warnings and information.
TOXICITY	All 324 Series product is lead and chromate free.

TYPICAL PROPERTIES			
PRODUCT NO/COLOR *	Industrial Color Card *	FLASH POINT	>100°F, Setaflash Closed Cup
GLOSS (60°) *	60 - 85 *	PACKAGING	55, 5, and 1 gal,
SOLIDS BY WEIGHT*	39% (324W1)	THEORETICAL COVERAGE	417 ft ² /gal @ 1.0 mil dry (324W1)
SOLIDS BY VOLUME*	26% (324W1)	RECMN'D COVERAGE	278 ft ² /gal @1.5 mil dry (324W1)
VISCOSITY *	68-72 Krebs Units	VOC	346 g/l, 2.88 lbs/gal (324W1)
WT/GALLON *	9.7± .1 lbs (324W1)	SHELF LIFE	1 Year

- The color, gloss and viscosity of 324 Series enamel can be adjusted to meet specific requirements in minimum order quantities of 25 gallons. These adjustments may cause small variations in physical properties; e.g. weight, VOC, Flash Point, etc. The data shown reflects expected minimums. Colors will be produced from dry-pigment grinds to ensure good coverage, gloss can be adjusted to optimize appearance and hide, and viscosity can be adjusted to accommodate application techniques.