



ICS FLEET DRY ALKYD TINT BASES

- IB-0562.....CLEAR BASE
- IB-1560.... WHITE BASE
- IB-1561.....DEEP BASE
- IB-2563.....METALLIC BASE

M. Entwell

PRODUCT DESCRIPTION:

Fleet Dry was developed as a fast drying, versatile, industrial finishing enamel for manufacturers of metal products. This enamel offers a quick dry time, high gloss, and good color and gloss retention. Fleet Dry is ideal for industrial OEM uses, including agricultural and construction equipment.

PHYSICAL PROPERTIES (Typical):

Weight Solids	39%
Volume Solids	33%
Resin Type	Alkyd
Gloss	90+ @ 60°
Theoretical Coverage	523 ft ² @ 1 mil
Weight Per Gallon	8.0 lbs.
VOC	4.8 lbs/gallon
Viscosity @ 77°F	60 KU
	47 - 52 seconds #2 Zahn
	18 - 21 seconds #3 Zahn

SURFACE PREPARATION:

The service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminants, including salt deposits.

Fleet Dry may be applied over steel and other properly prepared substrates. Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing. Aluminum and galvanized should be treated with appropriate metal cleaners and conditioners, including a vinyl wash primer or acrylic latex primer. For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast to SSPC-SP-6 (to an average profile of 1.5 mils) and then coated before flash rusting occurs. For long term corrosion protection, a primer is recommended.

REDUCTION:

Fleet Dry may be reduced with most aromatic solvents. Xylene (N-3023) would be the recommended "fast" reducer for application in cooler temperatures. D-100 (N-3065) can be used as a "slow" reducer to help the applied coating flow during warmer conditions.

APPLICATION:

This enamel may be used for one-coat, direct to metal applications; however a primer is required for long term corrosion protection.

For air spray (conventional) reduce approximately 20 - 30% by volume. Viscosity should be in the 18 - 30 second range #2 Zahn cup. For airless or air-assist airless application, apply Fleet Dry without reduction or reduced up to 15% by volume. Airless tip sizes should be in the .011 to .015 range.

Dry Film thicknesses required are 1 - 3 mils above profile in a minimum of two full wet coats. Recoat at tack free or up to approximately 8 hours. After 8 hours apply a small test patch to check for evidence of lifting before proceeding with a full recoat.

N-7019 Urethane Hardener can be used (8-1 ratio) for enhanced cure, gloss, and abrasion resistance. A 15 minute induction period is required before thinning. The pot life will be approximately 24 hours. If a hardener is used, Fleet Dry must be applied over a primer.

DRY TIMES:

Fleet Dry will dry to handle in about 30-60 minutes depending on film thickness, humidity, temperature, and air movement. Dry through times may take several days or more. Full adhesion may be gained after 4 - 7 days drying time. Always check for evidence of lifting before proceeding with a full recoat. Lifting will typically occur between 8 - 48 hours.



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CLEAN UP:

Use xylol to flush paint lines. N-9000 Gun Cleaner can be used for removing dried coatings.

PERFORMANCE CHARACTERISTICS:

(Typical, tested on B-1000 panels at 1.0 - 1.5 mils DFT)

low exposure - after one year facing south at a 60° angle - less than 10% loss of gloss at 60°.

SAFETY PRECAUTIONS:

Contains aromatic solvents. Vapor and spray mist harmful. Use proper respiratory protection.

Refer to MSDS for specific information.

All information subject to change without notice.



Vogel Paint & Wax Co., Inc.
1020 Albany Place SE
PO Box 80
Orange City, IA 51041-0080
PH: (712) 737-4993
www.vogelpaint.com