



Head Office
Red Deer, Alberta
Phone: 403-314-2221
Fax: 403-314-2226
Web Site: www.hpc.ca

5000 Industrial Enamel

Material Description

A high quality emanel, providing a full gloss, with excellent impact resistance and weatherability. Available in a wide range of custom colors.

Intended Applications

For use on equipment, machinery, piping and other metals in inditrial atmospheres.

Colors Available	Finish
Various colors available	Gloss 80+ @ 60 deg.

Physical Properties

Resin System	Pigment System
Alkyd Resin	Dependant on color

Solvent System	Packaged Viscosity
Aliphatic and aromatic hydrocarbons	9.0 +/-0.5 Poise @25C depending on color

Solids by Weight	Solids by Volume
37.9% depending on color	27.1% depending on color

Theoretical Coverage	Total VOC
114 sq ft/L	557 g/L

Wet Film Thickness	Dry Film Thickness	Specific Gravity
5.2 - 7.4 mils	1.4 - 2.0 mils	Dependant on color

Dry to Touch *	Dry to Handle *	Dry to Recoat *
2 hours	6 hours	2 hours

Coats Required	Components	Pot Life Hours
1-2	1	N/A

Recommended Thinners	Use With
Xylene or TS-28 Slow Reducer	N/A

Additional Application Notes

* Times listed are at 25°C. Temperature and humidity will affect dry and recoat times.



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Required Surface Preparation and Application Parameters

Surface Preparation	Surfaces must be free of dirt, grease, and oil. Steel surfaces must be thoroughly cleaned, a minimum SSPC SP-3 power tool cleaning is required.		
Atmospheric Conditions	Surface and product temperatures must be at least 10 deg C (50 F) and at least 3 deg C (5F) above dew point. Apply in dry weather when relative humidity is less than 85%.		
Blend Ratio	N/A		Induction Period
Reduction	Airless (5-10%) / A.A. Airless (10-20%)		
Application Viscosity	Airless (28" Z #2) / A.A. Airless (24" Z #2)		
Force Cure	30 mins @ 70 deg C (160F) after 15 min flashoff		
Airless Pressure	1400-2000 PSI min at tip	Airless Tip Size	0.009" - 0.013"
AA Airless Pressure	850 PSI min at tip	AA Airless Tip Size	0.009" - 0.013"
AA Airless Air Pressure	30 - 60 PSI		
Conventional Spray			
Brush	Polyester or nylon	Roller	Short nap
Procedure Part 1	Rinse all equipment with thinner prior to and after application.		
Procedure Part 2	When application is made by airless or air assisted airless, use and inbound pressure approx. 10-15 lbs above the level at which "fingering"		
Procedure Part 3	Special attention should be given to all edges, pits, welds, corners, rivets and other rough spots to insure complete coverage.		

Additional Information

Package Sizes	3.78 litre, 18.9 litres, 205 litres
Safety Information	See label precautions and MSDS.

Date Issued	20/04/2004	Supersedes	new issue
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The above information is given in good faith and to the best of our knowledge. Every reasonable precaution is taken in the manufacture of all products and compilation of data to ensure that they are consistent with the Manufacturer's standards. As the effectiveness of each product depends, in part, on correct methods of use and application, and since the conditions of the surface, application and method of use are beyond our control, no guarantee of such products or this data is made or implied by this. By virtue of this disclosure, it is the responsibility of the buyer to satisfy itself of the suitability of the goods for its own particular process and it will be deemed to have done so by virtue of accepting the goods on this understanding.