



Acrylic Modified Enamel Base

Acrylic Modified Enamel Base is a fast drying, economical industrial alkyd enamel. It is suited for quick, easy, low build protection of steel, aluminum and glass reinforced plastics. This is a tintable base and can be used to make any of the more than 15,000 colors in the Paladin Industrial Coatings range.



Mix Ratio

Ready to Use.
Can be reduced up to 20% with Paladin Zero VOC Reducer.



Suitable Substrates

- Mild steel
- Galvanized iron
- Glass reinforced polyester (GRP & general types of fiberglass body parts)
- Aluminum
- Previously painted substrates in sound condition



Surface Prep & Application

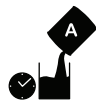
Sand and clean all areas prior to application with SCAT Wax & Grease Remover. Ensure all residue is removed prior to application. Lightly rusted surfaces must be treated with a Metal Converter.

Apply 1 coat followed by 2 medium wet coats.
Avoid heavy wet coats.



Flash/Dry Times (Air Dry) @ 77°F (25°C)

Flash Between Coats: 5 minutes.
Air Dry (to handle): 4 hours.



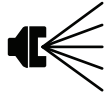
Pot Life

Indefinite unless activated.
If activated, 3 – 4 hours @ 77°F (25°C).



Gun Set-up

Gravity Feed	1.3 – 1.4 mm
Suction Feed	1.2 – 1.3 mm
HVLP/LVLP	1.3 – 1.4 mm



Air Pressure

Gravity/Suction Feed	30 – 35 psi at the gun
HVLP/LVLP	6 – 10 PSI at the gun



Technical Data & Physical Properties

Mix Ratio.....	RTU	Pot Life	6 hours
Theoretical Dry Film.....	245 ft ² @ 6.0 mil	Dry Film Thickness	2.0 mils
Volume Solids	49.1%	Weight Solids.....	70.1%
Viscosity	BSB 4 Cup 18 – 19 s; Ford 4 Cup 16 – 17 s		
<u>19-311-20</u>			
Actual VOC.....	2.3#/gal (276g/l)	Regulatory VOC.....	3.22#/gal (386g/l)
<u>19-311W-20 (White)</u>			
Actual VOC.....	2.05#/gal (246g/l)	Regulatory VOC.....	2.93#/gal (351g/l)
<u>19-311B-20 (Black)</u>			
Actual VOC.....	2.3#/gal (276g/l)	Regulatory VOC.....	3.21#/gal (385g/l)

Shelf Life - 36 months minimum from date of manufacture when maintained in protected storage @ 40 – 100°F (4° – 38°C) (subject to inspection thereafter).



Limitations

- Stir or shake for a minimum of 10 minutes before use.
- Never leave the mixture standing for more than 30 minutes before mixing.
- Use proper weights and measures per the color formulation.
- Color check is recommended prior to application.
- Surface temperature must always be a minimum of 37°F (3°C) above dew point.



Safety

Read all directions, safety warnings and SDS before using any Paladin Industrial Coating Products. **For use by professionally trained painters only. Not for sale or use by the general public. Keep out of reach of children.**

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Paladin Industrial Coatings warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within one year from date of shipment, Paladin Industrial coatings will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Paladin Industrial Coatings and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.