



PRODUCT DATA

ANTICORROSIVE ENAMEL  
24-AX-5 Black

Modified Alkyd Copolymer

<b>PRODUCT DESCRIPTION</b>	A quality quick drying enamel for use on properly prepared ferrous metal. Lead and chromate free.		
<b>TYPICAL USES</b>	For industrial and commercial use including machinery, piping, wrought iron, structural steel, plant equipment and other metal surfaces.		
<b>PRODUCT ADVANTAGES</b>	ANTICORROSIVE ENAMEL is a decorative and protective coating for use in exposures including mild industrial and marine environments. Exhibits very good adhesion to properly prepared ferrous metals. Easy to apply, fast drying. Lead and chromate free.		
<b>COLORS</b>	Black. Special colors available subject to minimum order.		
<b>GLOSS</b>	Gloss		
<b>PHYSICAL CONSTANTS</b>	<b>Nonvolatile -</b>	By weight - 34.1 ± 2.0% By volume - 26.5 ± 1.0%	
	<b>VOC (Calculated) -</b>	5.01 lbs./gal. 600 grams/liter	
	<b>Flash Point -</b>	66°F (Setaflash)	
	<b>Weight per gallon -</b>	7.6 ± 0.2 lbs.	
<b>APPLICATION</b>	<b>Recommended Film Thickness per Coat -</b> 1.0 mils dry, 3.8 mils wet		
	<b>Theoretical Coverage @ 1.0 mils dry -</b> 425 sq. ft./gal.		
	<b>Method -</b> Conventional or airless spray		
	<b>Thinner -</b> XYLENE 75-15		
	<b>Dry time @ 75°F -</b>	To touch	- 15 minutes
		To handle	- 30 minutes
		To recoat	- 1 hour
<b>SHIPPING &amp; STORAGE</b>	<b>Consists of -</b>	1 Gallon Unit	5 Gallon Unit
	<b>Unit Shipping Weight</b>	8 lbs.	41 lbs.
	<b>Shelf Life -</b> 12 months minimum from date of manufacture when maintained in protected storage @ 40-100°F (subject to reinspection thereafter).		

## APPLICATION INSTRUCTIONS

Consult your Mobile Paint Representative for the protective coating system best suited for your requirements.

**Limitations** - Apply in good weather when air and surface temperature are above 40° F and surface temperature is at least 5° F above the dew point. For optimum application properties, material should be between 70 to 100°F prior to mixing and application. Maintain unmixed material in closed containers in protected storage at 40-100°F.

**Surface Preparation:** Good surface preparation is essential to a satisfactory coating system. Surfaces to be coated should be clean and dry. Remove all dirt, dust, oil, grease, mildew, loose or cracked paint or other contamination.

**New or Unfinished Surfaces - Ferrous Metal:** For best performance, application to abrasive blasted and primed surface is recommended. "Commercial Blast Cleaning" (SSPC-SP6) is recommended as minimum. Proper blast media and blasting equipment shall be used to produce an average profile depth of 1.5 mils minimum. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of surface occurs. If blasting is not feasible, remove rust by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3). For best performance, prime with a suitable metal primer. **Galvanized Metal:** Remove oil and prime with Vinyl Wash Primer 9-42. **Aluminum:** Clean thoroughly and etch with phosphoric acid based cleaning solution. Rinse well and allow to dry. Prime with Prymall 35 Zinc Chromate Primer or other suitable primer.

**Previously Finished Surfaces:** Repair all damaged areas. Remove gloss from previous paint by sanding or "Brush Blasting" (SSPC-SP7). Remove rust, corrosion products, heavy chalk and loose or peeling paint by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3). Spot prime any bare areas as in new work above. If doubt exists concerning compatibility of this coating with the previous system, apply coating to a representative area (25 square feet minimum) and allow to cure and age several weeks. Then inspect for adhesion failure, wrinkling, lifting, blistering or any other sign of incompatibility. If there are no signs, coating work can proceed.

**Tinting:** Do not tint.

**Mixing** - This is a one component coating. Always mix thoroughly with a power agitator before application.

**Thinning** - This product is supplied at normal spraying viscosity. If thinning is necessary, thin up to 1/2 pint per gallon with XYLENE 75-15. Regulations may not allow thinning. Check applicable regulations for VOC requirements before thinning or using this product.

**Application** - Apply by conventional or airless spray. Apply at 3.8 mils wet film thickness which will yield 1.0 mils dry film thickness.

**Equipment** - Conventional spray - For suction feed, use DeVilbiss MBC gun with E tip and needle and 30 air cap or equivalent at 40-45 psi atomizing pressure. For pressure feed, use DeVilbiss MBC gun with E tip and needle and 704 air cap or equivalent at 40-45 psi atomizing pressure and 5-8 psi fluid pressure, 3/8" ID material hose, double regulated pressure tank with oil and moisture separator. Airless spray - Minimum of 28:1 ratio pump, .011"-.013" orifice tip, 1/4" ID material hose.

**Cleanup** - Clean all equipment immediately after use with XYLENE 75-15. Completely flush all spray equipment with this solvent. Occasional flushing of spray equipment during the course of the working day helps prevent buildup and possible clogging.

**Safety** - Safe storage, handling and use dictate that adequate health and safety precautions be observed with this product and any recommended thinners. User is specifically directed to consult the current Material Safety Data Sheet for this product as well as precautions contained on product labeling.

**Notice** - The technical data contained herein are true and accurate to the best of our knowledge. All products are offered and sold subject to Mobile Paint Manufacturing Company's Standard Conditions of Sale. Published technical data and instructions are subject to change without prior notice.

24x5 (5/99)

## LIMITED WARRANTY

The successful performance of this product is highly dependent on many factors beyond our control. Results are highly dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Mobile Paint 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, Mobile Paint 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 Mobile Paint 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.