

DrumCoat™ WR

Waterborne VOC Compliant Steel Drum Finish

SELECTION DATA

DESCRIPTION:

DrumCoat, 317G Series drum enamel is a high quality, single component, VOC compliant, industrial water reducible polyester baking enamel. When properly cured it produce a durable, solvent resistant flexible film with an attractive, glossy finish. **DrumCoat** is designed for spray application directly to properly cleaned steel or iron surfaces without the use of a primer. **317 Series** will deliver lasting beauty and durability in a one coat application. **DrumCoat** offers a drum manufacturer an excellent value for coating steel drums with a good balance of desirable properties.

USE:

Primarily designed for use on new and reconditioned steel drums.

ADVANTAGES:

- High gloss.
- Solvent resistant.
- Superior adhesion and impact resistance.
- High spreading rate.
- High film build for blasted surfaces.
- Low VOC Water-Borne Formulation

LIMITATIONS:

- Not recommended for surfaces subject to continuous submersion or chemical contact.

PHYSICAL PROPERTIES

VOC: [including water] <200 g/l – (2.46 lbs./gal.)
 [excluding water] <75 g/l – (0.6 lbs./gal.)
 [actual VOC will vary depending on color]

APPEARANCE: [Gloss at 60°]

Gloss (G) 80 – 90

WEIGHT PER GALLON: [average] 10.5 lbs.

FLASH POINT: [setaflash] 150°F – (65.5°C)

PACKAGE VISCOSITY: [at 77° F]

As packaged & application: 20 sec. #3 Zahn

SOLIDS BY VOLUME: [average]

By Weight: 66 ± 1%

By Volume: 32 ± 3%

COVERAGE: [average]

Theoretical at 1 mil DFT 513 sq.ft./gal.

Recommended DFT per coat 1 mils

DRY SCHEDULE: [at 50% RH and 1 mils DFT]

HVHA oven with PMT @ 275° F 5 min.

COLOR AVAILABILITY:

317G Series is available in a wide range of colors in factory batch production with a minimum 55 gallon order. Please specify if colors are required to be lead and chromate free.

ORDER CODE: 317 + gloss + custom color #
 Individual products are identified by the product series number (317), gloss (G) and ending in the custom color number. 317G700 is **DrumCoat** gloss white.

PACKAGING: [average]

One ea. 55 gallon drum 530 lbs.

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TRIANGLE™



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APPLICATION DATA

REQUIREMENTS FOR APPLICATION:

- Surfaces must be free of moisture, corrosion, scale, rust and oxides, oil and grease dirt, all forms of silicone, waxes, etc.
- Performance over mill scale cannot be predicted.
- For optimum performance metal surface should be at 100 - 130° F. at application. Below 100° F. take appropriate measures to ensure adequate solvent evaporation prior to baking.

SURFACE PREPARATION:

A four stage iron phosphate surface pretreatment will provide the best product performance.

PRIMING:

For better corrosion resistance, use a VOC compliant water base epoxy baking primer.

FILM DEVELOPMENT & THICKNESS:

Optimum dry film thickness is 1.0 mils per coat. Use one coat over bare metal. Typical, acceptable DFTs range between 0.8 and 1.2 mils.

THINNING: Potable water as needed

Typical Values for:

- Airless Spray: 3 – 5% by volume
- Air Assisted Airless: 3 – 5% by volume
- HVLP Conventional Air:.....5 – 10% by vol. Max.

APPLICATION:

317 Series is designed for spray application. Use HVLP or air assist airless for production line finishing. NIOSH respirators, hoods and gloves are recommended when spraying. Stir product thoroughly prior to use. Use stainless steel equipment only.

Air Assist Airless:

- Set maximum fluid pressure as high as possible to 2,000 psi.
- Use a 0.011" tip and set air pressure as necessary to eliminate tails or orange peel

HVLP:

- Use a 0.040" – .055" fluid nozzles (1.0 - 1.4 mm).
- Set fluid and pressure as needed for 6" stream without air cap

- Set air pressure to gun at 60- 80 psi to provide 16 - 18 CFM and air cap pressure to 10 psi.

Conventional Spray:

- Fluid nozzle size .040" - .050".
- Air cap appropriate for available air, feed (pressure or siphon) and spray viscosity.
- Typical atomizing air pressure set at 60 to 80 psi and fluid feed pressure set at 20 - 40 psi.

CLEANUP: Water
Equipment rinse Mineral spirits.
Solvents AT17, Xylene, or lacquer thinner can be used to clean partially dried spills or splatters.

SAFETY AND HANDLING

FLASH POINT: [setaflash] >150° F. (65° C.)

SHIPPING DESCRIPTION: [CFR 49]

Ground/Air/Vessel: Non Regulated Material
Required Label & Marking: Not Required

IMDG PACKAGING: Not Required

IMDG STOWAGE: Not Regulated

UNIFORM FIRE CODE: [CFR 29] CLASS III-A

STORAGE TEMPERATURE: 90° F. max.

Do not allow to freeze.

"HMIS" RATINGS: H - 2; F - 2; R - 0; PP - H

(01/30/02)

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