



Gillespie Coatings. Inc.

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**GCI PRODUCT DATA SHEET
25 SERIES – ALKYD ENAMEL TOPCOAT**

DESCRIPTION	Alkyd Enamel Topcoat
CHARACTERISTICS	<ul style="list-style-type: none">- High gloss alkyd enamel- Excellent gloss retention- Good drying properties- Excellent application characteristics- Brush, Roll or Spray- Single component system- Contains no lead or chromate pigments- Typical uses<ul style="list-style-type: none">Industrial FabricationTransportationEnhance appearance of finish and protectionDesigned for brush, roll or spray application
GLOSS AND COLOR	High gloss finish; Various colors 95° on 60° gloss meter
PHYSICAL DATA	
Vehicle	Modified alkyd resin
Pigment type	Light fast pigments
Solvent type	Aliphatic-Aromatic blend
VOC	4.3 ± .3 lbs. per gallon - (Varies with color)
Weight per Gallon	7.4 lbs. to 9.54 lbs. /gallon (Varies with color)
Flash point	90° F
Recommended	
Dry film thickness	1.5 – 2.0 mils
Theoretical spread	
Spread rate	515 to 600 ft ² at 1 dry mil (Coverage will vary with color)
Volume solids	32 – 38% (Varies with color)
Volume weight	Varies with color
Viscosity	65 ± 5 Ku @ 78°F
Resistance to	Excellent performance to general environmental conditions. General transportation and industrial service

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Limitations Not for severe service including: chemical, elevated temperature, water immersion, acid or base conditions, heat or physical abrasion service.

APPLICATION

Surface Preparation Coatings performance is dependent upon surface preparation. Surface must be clean, dry and free from all oil, grease, rust, dirt, dust, or other foreign material. Substrate material must be primed.

Recommended Primer GCI 94 series, GCI 100 series, and GCI 200 series primers.

Mixing Paint must be thoroughly mixed to a uniform consistency with a low speed air powered or explosion proof power agitator prior to use.

Application Equipment Airless spray
The following is a guide suitable for equipment from various manufacturers. For proper spray characteristics, changes in pressure and type size may be needed.

Airless pump ratio 30:1
Non-cycling, air pressure to pump, approximately 40 - 50 psi
Tip pressure approximately 1200 psi
Tip size: .013-inch to .015-inch

Conventional Spray
The following is a guide suitable for equipment from various manufacturers. For proper spray characteristics, changes in pressure and type size may be needed. Main line air supply with moisture and oil trap are recommended

Main air-line pressure	100 psi
Fluid (pot) pressure	60 – 65 psi
Atomizing (gun)	40 – 60 psi
Tip size:	.046-inch to .070-inch

Film Thickness	Minimum / Maximum	
Wet Mils	3 mils	4 mils
DFT Mils	1.5 mils	2 mils

Film thickness below minimum may degrade coating performance and above maximum will affect dry time and recoat window

Recommended Thinner Airless Spray
Normally no thinning is required. Under certain conditions use of GCI Thinner (Mineral Spirits) at 8 – 14 oz. per gallon is recommended.

Conventional Spray
Thin up to 20% with GCI Thinner (mineral spirits) at 10 to 20 oz. per gallon

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Application conditions	Coatings material must be above 50° F before use. Air and substrate surface temperature must be above 50° F. Surface temperature must be a minimum of 5° F above dew point to prevent condensation formation. Do not apply when humidity is high and condensation is possible. Painting of metal in direct sunlight not recommended.
Average Drying time	
To Touch	40 – 60 Minutes
Tack free	4 – 6 hours
Through dry	24 hours
Re-coat	Re-coat with itself at any time.
Optional	For accelerated hardening, use GCI QSC-100 acrylic hardener at 1 pint per gallon. Recoating should be tested on small area
Clean Up Solvent	GCI – ES - 5 (xylene) GCI Thinner (mineral spirits)

Clean equipment immediately after use.

All surplus materials and empty containers should be disposed of according to regional regulations

PACKAGING One gallon containers.
 Some colors available in five gallon size container

SHIPPING DATA

DOT Name	Paint
UN Number	UN1263
Hazardous Class	3, Flammable Liquid
Packing Group	PG III

CAUTION STATMENT

WARNING - Flammable Liquid

FOR INDUSTRIAL USE ONLY

GCI 11 Series coatings are flammable. Keep away from open flames and heat. Use adequate ventilation. Avoid contact with skin and breathing of vapors or spray mist. Improper use and handling of this product can be hazardous to health and cause fire. Close container after each use.

Gillespie Coatings, Inc. is responsible for technical accuracy and conformation to GCI specifications. This bulletin supersedes previous bulletins. Always consult your GCI representative for latest information and recommendations for GCI products.