



Gillespie Coatings. Inc.
211 Gum Springs Road
Longview, Texas 75602
903-753-0393

G.C.I. PRODUCT DATA SHEET 244 SERIES – COMPLIANT ACRYLIC ENAMEL

DESCRIPTION	A high gloss Acrylic Alkyd Enamel Topcoat
CHARACTERISTICS	<ul style="list-style-type: none">- VOC and HAPs compliant coatings- High gloss alkyd enamel with outstanding service- Excellent gloss retention- Good drying properties- Excellent application characteristics- Single component system- Contains no Lead or Chromate pigments- Typical uses<ul style="list-style-type: none">Industrial FabricationTransportationStructuralEnhance appearance of finish and protection
GLOSS AND COLOR	High gloss finish; Various colors 95 ^o + on 60 ^o gloss meter
PHYSICAL DATA	
Vehicle	Acrylic alkyd resin
Pigment type	Light fast for exterior application
Solvent type	Aliphatic-Aromatic blend
VOC	3.1± .3 lbs. per gallon - (Varies with color)
Weight per Gallon	8.4 lbs. to 9.54 lbs. /gallon (Varies with color)
Flash point	73 ^o F
Recommended	
Dry film thickness	1.5 – 2.5 mils over primed surface
Theoretical spread	
Spread rate	618ft ² at 1 dry mil (Coverage will vary with color)
Volume solids	35%-42% (Varies with color)
Volume weight	44%-57% (Varies with color)
Viscosity	65 ± 5 Ku @ 78 ^o F
Resistance to	General service: abrasion, moisture, exterior and interior conditions up to 200 ^o F, continuous dry heat; 250 ^o F intermittent dry heat.
Limitations	Not for severe service including: acid or base conditions, continuous temperatures above 250 ^o F, or prolonged water immersion.

G.C.I. PRODUCT DATA SHEET 244 SERIES – COMPLIANT ACRYLIC ENAMEL

APPLICATION

Application Method	Spray																			
Surface Preparation	<p>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. Primed substrate material is recommended.</p> <p>Direct to Metal (DTM) Steel – metal preparation SSPC 6</p>																			
Recommended Primer	GCI 100 series universal lift resistant primer.																			
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	<p>The following is a guide suitable for equipment from various manufacturers. For proper spray characteristics, changes in pressure and type size may be needed.</p> <p>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</p> <p>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</p> <table border="0" style="margin-left: 40px;"> <tr> <td>Main airline pressure</td> <td>100 psi</td> </tr> <tr> <td>Fluid (pot) pressure</td> <td>60 – 65 psi</td> </tr> <tr> <td>Atomizing (gun)</td> <td>40 – 60 psi</td> </tr> <tr> <td>Tip size:</td> <td>.046-inch to .070-inch</td> </tr> </table>		Main airline pressure	100 psi	Fluid (pot) pressure	60 – 65 psi	Atomizing (gun)	40 – 60 psi	Tip size:	.046-inch to .070-inch										
Main airline pressure	100 psi																			
Fluid (pot) pressure	60 – 65 psi																			
Atomizing (gun)	40 – 60 psi																			
Tip size:	.046-inch to .070-inch																			
Film Thickness	<table border="0" style="margin-left: 40px;"> <tr> <td>Primed surface</td> <td colspan="2">Minimum / Maximum</td> </tr> <tr> <td>Wet Mils</td> <td>3 mils</td> <td>5 mils</td> </tr> <tr> <td>DFT Mils</td> <td>1.5 mils</td> <td>3 mils</td> </tr> <tr> <td>Direct to Metal (DTM)</td> <td colspan="2">Minimum / Maximum</td> </tr> <tr> <td>Wet mils</td> <td>5 mils</td> <td>8 mils</td> </tr> <tr> <td>DFT mils</td> <td>3 mils</td> <td>4 mils</td> </tr> </table> <p>(NOTE: Primed surface recommended)</p> <p>Film thickness below minimum may degrade coating performance and above maximum will affect dry time and recoat window</p>		Primed surface	Minimum / Maximum		Wet Mils	3 mils	5 mils	DFT Mils	1.5 mils	3 mils	Direct to Metal (DTM)	Minimum / Maximum		Wet mils	5 mils	8 mils	DFT mils	3 mils	4 mils
Primed surface	Minimum / Maximum																			
Wet Mils	3 mils	5 mils																		
DFT Mils	1.5 mils	3 mils																		
Direct to Metal (DTM)	Minimum / Maximum																			
Wet mils	5 mils	8 mils																		
DFT mils	3 mils	4 mils																		

**G.C.I. PRODUCT DATA SHEET
244 SERIES – COMPLIANT ACRYLIC ENAMEL**

Recommended Thinner	GCI ES-5 (xylene)
	Airless Spray - Normally no thinning is required. Under certain conditions use of ES-5 (Xylene) at 8 – 14 oz. per gallon is recommended.
	Conventional Spray Thin up to 20% with ES-5 (xylene) per gallon
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
Average Drying time	
To Touch	30-45 Minutes
Tack Free	60 minutes
Through dry	24 hours
Re-coat	1 - 3 hours or after 7 days
Optional	Modified Re-coat window: Add 1 pint per gallon Urethane (isocyanate) hardener to first coat. Then, Re-coat after 4 hours. Recoating should be tested on small area

Dry times are affected by air and surface temperatures, relative humidity, ventilation and film thickness.

Clean Up: Clean up spills and splatters with Xylene. Clean equipment and tools immediately after use with Xylene.

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

PACKAGING	Five gallon size container 50 gallon size drum 55 gallon size drum
-----------	--------------------------------------------------------------------------

SHIPPING DATA

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

G.C.I. PRODUCT DATA SHEET
244 SERIES – COMPLIANT ACRYLIC ENAMEL

CAUTION STATEMENT

WARNING - Flammable Liquid FOR INDUSTRIAL USE ONLY

GCI 244 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.

The information and instructions provided in this Product Data Sheet are subject to change without notice. Consult your Gillespie Coatings representative to obtain the most recent information.

Gillespie Coatings, Inc. is responsible for technical accuracy and conformation to GCI specifications.