



Gillespie Coatings. Inc.
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Longview, Texas 75602
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G.C.I. PRODUCT DATA SHEET 55 SERIES – METALLIC ACRYLIC ENAMEL

DESCRIPTION	A high gloss Acrylic Alkyd Enamel Topcoat
CHARACTERISTICS	<ul style="list-style-type: none">- High gloss metallic alkyd enamel- Excellent gloss retention- Good drying properties- Excellent application characteristics- Single component system- Contains no Lead or Chromate pigments- Typical uses <p>Industrial Equipment Fabrication Transportation Structural Enhance appearance of finish and protection</p>
GLOSS AND COLOR	High gloss finish; Various colors 90°+ on 60° gloss meter
PHYSICAL DATA	
Vehicle	Modified alkyd resin
Pigment type	Light fast for exterior application
Solvent type	Aliphatic-Aromatic blend
VOC	4.3 ± .3 lbs. per gallon - (Varies with color)
Weight per Gallon	8.4 lbs. to 9.54 lbs. /gallon (Varies with color)
Flash point	86° F minimum
Recommended Dry film thickness	1.5 – 2.0 mils over primed surface
Theoretical spread Spread rate	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	General service: abrasion, moisture, exterior and interior conditions up to 200° F, continuous dry heat; 250° F intermittent dry heat.
Limitations	Not for severe service including: acid or base conditions, continuous temperatures above 250° F, or prolonged water immersion.

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APPLICATION

Application Method	Spray (not recommended for brush or rolling)																			
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. Primed substrate material is recommended.																			
Recommended Primer	GCI 100 series universal lift resistant primer or GCI 200 series primer																			
Mixing	The metallic flakes may settle to the bottom of the container therefore, it must be thoroughly mixed prior to use. Boxing method is recommended. This is performed by pouring from one container to another, letting the paint fall from a reasonable height to promote mixing without increasing the risk of spills. Boxing needs to be performed several times in order to incorporate flakes into the resin.																			
Application Equipment	<p>Conventional Spray</p> <p>The following is a guide suitable for equipment from various manufacturers. For proper spray characteristics, changes in pressure 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>65 - 70 psi</td> <td></td> </tr> <tr> <td>Fluid (pot) pressure</td> <td>15 – 20 psi</td> <td></td> </tr> <tr> <td>Atomizing (gun)</td> <td>40 – 60 psi</td> <td></td> </tr> <tr> <td>Tip size:</td> <td>0.013-inch</td> <td></td> </tr> </table> <p>Quart Cup Type Equipment</p> <table border="0" style="margin-left: 40px;"> <tr> <td>Airline pressure</td> <td>40 – psi</td> <td></td> </tr> <tr> <td>Tip size:</td> <td>0.013-inch</td> <td></td> </tr> </table>		Main airline pressure	65 - 70 psi		Fluid (pot) pressure	15 – 20 psi		Atomizing (gun)	40 – 60 psi		Tip size:	0.013-inch		Airline pressure	40 – psi		Tip size:	0.013-inch	
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Recommended Thinner	<p>GCI ES-5 (xylene)</p> <p>Product recommended for spray only in conventional type spray equipment or quart cup type spray equipment. Not recommended to use with airless spray. Metallic flakes must be able to move in thinner to properly provide appearance.</p>																			

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Not recommended to use with airless spray equipment. Metallic flakes must be able to move in thinner to properly provide appearance.

Conventional Spray
Thin up to 1 pint per gallon with ES-5 (xylene)

Quart cup type
Thin up to 1 quart per gallon with ES-5 (xylene)

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 – 60 Minutes
Tack Free	4 – 6 hours
Through dry	24 hours
Re-coat	After 1 hour
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

One gallon size container
Five gallon size container (depending on color chosen)

SHIPPING DATA

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

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CAUTION STATEMENT:

WARNING - Flammable Liquid FOR INDUSTRIAL USE ONLY

GCI 55 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.

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