



ULTRACOTE AL 64

Modified Alkyd Phenolic Finish

(Paints & Coatings)

HEAVY DUTY, HIGH PERFORMANCE

GENERIC CLASS: Modified alkyd phenolic resin with high quality grade pigment.

PRODUCT DESCRIPTION: A high gloss alkyd enamel topcoat for interior and exterior protection against weather, mild industrial fumes and light abrasion. It exhibits tough film finish and performs good adhesion to rust preventive primers and also good adhesion between undercoat and topcoat. It has a very good gloss and color retention.

TYPICAL USES: Coating primed on previously painted steel, dry wall or wood expose to light industrial and light marine service. It is recommended as a topcoat for piping, storage tanks exteriors, building interiors and exteriors, ship and boat interiors and exterior hull above the waterline.

LIMITATIONS: Not recommended for immersion service or splash and spillage of strong acids, alkalies and solvents.

CHEMICAL RESISTANCE GUIDE:

| <u>Exposure</u> | <u>Splash & Spillage</u> | <u>Fumes</u> |
|-----------------|------------------------------|--------------|
| Acids | NR | Poor |
| Alkalies | NR | Poor |
| Solvents | NR | Poor |
| Salt | Good | Very Good |
| Water | Excellent | Excellent |

TEMPERATURE RESISTANCE: (Dry Basis)

| | | |
|--------------|---|---------------|
| Sustained | : | 200°F (93°C) |
| Intermittent | : | 250°F (121°C) |

FLEXIBILITY: Excellent. ASTM D522-60. Passes 1/8" conical mandrel.

WEATHERING: Excellent. Conform to salt spray (fog) ASTM B 117-73.

ABRASION RESISTANCE: Good

ADHESION: Very Good. Conform to ASTM D3359 Method B.

SUBSTRATES: Apply over suitably primed metal, masonry surfaces, or others as recommended. Apply directly over clean, dry wood.

TOPCOAT REQUIRED: None required. Optional second coat will give a longer service life and may be required when covering dark primers with a light color topcoat.

COMPATIBILITY WITH OTHER COATINGS: May be applied over alkyd primers and chlorinated alkyd primers and others as recommended.

CALCULATED VOLUME SOLIDS:

Ultracote AL 64 35%±2%

RECOMMENDED DRY FILM THICKNESS PER COAT:

1.5 - 2 mils (37.5 - 50 microns)

CALCULATED COVERAGE PER GALLON:

561 mil sq. ft. (13.78 sq. m./ li. @ 25 microns)
 502 sq. ft. @ 1.5 mils (12.3 sq. m./ li. @ 37.5 microns)
 280 sq. ft. @ 2 mils (6.88 sq. m./ li. @ 50 microns)

NOTE: Assume loss factor when estimating job requirements at prevailing condition.

FLASH POINT: (Pensky Martens Closed-Cup)

| | |
|-------------------------|--------------|
| Ultracote AL-64 Topcoat | 105°F (41°C) |
| Ultracote Thinner #6 | 105°F (41°C) |
| Ultracote Thinner #63 | 105°F (41°C) |

SHELF LIFE: 12 months. Turn stock upside down every 3-4 months.

COLOR: Brilliant

FINISH: High Gloss

COMPONENT: One

SURFACE PREPARATION: Surfaces must be dry, clean and free of oil, grease and other contaminants. Remove rust and paint not tightly bonded to the surface and spot prime.

STEEL: Apply over properly primed surfaces and/or tie coat.

ALLOY STEEL, GALVANIZED STEEL AND NON-FERROUS METALS: Chemically clean surfaces in accordance with SSPC-SP-1 (Solvent Cleaning). Abrasive "brush blast to provide a lightly profiled and etched surface.

WELDING: Welding should precede coating. In the event welding or flame cutting is performed on metal already coated with this product, do so in accordance with the latest instruction in USA Standard Z49:1 "Safety in Welding and Cutting". All welded, burned or otherwise damaged areas should be cleaned to base metal, prepared and recoated as specified.

PREVIOUSLY PAINTED SURFACES: All surfaces must be thoroughly clean, dry and free from dirt, rust, grease and loose paint flake. Lightly sand the surface prior to painting. Loose flaking paint must be scraped off to a firm edge and defective areas must be sanded down to the substrate and primed with the appropriate primer before overcoating.

CONCRETE/MASONRY SURFACES: Apply over clean, dry recommended alkali resistant primer or surfacer.

WOOD: Apply directly over clean, dry unprimed surface. First coat may be thinned up to 15% by volume for better penetration. A second coat is required for uniform appearance.

MIXING: Stir very thoroughly before use and occasionally during application.

THINNER: Thin up to 5% by volume with Ultracote Thinners # 6 or #63. Do not overthin!

NOTE: Use of thinners other than those specified may adversely affect the paint performance.

APPLICATION TEMPERATURES:

Materials : 35-120°F (2-49°C)
Surfaces : 35-165°F (2-74°C)
Ambient : 35-120°F (2-49°C)
Humidity : 0-98%

Application at air and surface temperature lower than 120°F (49°C) and above 35°F (2°C) and more than 5°F (2°C) above the dew point is suggested.

SPRAY TECHNIQUE: Use sufficient air volume for correct operation of equipment. Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

APPLICATION EQUIPMENT: Air or airless, brush or roller.

CONVENTIONAL SPRAY: Suggested equipment or equal: Binks 62: 66 fluid tip, 63 PB air cap, 5/16" or 3/8" air hose, 3/8" or 1/2" material hose, 40-70 psi atomizing pressure and 10-20 psi pot pressure. Low temperature or longer hoses require higher pot pressure.

AIRLESS SPRAY: Graco 205-591, 30:1 President or Bulldog pump, 0.013" to 0.017" tip orifice, 2,400-3,000 psi atomizing pressure, 1/4" or 3/8" material hose, 60 mesh manifold filter. Teflon packings are recommended.

BRUSH/ROLLER: Use medium bristle brush/short nap mohair.

DRYING TIME:

To Touch : 2 hrs. @ 90°F (32°C)
 3 hrs. @ 75°F (24°C)
To handle : 4 hrs. @ 90°F (32°C)
To Recoat : 3-4 hrs. @ 90°F (32°C)
Final Cure : 24 hrs. @ 90°F (32°C)

CLEAN-UP INSTRUCTIONS: Clean all equipment immediately after use with Thinner #2 or xylol. Flush and clean spray equipment before material set up.

STORAGE CONDITION:

Temperature : 35°F (2°C) to 110°F (43°C)
Humidity : 0-100%

PACKAGING: Gallon (3.785 liters)
Pail (4 & 5 Gallons)

SAFETY INFORMATION: This product (and any recommended thinners) contains solvents and/or other chemical ingredients. Adequate health and safety precautions should be observed during storage, handling, application and curing. Keep away from sparks, heat and open flame and use necessary safety equipment such as air mask, non-sparking tools and ladders, etc. When working in tanks, rooms and other enclosed spaces, adequate ventilation must be provided. Keep out of reach of children.

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