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TT-E-489G AIR DRY & BAKE ENAMEL

DESCRIPTION

This one component high grade, alkyd type, high gloss enamel is intended for use on primed exterior and interior wood or metal substrates, but particularly on smooth exterior metal. It is highly weather resistant and is characterized by good color and gloss retention, good drying, freedom from after-tack with good flexibility. Can be applied with either brush or spray. This enamel under this specification, is only available in 1 Series (Gloss), Federal Standard 595b Colors. There are two types, Class A—Air Dry & Class B Bake Enamel.

SUGGESTED APPLICATIONS

- Machinery - Motors - Trucks - Tractors - Railings - Steel Structures
- Pumps - Metal Signs - Metal Fences - Metal Drum Exteriors

PERFORMANCE CHARACTERISTICS

Adhesion: Cross-Hatch Tape Pull
Plain Steel: No Loss

Pencil Hardness: Class A: 3B Minimum
Class B: H Minimum

Flexibility: Passes 1/8" Mandrel Bend

Dry Times: Class A
To Touch: 1 - 2 Hours
Through Dry: 8 Hours
Recoat: 24 Hours
Full Hardness: 48 Hours
Full Cure: 1 Week
Class B 20 mins @ 300°F

Solids by Volume:
27 - 58% Depending on Color

Coverage: 525 sq. ft./gallon at 1 mil DFT,
No Loss

Chemical Resistance:
1 Hour Spot Tests:
Engine Oil: No effect
Transmission Oil: No effect
Hydraulic Oil: No effect

Primer Absorption/TT-P-1757:
18 Hours, Then Apply Topcoat

Water Resistance: ASTM D1308
1 Week: No Softening, Whitening or Dulling

Hydrocarbon Resistance: ASTM D1308
8 Hours: No Softening, Whitening or Dulling

Accelerated Weathering: ASTM D2244/E97
100 Hours: No Cracking, Slight Loss of Gloss

Weathering Resistance: ASTM D659
18 Months: No Checking or Cracking

Application:

These enamels can be sprayed or brush applied. Class A: For spraying, mix by volume 4 Parts TT-E 489 with 1 Part Mineral Spirits. Proper thinning for brushing is dependent upon application requirements. Class B: Use a mixture of the following:

% by Volume	
Butyl Alcohol	20%
Toluol	15%
V M & P Naptha	65%

Or use thinner conforming to Mil-T-81772B Ty III, and reduce to a satisfactory spray viscosity. With either thinner, do not exceed a mixing ratio by volume of 3 parts paint to 1 part thinner.

Surface Preparation:

All surfaces to be coated must be clean and free from dirt, oils, greases, polishing or rubbing compounds, fingerprints, and any other foreign matter.

Primers:

Ferrous Metal Surfaces: TT-P-636, TT-P-645 or TT-E-485.

Aluminum: TT-P-1757B

Primers should be air dried 18 hours before applying TT-E-489 Class A Enamel.

A coat of primer surfacer conforming to TT-P-659 may be used in place of TT-P-636 for white or light tints.

SAFETY & HANDLING INFORMATION

NOTE: The above information is supplied as a guideline to our customers. The user must be aware of the cleaning, pretreatment, primer, application and testing requirements for their specific job.