PPG TrueFinish®
Industrial Coatings

# SPECTRACRON® 550 SERIES 2K HS EPOXY DTM ENAMEL

## DESCRIPTION:

**SPECTRACRON® 550 SERIES 2K HS Epoxy DTM Enamel** is recommended for use on pretreated or properly prepared steel and aluminum and where a hard, chemically resistant colored finish is required for interior applications. Suggested uses include metal fabrication, machinery, office furniture and heavy equipment.

## HIGHLIGHTS:

- Excellent corrosion and chemical resistance
- Excellent hardness, abrasion, and mar resistance
- Excellent adhesion

## TECHNICAL PROPERTIES:

| PROPERTY | METHOD | RESULT* |
|---|---|---|
| Color | | Custom Colors |
| Gloss @ 60° Angle | ASTM D523 | 80 - 90 |
| Pencil Hardness | ASTM D3363 | ≥ H |
| Adhesion | ASTM D3359 | 5B – Excellent |
| Humidity Resistance – 100 Hrs. | ASTM D2247 | Excellent |
| Salt Spray Resistance – 300 Hrs. | ASTM B117 | Very Good |
| Chemical Resistance | | Excellent |
| Gasoline | | No effect |
| Machine Oil | | No effect |
| Substrates | | CRS, HRS, Alum, Galv |
| Recommended Primer(s) (recommended for a smooth finish on casted or blasted metal) | | SPECTRACRON: 135, 501, 531, 560, 701 |

*These results were obtained over iron phosphated CRS panels.

## PHYSICAL PROPERTIES:

| PROPERTY | BLENDED VALUE* |
|---|---|
| Weight per gallon | 13.2 ± 0.7 lbs./gal. |
| Weight Solids (%) | 69 ± 3 |
| Volume Solids (%) | 51 ± 3 |
| Flash Points: | |
| SPECTRACRON 550 | 74°F (23°C) |
| SPECTRACRON 5501 | 80° F (27°C) |
| VOC (less exempts) | 3.5 lbs./gal. (avg.) |
| VOE (actual) | 3.5 lbs./gal. (avg.) |
| Coverage (@ 1 mil, no loss) | 770 – 866 sq. ft./gal. |
| Shelf Life - unopened container | QT550 – 4 years<br>Q5501 – 4 years |

*Blended values listed will be color dependent.

Revision Date: 2/2011

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## SURFACE PREPARATION:

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating and/or primer will improve the performance properties of the coating system. See your PPG Representative for recommendations.

## APPLICATION DATA:

| | |
|---|---|
| Mixing Instructions: | 4 parts SPECTRACRON 550 (QT550) : 1 part SPECTRACRON 5501 (Q5501) By volume. Mix thoroughly. No digestion/induction time required. |
| Wet Film Thickness: | 3.0 – 5.0 mils |
| Dry Film Thickness: | 1.5 – 2.5 mils |
| Thinner: | Q80 (xylene) or Q70 (MAK) |
| Clean up: | Q80 (xylene) or Q70 (MAK) |
| Pot Life (@77°F): | 8 hours |
| Full cure: | 24 – 48 hours |

| SPRAY APPLICATION | SPRAY EQUIPMENT* | FLUID PRESSURE (psi) | ATOMIZATION PRESSURE (psi) | FLUID NOZZLE | AIR NOZZLE |
|---|---|---|---|---|---|
| Conventional | Binks 2001 or 95 | 8 - 10 | 45 - 55 | 63C | 63PE |
| Conventional | DeVilbiss MBC-510 | 8 - 10 | 45 - 55 | FF (0.055", 1.4mm) | 797 |
| Airless | Graco G-40 | 1800 - 2400 | n/a | 0.011 to 0.015" | n/a |
| Air Assisted Airless | Graco Alpha A.A. | 900 - 1300 | 20 - 40 | 0.011 to 0.015" | Alpha |
| HVLP | DeVilbiss – JGHV | 8 - 10 | 55 – 60** | FF (0.055", 1.4mm) | #46 MP |

*or equivalent

**atomization pressure should read <10 psi @ the cap

## CURE SCHEDULE:

Air-dry (assumes 77°F & 50% Relative Humidity)

| | |
|---|---|
| To Touch: | 2 hrs. |
| To Handle: | 4 hrs. |
| To Recoat: | 4 hrs. |

Bake / Force Cure

| | | |
|---|---|---|
| Flash Time: | 10 min. (ambient) | |
| Substrate Temp: | 140°F or | 160°F |
| Bake Time: | 30 min. | 20 min. |

## ADDITIONAL INFORMATION:

- Do not apply at temperatures below 50°F
- Excess film thickness or cooler temperatures will retard dry times and affect recoat window
- In-Service Temperature: 300°F - as you approach 300°F, depending on the pigmentation, the color may change, but the film integrity will be maintained
- This product will experience fade and loss of gloss when used in an outdoor exposure environment however, it will continue to provide corrosion protection



**CONTACT 1-866-PPG TRUE**



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