



**2500 SYSTEM
DTM 250 VOC ALKYD ENAMEL**

DESCRIPTION & USES

2500 System DTM 250 VOC Alkyd Enamel is designed for interior and exterior surfaces in mild to moderate industrial environments. Not for use on galvanized steel.

If desired, the 2500 System DTM 250 VOC Alkyd Enamels can be applied direct-to-metal (DTM), however optimal corrosion protection is achieved when the finish coat is used in conjunction with one of the recommended primers.

PRODUCTS

1-Gallon	5-Gallon	Description
215758	—	White
215954	—	Forest Green
215759	—	Black
215955	—	Dunes Tan
215950	—	Safety Yellow
215956	—	Safety Orange
215951	—	Safety Red
215957	—	Safety Blue
215952	—	Navy Gray
215958	—	Rusty Metal Primer
215959	—	Gray Primer
215960	—	Masstone Base
215961	—	Deep Base
215962	—	Light Base

COMPANION PRODUCTS

RECOMMENDED PRIMER

- 215958 Rust Inhibitive Red Primer
- 215959 Rust Inhibitive Gray Primer

OTHER FINISHES

- 3415402 Aluminum*

*The 3415402 Aluminum is suitable for use in California. See 3400 System Technical Data Sheet, Form 2055990, for product physical properties.

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Pure Strength® Cleaner/Degreaser, item #3599402, commercial detergent or other suitable cleaner. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings. If abrasive blasting cleaning is used, then two coats of recommended primer is required.

PREVIOUSLY COATED: Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding to create a surface profile. The 2500 System Enamels are compatible with most coatings, but a test patch is suggested. **WARNING!** If you scrape, sand or remove old paint from any surface, you may release lead paint dust. **LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE.** Wear a NIOSH-approved respirator to control lead exposure. Carefully clean up with a wet mop or HEPA vacuum. For additional information, contact the U.S. EPA/Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.



PRODUCT APPLICATION (cont.)

APPLICATION

Apply only when the air and surface temperatures are between 32-100°F (0-38°C) and the surface temperature is at least 5°F (3°C) above the dew point.

EQUIPMENT RECOMMENDATIONS

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atom. Pressure
Pressure	0.055-0.070	16 oz./min.	25-60 psi
Siphon	0.055-0.070	—	25-60 psi
HVLP	0.043-0.070	10-12 oz./min.	10 psi @ tip

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
2,000-2,800 psi	0.013-0.017	100

THINNING

BRUSH/ROLLER: 333 Thinner: Normally not required.

AIR-ATOMIZED SPRAY: 333 Thinner: If needed, use up to 10%.

AIRLESS SPRAY: 333 Thinner: Normally not required. If needed, use 5-10%.

CLEANUP

333 Thinner or Mineral Spirits



TECHNICAL DATA

2500 SYSTEM DTM 250 VOC ALKYD ENAMEL

PHYSICAL PROPERTIES

		FINISHES	TINT BASES	PRIMERS
Resin Type		Modified Alkyd	Modified Alkyd	Modified Alkyd
Pigment Type		Varies with color	Varies with color	Varies with color
Solvents		Mineral spirits, acetone	Mineral spirits, acetone	Mineral spirits, acetone
Weight	Per Gallon	7.8-9.7 lbs.	7.9-9.2 lbs.	12.1 lbs.
	Per Liter	0.94-1.16 kg	0.95-1.1 kg	1.4 kg
Solids	By Weight	69.8-79.3%	73.5-75.2%	79.2%
	By Volume	61.4-63.8%	66.6-69.4%	61.4%
Volatile Organic Compounds		< 250 g/l (2.08 lbs./gal.)	< 250 g/l (2.08 lbs./gal.)	< 250 g/l (2.08 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		1.5-2.5 mils (37.5-62.5μ)*	1.5-2.5 mils (37.5-62.5μ)*	1-2 mils (25-50μ)
Wet Film to Achieve DFT		2.5-4.0 mils (62.5-100.0μ)	2.0-3.5 mils (50.0-87.5μ)	1.5-3.0 mils (37.5-75.0μ)
Theoretical Coverage at 1 mil DFT (25μ)		985-1,023 sq. ft./gal. (24.2-25.2 m ² /l)	1,068-1,113 sq. ft./gal. (26.3-27.4 m ² /l)	985 sq. ft./gal. (24.2 m ² /l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		335-580 sq. ft./gal. (8.2-14.3 m ² /l)	360-630 sq. ft./gal. (8.9-15.5 m ² /l)	420-870 sq. ft./gal. (10.3-21.4 m ² /l)
Dry Times at 70-80°F (21-27°C) and 50% rel. hum.	Tack-free	5-7 hours	5-7 hours	3-5 hours
	Handle	8-12 hours	10-14 hours	5-10 hours
	Recoat	24 hours	24 hours	24-48 hours
Dry Heat Resistance		212°F (100°C)	212°F (100°C)	212°F (100°C)
Shelf Life		5 years	5 years	5 years
Safety Information	Flash Point	23°F (-5°C) Setaflash	23°F (-5°C) Setaflash	11°F (-12°C) Setaflash
	Contains	No lead has been deliberately added.		
	Warning!	FLAMMABLE LIQUID AND VAPOR. HARMFUL IF INHALED. MAY AFFECT THE BRAIN OR NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. CAUSES NOSE, THROAT, EYE AND SKIN IRRITATION. CONTAINS ALIPHATIC POLYISOCYANATE; METHYL AMYL KETONE AND METHYL ACETATE SOLVENTS. REFER TO MATERIAL SAFETY DATA SHEET (MSDS) FOR ADDITIONAL INFORMATION.		

Calculated values are shown and may vary slightly from the actual manufactured material.

*If applied over a primer or previously coated steel, a dry film thickness of 1-2 mils (25-50μ) is acceptable, 2-4 (50-100μ) wet film thickness.

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Form: 2500990
Rev.: 013009