

## AQUACRON® 880 SERIES WATER REDUCIBLE ENAMEL

### DESCRIPTION:

**AQUACRON® 880 SERIES Water Reducible Enamels** are fast drying interior/exterior enamels intended for industrial use on bare or primed metal surfaces. Suitable applications include metal fabrication, utility trailers, industrial machinery, cabinets and shelving.

### HIGHLIGHTS:

- ❖ Provides a wide balance of performance properties
- ❖ Fast dry
- ❖ No recoat window
- ❖ Can be formulated to 2.8 VOC compliance
- ❖ Available in wide range of colors and gloss
- ❖ Contains no heavy metals
- ❖ Low VOC, low odor
- ❖ Water reduction and clean-up
- ❖ Higher flashpoint than solvent borne coatings

### TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT*
Color		Custom Colors
Gloss @ 60° Angle	ASTM D523	5 - 90
Pencil Hardness	ASTM D3363	F - H
Conical Mandrel	ASTM D522	Pass
Adhesion	ASTM D3359	5B – Excellent
Humidity Resistance – 200 Hrs.	ASTM D2247	Good
Salt Spray Resistance – 200 Hrs.	ASTM B117	Good
Chemical Resistance		Good
Substrates		CRS, HRS, Alum
Recommended Primer(s)		AQUACRON: 833, 835, Q8135, MV390-9300, MV447-9303, MV409-90

\*These results were obtained over iron phosphated CRS panels.

### PHYSICAL PROPERTIES:

PROPERTY	VALUE*
Weight per gallon	9.2 ± 0.8 lbs./gal.
Weight Solids (%)	32.0 ± 5.0
Volume Solids (%)	27.0 ± 3.0
VOC (less water)	3.0 ± 0.2 lbs./gal.
VOE (actual)	1.2 ± 0.1 lbs./gal
Flash Point	106°F (41°C)
Coverage (@ 1 mil, no loss)	395 – 453 sq. ft./gal.
Shelf Life	1 year

\*Values listed will be color dependent

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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 will improve the performance properties of the coating system. See your PPG Representative for recommendations.

### APPLICATION DATA:

Mixing Instructions:	Mix thoroughly before and during use
Wet Film Thickness:	4.0 – 7.5 mils
Dry Film Thickness:	1.0 – 2.0 mils
Thinner:	Water or AquaThin Refresher (TFA880-70) Up to 5% for conventional spray application
Brush Application:	High Quality Natural Bristle Brush
Roller Application:	3/8" Nap Solvent Resistant Core
Clean up:	Soap and warm water, TFA880-70, MV398 Equipment Cleaner

SPRAY APPLICATION	SPRAY EQUIPMENT*	FLUID PRESSURE (psi)	ATOMIZATION PRESSURE (psi)	FLUID NOZZLE	AIR NOZZLE
Conventional	Binks 2001 or 95	8 - 10	35 - 50	63C	63PE
Airless	Not recommended	N/A	N/A	N/A	N/A
Air Assisted Airless	Graco G-40	300 - 400	30 - 40	0.011 - 0.015"	249 - 180
Electrostatic	Graco Xs3	25	50	0.055" (1.5mm)	24A376
HVLP	DeVilbiss – JGHV	40 - 50**	10 - 20	FF	#33A or #46 MP

\*or equivalent

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

### CURE SCHEDULE:

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

To Touch: 20 – 40 min.  
To Handle: 1.5 – 4 hrs.

Bake/Force Cure

Flash Time: 10 min. (ambient)  
Substrate Temp: 160°F  
Bake Time: 10 – 20 min.

### ADDITIONAL INFORMATION:

- ❖ Do not apply at temperatures below 50°F
- ❖ Protect from freezing
- ❖ In-Service Temperature: 120°F
- ❖ Excessive film thickness will retard dry times and can cause a recoat window issue
- ❖ Poor air movement in drying area will significantly increase dry time of product
- ❖ Not recommended for use on galvanized, galvaneal or zinc rich surfaces

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**CONTACT 1-866-PPG TRUE**

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