



# Lettering Enamels

Oil based, high gloss enamels for interior or exterior use on metal, glass, wood, enamel receptive banners and vinyl, vehicle lettering, pinstriping and graphics.

## Features & Benefits

- Single stroke coverage
- Outstanding hiding, durability, and fade resistance
- Superior flow characteristics assure the virtual absence of brush marks and provide a clean, sharp edge
- Excellent weathering properties
- Vibrant colors can be intermixed
- Can be brushed, rolled, or sprayed
- Intended for sign writing on storefronts, vehicles, or wherever fine lettering is desired.



## Compatible Surfaces

- 4331010 Gloss Chromatic TiCote Clear Primer/Barrier

## Optional Products

**Hardeners:** 4007 Hardener (No more than 10%.)

**Reducers:** ZZ6000 Cromaflo Enhancer, ZZ6001 Low Temperature Reducer, ZZ6002 High Temperature Reducer

**Additives:** 4329500 Clear Flattening Paste (no more than 50%), Dana Color D406 Smith's Cream Blending Agent (no more than 10%)

## Directions For Use



### Surface Preparation:

- Apply over clean, dry surfaces which are free from wax, grease, dust, chalk, etc., and have been primed with the appropriate 1 Shot/Chromatic Primer.
- Prime most flexible plastics, synthetics, (including vinyl, many awning materials and non-ERC prepared banner materials) as well as leather and faux leathers with Chromatic Ti-Cote Primer Barrier (4331010 Gloss).



## Directions For Use (Continued)



### Mix Ratios:

- Use only 6000 series reducers (ZZ6000, ZZ6001, ZZ6002).
- For brush applications, use no more than 10% reducer or flow enhancer as needed to maintain desired flow characteristics and brush control.
- For spray and airbrush applications, use no more than 25% ZZ6001 Low Temperature Reducer.
- Do not reduce Lettering Enamels for roller applications.



### Application:

Brush, roller, airbrush or spray



### Drying Times:

- Dry to touch: 2 to 5 hours
- Dry to handle: 8 to 12 hours
- Dry to recoat: 12 to 16 hours

Drying time is best when temperature is above 65°. Between 50° and 65°, drying time is much slower. Paint will not completely dry below 50°.

### Total Film Build:

None required. Color dependent.

### Equipment Cleaning:

- Clean equipment with mineral spirits

### Technical Data:

VOC Less Water Less Exempts - Ready to Use (package/as is) .....	2.87-4.36 lbs./gal (344-523 g/L)
VOC Less Water Less Exempts - w/ 10% hardener.....	2.95-4.31 lbs./gal (353-517 g/L)
VOC Less Water Less Exempts - w/ 10% reduction or flow enhancer .....	3.21-4.57 lbs./gal (385-548 g/L)
VOC Less Water Less Exempts - w/ 25% reduction .....	3.62-4.81 lbs./gal (385-548 g/L)
Solids by Weight - Ready to Use (package/as is) .....	50.3-74.9 %
Solids by Volume - Ready to Use (package/as is) .....	38.6-56.9 %
Theoretical Coverage - Ready to Use (package/as is) .....	619-913 sq. ft./gal at 1 mil, 100% transfer efficiency

### Important:

To prevent the possibility of condensation during the coating application the surface temperature should be a minimum 5° above the dew point. If the surface temperature is too high the solvents will volatilize within the film, causing tiny vapor blisters or pinholes that usually leads to an early coating failure. When the ambient temperature is too high, the coating may cure on the surface and inhibit full cure of the underlying material and this will also lead to the formation of blisters and pinholes. To prevent above problems the temperature range has been established. The additives should be used when their properties are required.

The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

**See Material Safety Data Sheet and Labels for additional safety information and handling instructions.**

### Emergency Medical or Spill Control Information:

US (412) 434-4515; CANADA (514) 645-1320; Mexico 01-800-00-21-400

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