



**IMA – 512**  
**COROTILE®**  
**HS Quick Dry Enamel**  
**2239 Line**  
**Rev. 11/11**

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## COROTILE® HS Quick Dry Enamel

### 2239 Line

Type	Sheen	Theoretical Spread Rate	Recommended Application	Thinner	Clean Up
Modified Alkyd	High Gloss	320 - 420 Sq. Ft. Per Gallon*	Airless or Air Spray (Brush or Roll for small areas)	Xylene or Acetone	Xylene
<b>Touch Dry Time:</b>	1 Hr. @55°F 20 Min. @77°F 10 Min. @100°F	<b>Min Recoat:</b>	3 Hrs. @55°F 1 Hr. @77°F 30 Min. @100°F	<b>Max Recoat :</b> Unlimited*	* See Application Data Below

<b>PRODUCT NAME:</b> 2239 Line COROTILE® HS Quick Dry Enamel	COROTILE® HS Quick Dry Enamel is designed as a finish coat for metal where a rugged, abrasion resistant, high gloss finish is desired. This product has a low VOC and may be used in field painting applications as well as shop applications. Designed for interior or exterior use, the formulation chemistry far surpasses many high solids enamels on the market in gloss and color retention in exterior exposures. The addition of 1 pint per gallon of 827-1B converter may be added to increase the gloss retention, and abrasion and chemical resistance of this product, however this additive is not required.	
<b>WHERE TO USE:</b>	<b>Ferrous Metal Iron Substrates</b>	Use in field or shop application in the general metal finishing/fabrication market, the industrial maintenance market, food and beverage processing facilities or any place a general purpose, quick drying enamel is required. May also be used on properly prepared and primed wood or composition board (interior only) and concrete (interior and exterior). Not recommended for immersion or contact with strong solvents.

REGULATORY INFORMATION:	VOC/VOS STATEMENT:	OTC CATEGORY:	MPI / LEED:
	The products supported by this data sheet contain a maximum of 340 grams per liter VOC / VOS (2.83 lbs/gal.) excluding water & exempt solvents.	This product is compliant under the Ozone Transport Commission regulations as an Industrial Maintenance Coating.	This product is not currently certified under MPI. This product does not meet qualifications for LEED (Leadership in Energy and Environmental Design) projects.

<b>SURFACE PREPARATION:</b>	<p>The performance of this product is directly dependent upon the degree of surface preparation employed. All dirt, oils and accumulated salts must be removed prior to employing specific surface preparation methods. Pressure washing with and oil and grease emulsifier (min. 2500 psi) will best accomplish this task. SSPC-SP1 Solvent Cleaning will also remove surface contaminants.</p> <p>All rust and mill scale must be removed prior to application of this product. This is best accomplished by abrasive blasting. A minimum of SSPC-SP6 Commercial Blast is recommended for severe environmental exposures. Small areas may be cleaned in accordance with SSPC-SP2 Hand Tool Cleaning or SSPC-SP11 Power Tool Cleaning to Bare Metal.</p> <p>This product may be applied directly to clean ferrous metal, however, for best corrosion protection the use of a primer is recommended.</p> <p>Existing coatings should be cleaned as stated above and then checked for compatibility by application of a test patch.</p> <p>For use on substrates other than ferrous metal or iron, please use the proper primer as specified by Technical Service.</p>
<b>APPLICATION:</b>	<p>Mix the product thoroughly before application. The use of a drill mixer at low speed will best accomplish this task. At temperatures above 90°F, or in very low humidity (less than 30%), this product may dry excessively fast, and the use of a slower solvent (High Flash Naphtha) may be required as a thinner.</p> <p>Application in normal temperatures (45 to 90°F) or normal humidity (30 to 85%) should not require thinning, however small amounts of xylene may be used if necessary. SEE THINNING INSTRUCTIONS ON PAGE THREE.</p> <p><b>Airless Spray (Preferred Method):</b> Tip range between 13 and 17 thousandths. Total fluid output pressure at tip should not be less than 2100 psi.</p> <p><b>Air Spray (Pressure Pot):</b> DeVilbiss MBC or JGA gun, with 704 or 765 air cap and Fluid Tip E.</p> <p>NOTE: Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with recommended thinner.</p>

	<p><b>Brush:</b> Natural Bristle for small areas only due to fast dry nature of this product.  <b>Roller:</b> Industrial Cover with Phenolic core for small areas only due to fast dry nature of this product.</p> <p><b>Recoating COROTILE HS QD Enamel with itself:</b> Due to the curing mechanism of this coating, recoating should take place between 1 and 6 hours (at 77°F). If more than 6 hours has elapsed, wait a total of 36 hours before recoating, or wrinkling could occur. After 36 hours (at 77°F) recoating will not be a problem.</p>
<b>*NOTE ON SPREAD RATE:</b>	Actual spread rate will vary based upon numerous factors, including texture of the substrate, application method, waste, surface porosity and thinning. The Theoretical Spread Rate listed on this document has not taken into account these factors and is only based upon the volume solids of this product and the recommended wet film thickness when applied to a smooth substrate.
<b>STORAGE:</b>	24 months at 77°F in original unopened container. Prolonged storage at higher temperatures can shorten the shelf life. Store in dry, shaded area, away from heat and ignition sources. Protect from frost.
<b>TINTABILITY:</b>	COROTILE® HS QD Enamel is available in three tinting bases to be tinted with Prism Industrial Colorants ONLY. Additionally, an assortment of ready mixed colors is available and custom colors may be ordered in minimum batch quantities.
<b>RESIN TYPE:</b>	Modified Alkyd
<b>VOLUME SOLIDS:</b>	51.4 ± 1.0%
<b>WEIGHT PER GALLON:</b>	11.0 lbs. (Varies with color)
<b>MIX RATIO:</b>	N/A (One Component Material), however 1 pint 827-1B (8:1 ratio) may be added for additional gloss retention and abrasion resistance.
<b>INDUCTION TIME:</b>	N/A (One Component Material); If 827-1B is added, a 15 minute induction time should be allowed.
<b>POT LIFE:</b>	8 hours @ 55°F / 2.5 hours @ 77°F / 1 hour @ 100°F (Only if 827-1B is added)
<b>FLASH POINT:</b>	55°F. (TT-P-141, Method 4293)
<b>SPECULAR GLOSS:</b>	85+ units @ 60°
<b>WET FILM THICKNESS:</b>	3.8 to 5.0 mils
<b>DRY FILM THICKNESS:</b>	2.0 to 2.6 mils
<p><b>CAUTIONS:</b>  <b>(Based upon 2239-1 Tintable White – Other Colors May Vary)</b></p>	<p style="text-align: center;"><b>WARNING!</b></p> <p>EXTREMELY FLAMMABLE LIQUID AND VAPOR. VAPORS MAY CAUSE FLASH FIRE. COMBUSTIBLE LIQUID AND VAPOR. HARMFUL OR FATAL IF SWALLOWED. HARMFUL IF INHALED. OVEREXPOSURE MAY CAUSE KIDNEY DAMAGE. Causes nose, throat, eye and skin irritation. Avoid contact with eyes. <b>Contains Crystalline Silica</b>, which can cause cancer. Risk of cancer depends on duration and level of exposure.</p> <p><b>NOTICE:</b> Reports have associated repeated and prolonged occupational overexposure to solvent with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal.</p> <p><b>Use only with adequate ventilation.</b> Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation. Ensure fresh air entry during application and drying. If you experience eye watering, headache or dizziness or if air monitoring demonstrates vapor/mist levels are above applicable limits, wear an appropriate, properly fitted respirator (NIOSH approved) during and after application. Follow manufacturer's directions for respirator use. Avoid contact with eyes, skin and clothing. Wash thoroughly after handling. Close container after each use. If you experience difficulty in breathing, leave the area to obtain fresh air. If continued difficulty is experienced, get medical attention immediately. Keep away from heat, sparks and flame. Vapors can cause flash fire. Do not smoke. Extinguish all flames and pilot lights, and turn off stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Vapors may ignite explosively</p> <p><b>First Aid:</b> In case of eye contact, flush immediately with plenty of water for at least 15 minutes and get medical attention immediately; for skin, wash thoroughly with soap and water. If swallowed, do not induce vomiting. Get medical attention immediately.</p> <p>If spilled, contain spilled material and remove with inert absorbent. Dispose of contaminated absorbent, container and unused contents in accordance with local, state and federal regulations.</p> <p><b>DANGER</b> – Rags, steel wool or waste soaked with this product may spontaneously catch fire if improperly discarded. Immediately after use, place rags, steel wool or waste in a sealed, water-filled metal container.</p> <p><b>WARNING:</b> This product contains chemicals known to the state of California to cause cancer, birth defects or other reproductive harm.</p> <p style="text-align: center;"><b>Obtain and read the MSDS prior to using this product.</b></p> <p style="text-align: center;"><b>KEEP OUT OF REACH OF CHILDREN</b></p> <p style="text-align: center;"><b>FOR INDUSTRIAL USE ONLY</b></p>

**TEST DATA**

<b>Abrasion resistance by Taber (ASTM D1044) CS-10 Wheel, 1000 g load, 1000 rotations</b>	120 mg loss
<b>Gloss Retention by QUV Testing (ASTM G53) 500 hours</b>	75% retention
<b>Salt Fog Resistance (ASTM B117) Two coats over 820 Line Primer</b>	1,000 Hours
<b>Dry Heat Resistance</b>	300°F
<b>Wet Heat Resistance</b>	150°F
<b>Flexibility (ASTM D1737)</b>	Pass 1/4" Mandrel

**CHEMICAL RESISTANCE GUIDE (NON-IMMERSION)**

<b>Fresh Water</b>	Excellent
<b>Salt Water</b>	Excellent
<b>Acids</b>	Good
<b>Alkalis</b>	Good
<b>Solvents</b>	Fair
<b>Fuel</b>	Fair
<b>Acidic Salt Solutions</b>	Good
<b>Alkaline Salt Solutions</b>	Good
<b>Neutral Salt Solutions</b>	Good

**QUALIFICATIONS**

Suitable for use in USDA inspected facilities.
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**SYSTEMS RECOMMENDATIONS  
COMPATIBLE PRIMERS**

820 Line, 1147 Line, 1201 Line, 317-200, 100-10, 180-11, 954-11, V110 Line, V114, V132 Line, V131 Line, V150 Line, V160 Line
For coatings other than listed above, or for usage in severe environmental conditions, please consult with Coronado Industrial Coatings technical service.

**WARRANTY**

Coronado Paint Company warrants its products to be free from defects in materials and workmanship. Coronado Paint Company's sole obligation and the purchaser's exclusive remedy shall be limited, at Coronado Paint Company's option, to either replacement of nonconforming products or credit to the purchaser's account in an amount not greater than the original purchase price of the nonconforming products. Any claim under this warranty must be made by the purchaser, in writing to Coronado Paint Company, within ten (10) days of the purchaser's discovery of the claimed defect, but not later than the expiration of the applicable shelf life, or one year from the original delivery date, whichever is earlier. Purchaser's failure to notify Coronado Paint Company of any nonconformance as required shall bar the purchaser from recovery under this warranty.

Coronado Paint Company makes no other warranties, expressed or implied, such as merchantability or fitness for a particular purpose concerning its products. In no event shall Coronado Paint Company be liable for consequential or incidental damages.

Any recommendation or suggestion relating to the usage of products made by Coronado Paint Company, whether in the form of literature, data, or in response to specific inquiry, or otherwise is based upon information believed to be reliable; however the products and information are intended for use by skilled and knowledgeable purchasers, and is therefore for the purchaser to satisfy itself of the suitability of the products for its own specific use, and it shall be deemed that the purchaser has done so, at the sole discretion and risk. Variation in application conditions, ambient conditions or extrapolation of information may cause unsatisfactory results.

**LIMITATION OF LIABILITY**

Coronado Paint Company's liability on any claim, including claims based upon negligence, or strict liability for loss, or damage arising out of, connected with, or resulting from the use of products, shall in no case exceed the purchase price of the products directly giving rise to the claim. In no event shall Coronado Paint Company be liable for consequential or incidental damages.

**THINNING RECOMMENDATIONS:**

Do not thin more than local regulations allow.  Thinning with acetone in any amount will not change the VOC level of this product.
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