



## LV ENVIRO-TUFF® (986-SERIES)

### PRODUCT DESCRIPTION

**LV Enviro-Tuff®** Industrial Enamel is a low VOC version of our 886-Line Enviro-Tuff®. This special formula has maximum pigment levels to ensure great coverage and optimum hiding power. **LV Enviro-Tuff®** also provides good exterior protection for many industrial applications.

**LV Enviro-Tuff®** offers benefits such as:

- Durable protection
- Excellent coverage
- User friendly
- Wide color selection
- Economical
- Brush, roll or spray application
- Environmental acceptance in most areas

### PERFORMANCE PROPERTIES

#### System Tested:

Substrate: Steel  
Surface Preparation: SSPC-SP6  
1 ct. Universal Primer @ 3 mils dft  
1 ct. Enviro-Tuff® Enamel @ 3 mils dft

#### Adhesion:

Method: ASTM D4541 Type II  
Result: 7-day cure: Passes 250 lbs/sq in

#### Pencil Hardness:

Method: ASTM D3363  
Result: 7-day cure: 3B

#### Direct Impact Resistance:

Method: ASTM G14  
Result: 24-hour cure: Passes 90 lbs/sq in  
7-day cure: Passes 30 lbs/sq in

#### Flexibility:

Method: ASTM D522  
Result: 24-hour cure: Passes 1/8" bend  
7-day cure: Passes 1/8" bend

#### Humidity Resistance:

Method: ASTM D4585  
Result: Passes 120 hours @ 100°F

#### Dry Heat Resistance:

Method: ASTM D2485 Method A  
Result: Passes 200°F

#### Salt Spray Resistance:

Method: ASTM B117  
Result: Passes 500 hours

#### Thermal Shock:

Method: ASTM D2246 – 5 cycles  
Result: Passes

### TECHNICAL INFORMATION

*The following information is based on white.  
Other colors may vary slightly.*

**Gloss:** 85+ units @ 60° Maximum

**Use:** Protective / Decorative

**Color:** White, Black and Custom Colors

**Recommended Film Thickness:** 2.0 – 4.0 Mils Dry

**Spread Rate:** 425 – 212 sq ft/gal  
@ Recommended Dry Film – No Loss

**Dry Time:** @ 5.0 Mils Wet  
@ 77°F (25°C) & 50% Relative Humidity

To Touch: 1 – 2 hours

Tack Free: 4 – 6 hours

To Recoat: Overnight or 8 hours

Drying times are dependent upon film thickness, temperature, and humidity.

**Flash Point:** 70°F SETAFLASH

**Viscosity:** 80 – 90 KU @ 77°F (25°C)

**VOC:** 2.79 lbs/gal, or less

**Solids by Volume:** 53.00 ± 2%

**Weight per Gallon:** 10.15 lbs

**Shelf Life:** Two years unopened from date of manufacture.

**Reducer:** 560X7002 (Exempt Reducer)

**Clean Up:** 560X0952 (Wash Solvent),  
560X3502 (VM&P Naphtha), or  
560X0194 (Mineral Spirits)

## APPLICATION INFORMATION

### SURFACE PREPARATION:

Surface of substrate should be dry, clean, and in sound, paint worthy condition. The surface must be free of dirt, grease, oil, salts, loose rust, loose mill scale, and any other foreign materials or contaminants.

### Steel and Iron:

The minimum surface preparation for steel and iron is Hand Tool Cleaning per SSPC-SP2. Power Tool Cleaning per SSPC-SP3 is preferred for better performance. Prior to either procedure, the surface should be solvent cleaned per SSPC-SP1. For even better performance, begin with SSPC-SP1 followed by SSPC-SP6, Commercial Blast Cleaning. Bare metal should be primed as soon after surface preparation as possible, or before flash rusting occurs.

### APPLICATION CONDITIONS:

#### Temperature:

Temperature should not exceed 120°F or go below 40°F during application. This applies to air, surface of substrate and the primer itself. The temperature should be at least 5° F above the dew point.

#### Relative Humidity:

Dry times may be adversely affected as the relative humidity increases. Caution should be taken when painting in very humid conditions.

### MIXING & THINNING INSTRUCTIONS:

Before use, mix paint thoroughly by boxing and stirring. Mechanical agitation is preferred. Be sure all settlement, if any, is well incorporated. Thinning of this product is not normally required; however, if it is deemed necessary, use 560X7002 (Exempt Reducer).

**Note:** The addition of thinner reduces viscosity, which, in turn, affects spread rate and application characteristics. If thinner is used, make sure it is well incorporated into the paint prior to application.

*This product is available in one-gallon containers. Other units of measure are available upon request.*

## APPLICATION EQUIPMENT:

The following are general recommendations. Pressure and tip size may be varied due to temperature changes and for proper spray characteristics.

**Thinner:** Typically not recommended. If deemed necessary, use 560X7002 (Exempt Reducer).

*See Mixing and Thinning Instructions for further information.*

#### Airless Spray:

Pump Ratio: 30:1  
Hose: 1/4" or 3/8"  
Tip Size: .015 – .019  
Pressure: 1800 – 3000 psi  
Filter: 60 Mesh

#### Air-assisted Airless

Pump Ratio: 15:1 – 30:1  
Fluid Pressure: 800 – 1200 psi  
Air Pressure: 5 – 20 psi  
Fluid Hose: 1/4" – 3/8"  
Tip Size: .015 – .019

#### Conventional Spray:

Gun: Graco AirPro or equal  
Fluid Nozzle: 1.4 mm  
Air Cap: 289773  
Atomization Pressure: 40 – 50 psi  
Fluid Pressure: 15 – 20 psi

Brush: Natural Bristle

Roller: ½" or ¾" Nap

### HINTS FOR BETTER PERFORMANCE:

A clean substrate is necessary for optimal performance of the primer, as direct contact of primer and steel surface is required for rust inhibition and good adhesion.

All welds, sharp edges, angles, and other areas prone to early rusting due to insufficient coverage should be stripe-coated prior to full application in order to help prevent premature failure in these areas.

Over-thinning of the coating material can result in an insufficient film-build, poor adhesion and overall poor appearance.

During the spray application, use a 50% overlap with each pass of the gun. This will help ensure complete and thorough coverage, avoiding low build areas, which may corrode prematurely due to insufficient primer.

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The technical data furnished are true and accurate to the best of our knowledge at the date of issuance. It is subject to change without prior notice. It is suggested the user verify with Sumter Coatings, Inc. prior to specifying or ordering. Test results are believed to be reliable; however, no guarantee of accuracy is given or implied. We guarantee all products to conform to Sumter Coatings, Inc.'s quality control standards. Liability, if any, is limited to replacement of product. No other warranty or guarantee of any kind, expressed or implied, is made by Sumter Coatings, Inc., including fitness for a particular purpose.