



Thinning instructions; Van Sickle Tractor & Equipment Enamels

Van Sickle Tractor & Equipment Enamel is formulated to have a flash point over 100° F, qualifying the paint as combustible rather than Flammable (flash points under 100° F). Understandably, with a higher flash point, we use a slower dry solvent system than is used in comparable flammable products.

When thinning Van Sickle Enamel, as recommended on the label, we suggest starting at 8 parts paint to 1 part thinner (approximately 10%). Use either our R-05 VOC exempt reducer, VM&P Naphtha or Mineral Spirits. Mineral Spirits is a very slow dry solvent and is combustible; R-05 and VM&P are faster dry but are flammable. In most cases if using a flammable solvent is not an issue, we prefer VM&P Naphtha as the thinning solvent because it will “flash” off and aid in the finish coat to tack up and cure a bit faster. Both solvents are very forgiving when painting over previous finishes and are not likely to lift or wrinkle previous layers of paint, unlike stronger solvents like Lacquer Thinner or Xylene solvents.

The recommended thinning rate is basically a starting point and in most cases, depending on temperatures, the paint will need to be thinned more. Cold temperatures will thicken and hot temperatures will thin the paint much like how oils are affected by temperature, so naturally the colder the temperature the more solvent you may need. Most experienced painters will thin at a rate of about 4 or 5 parts paint to one part solvent/ reducer (about 20%). Remember, if using our Hardener in the paint always mix in the hardener 10 to 15 minutes prior to thinning.

Take care not to over apply the coating as it has a high concentration of pigment and resin solids that can be built heavier than most other paints without runs and drips. Over applying or applying 2-3 coats too quickly will result in surface drying that will be dry to touch, but will be very slow to through cure. For best results apply one good coat (2-light passes) and allow it to dry at least 8-hours prior to re-coat. Re-coats can be applied even weeks later without the need for sanding, as our enamel has very good inter-coat adhesion, unlike most automotive paints. If a finish coat is allowed to dry for a month or two, sanding is recommended prior to a second coat.