



CHEMICAL COATINGS

PRODUCT
DATACC-
B21

HIGH SOLIDS ACRYLIC ENAMEL

Package Colors				Monochromatic			
Gloss Black	F00D141	Gloss White	F88W188	Silver	F88B142	Red Oxide	F88R146
Low Gloss Black	F88B142	Container Blue	F88L159	L.F. Orange	F88E143	L.F. Red	F88R147
Container Brown	F88N150	Blending White	F88W200	Phthalo Green	F88G144	Violet	F88V148
Packer Green	F88G151	Blending Clear	F88T204	Phthalo Blue	F88L145	Yellow Oxide	F88Y149
WMI Burgandy	F00R152					Organic Yellow	F88Y148

PRODUCT DESCRIPTION

CHARACTERISTICS

SPECIFICATIONS

HIGH SOLIDS ACRYLIC ENAMEL is a high gloss, durable, 3.5 lb./gal. VOC acrylic enamel suitable for coating various metal products.

Advantages:

1. VOC compliant. Max. 3.5 lb./gal. (420 gm./liter) VOC at gun.
2. Fast air dry.
3. Good gloss and color retention.
4. Good one coat protection.
5. High gloss.
6. May be catalyzed with POLANE® Catalyst V66V29 for higher gloss, increased hardness and improved resistance properties.
7. Full color range through package colors and monochromatics.
8. Free of lead and chromate hazards.
9. Does not contain 1,1,1 Trichloroethane.
10. Apply by conventional, airless, HVLP and electrostatic spray methods.

Gloss:	Full (85 +)
Volume Solids: (As packaged)	51% ± 2% (varies by color)
Package Viscosity:	20-50 seconds #3 Zahn
Spreading Rate:	800-820 sq.ft./gal. at 1 mil dry film, no appli- cation loss (varies by color)
Package Life:	1 year
Drying: (Air Dry at 77°F, 50% R.H. at 1 mil DFT)	
To Touch:	15-25 minutes
To Handle:	30-40 minutes
Tack Free:	40-60 minutes
To Recoat:	Before 2 hours or after 24 hours
NOTE: For optimum drying and gloss, good air movement is important.	
Force Dry:	10-20 minutes 140°-180°F
Flash Point:	85°F Seta Flash Closed Cup

Air Quality Data:
Photochemically reactive. Volatile Organic Com-
pounds (VOC) 3.5 lb./gal. (420 gm./liter) max-
imum. Free of lead and chromate hazards as
packaged.

Product Limitations:

1. Critical recoat - do not recoat between 2 hours and 24 hours air drying at room temperature because of potential wrinkling and lifting. (Force drying, film thickness and varying humidity conditions may change critical recoat time.) Recoating should be tested on small areas under actual application conditions.
2. High Solids Acrylic Enamels apply best at temperature above 65°F. Coating temperature affects viscosity and application. Recommended coating temperature is above 70°F. In-line heaters reduce viscosity and improve atomization and flow. Temperatures of up to 125°F may be used.
3. When applied to properly cleaned, untreated cold rolled steel, optimum adhesion is obtained after 4-7 days air drying. Heavier films (greater than 1.5 mils) require longer drying to obtain best adhesion. Adhesion develops much faster over iron phosphate pretreatment.
4. Force dry schedules may affect color of whites because of the heat.
5. To maintain 3.5 VOC, no reduction is permitted.
6. Application by air assisted airless is not recommended because of air entrapment and poor flow.

Surface Preparation:

Iron and Steel: Substrate must be free of dirt, grease, fingerprints, rust, and other contaminants to insure good adhesion and coating performance properties. A surface chemical treatment (iron or zinc phosphate) gives better performance than untreated metal. Refer to Metal Preparation brochure CC-T1.

Primers:

For improved corrosion resistance, prime with KEM FLASH® Prime H.S. E61R702 or E61A700.

Aluminum and Galvanized Steel (Untreated):

Prime with KEM AQUA® 10P W/R prep primer E61G510/V66V511 followed by KEM FLASH® Prime H.S. primer.

Application:**Recommended film thickness:**

Wet 2.0 - 3.0 mils

Dry 1.0 - 1.5 mils

May require multiple passco

Conventional Spray:

Use 40-60 psi atomizing pressure and 3-10 psi fluid pressure with pressure pot.

Airless Spray:

Use .011-.013 tip with narrow fan and 2000-2500 psi pressure.

HVLP:

Use 8-10 psi atomizing air and 3-8 psi fluid pressure.

Electrostatic Spray (hand gun):

Addition of polar solvent will improve wrap.

NOTE: To maintain 3.5 VOC, no reduction is permitted.

High Solids Acrylic Urethane:

For increased chemical and abrasion resistance, improved hardness plus sharper gloss and better color and gloss retention, High Solids Acrylic Enamel may be catalyzed at an 8:1 ratio with POLANE® Exterior Catalyst V66V29 prior to reduction. Drying times are slower than for High Solids Acrylic. Add 1 oz. of Polane accelerator V66VB11 per gallon of paint for faster drying. Up to 4% reduction with MAK R6K30 is permitted to maintain VOC compliance.

Clean-Up:

Use Xyol or Aromatic Naphtha following supplier safety recommendations.

Safety Cautions:

Contents are **FLAMMABLE**. Keep away from heat, sparks, and open flame. Vapors will accumulate readily and may ignite explosively. During use and until all vapors are gone: Keep area ventilated—Do not smoke—Extinguish all flames, pilot lights, and heaters—Turn off stoves, electric tools and appliances, and any other source of ignition.