



# Technical Data Sheet

## 270-xxxx Interior / Exterior Industrial Acrylic Modified Enamel

### Product Description:

This acrylic modified enamel was developed as a fast drying, versatile, industrial finishing enamel for manufacturers of metal products. Product offers a quick dry time, high gloss, and good color and gloss retention. It is ideal for industrial OEM uses including metal fabrication, castings, cabinets, machinery and heavy equipment. Available in all sheens and custom colors.

### Features:

Fast Dry  
Excellent block resistance  
Excellent adhesion to variety of surfaces  
Excellent film build properties  
Excellent flow and leveling  
Very good color and gloss retention  
Very good mar and scratch resistant  
Apply by various spray application  
Unlimited color availability

### Limitations:

Substrate and ambient air above 60 F  
Excessive applications slow dry and cure  
High humidity will slow dry and cure  
Not for use on large wood structures  
Metal surfaces to be properly primed

### Specification Values

Sheen:	85 <sup>0</sup> - 95 <sup>0</sup>
Flash Point:	>79 <sup>0</sup> F
Weight per Gallon:	7.7 – 7.9 pounds
Solids by Weight:	43% - 48%
Solids by Volume:	36% - 40%
Fire Hazard Class:	3
Health Hazard Class:	2
EPA VOC:	4.2 – 4.4 lbs./gal.
VOC:	4.2 – 4.4 lbs./gal.

### Specification Information

Shelf Life: Twelve months recommended if unopened and stored between 59 and 77°F. Always rotate stock.

Pot Life: N/A

Mixing Ratio: N/A

Reduction: Thinning is not generally required. If reduction is necessary, reduce with most aromatic solvents, N Butyl Acetate or acetone. For additional open time and better flow and leveling, use MAK or EEP. Consult with your supplier for specific recommendations.

Primers: This product can be used on properly prepared bare metal surfaces for interior application. To improve adhesion and corrosion resistance and for all exterior application prime all bare metal surfaces with a fast dry industrial enamel, epoxy or two-component urethane metal primer. Consult with your coatings supplier for specific primer recommendations.

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### **Directions For Use:**

**Surface Preparation:** Surface should be free of grease, oil, release agents, curing compounds and other foreign materials. Previously primed surfaces should be sanded using 180 or 220 grit sandpaper prior to top coating. The service life of the coating is directly related to the surface preparation.

Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing. Aluminum and galvanized should be treated with appropriate metal cleaners and conditioners, including a vinyl wash primer. For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast and then coated before flash rusting occurs. For long term corrosion protection, a primer is recommended.

**Directions for Use:** Mix material before use. Add solvent to reduce, if required, and mix thoroughly. Apply by spray at wet film builds of 4-5 mils. Application and drying conditions must be at temperatures of 64°F or above and at a humidity of less than 65%. Increased airflow and/or drying temperatures, including the use of infrared, will greatly decrease dry times.

This product may be used for one-coat, direct to metal applications, for interior exposure; however a primer is required for exterior or long term corrosion protection.

Dry film thicknesses required are 1 – 3 mils above profile of metal in a minimum of two full wet coats. Recoat at tack free or up to approximately 8 hours. After 8 hours apply a small test patch to check for evidence of lifting before proceeding with a full recoat. Lifting may occur between 8 – 48 hours.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this technical data sheet will likely result in unsatisfactory film appearance or film failure.

### **Drying Times:**

Enamel will dry to touch in about 30 – 60 minutes depending on film thickness, humidity, temperature, and air movement. Dry through times may take overnight or longer. Always check for evidence of lifting before proceeding with a full recoat. Lifting may occur between 8 – 48 hours.

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity.

**Clean-up:** Clean and flush equipment with any keytone solvent, lacquer thinner, or acetone.

Best results are obtained when following label directions for use and application. Unless otherwise agreed in writing, products are sold without warranty. Users assume all responsibility and liability for loss or damage arising from their application, whether used alone or in combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended. “

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