

PRO TECH™

PRODUCTION PAINT COATINGS

PRODUCT DATA

ACRYSTAR™ Acrylic Alkyd Enamel 3000-series

Acrylic Alkyd Copolymer

PRODUCT DESCRIPTION

A high quality, quick drying, high gloss acrylic enamel for OEM use on properly prepared metal surfaces.

TYPICAL USES

For industrial and commercial use including machinery, trailers, industrial garbage compactors and containers, implements and vehicles.

PRODUCT ADVANTAGES

ACRYSTAR Acrylic Alkyd Enamel offers excellent long term protection in exposures including mild industrial and marine environments. Excellent color and gloss retention and overall durability. Good application properties with very high gloss. Provides an "automotive-like" finish. For OEM use only.

COLORS

Gloss Black 111, Gloss White 157, Bright Red 713, Cat Yellow 508, John Deere Green 404. Mixing Bases also available. Special colors available subject to minimum order.

GLOSS

High Gloss

PHYSICAL CONSTANTS

Nonvolatile - By weight - $45.5 \pm 2.0\%$ Average*

By volume - $37.6 \pm 1.0\%$ Average*

VOC (Calculated) - 4.43 lbs./gal. Average*
531 grams/liter Average*

Flash Point - 88° F (Setaflash)

Weight per gallon - 8.8 ± 0.2 lbs. Average*

*Varies with color.

APPLICATION

Recommended Film Thickness per coat - 2.0 mils dry, 5.3 mils wet

Theoretical Coverage @ 2.0 mils dry - 302 sq. ft./gal.

Method - Conventional or airless spray

Thinner - TECH Thinner #901 or XYLENE #903

Dry time @ 75°F -

To touch	-	10 minutes
To handle	-	30-45 minutes
To recoat	-	2 hours

SHIPPING & STORAGE

Consists of -	1 Gallon Unit	5 Gallon Unit
Unit Shipping Weight	10 lbs.	47lbs.

Shelf Life - 12 months minimum from date of manufacture when maintained in protected storage @ 40-100°F (subject to reinspection thereafter).

APPLICATION INSTRUCTIONS

Consult your Mobile Paint Pro Tech Representative for the protective coating system best suited for your requirements.

Limitations: Apply in good weather when air and surface temperature are above 40°F and surface temperature is at least 5°F above the dew point. For optimum application properties, material should be between 70° to 100°F prior to mixing and application. Maintain unmixed material in closed containers in protected storage at 40 - 100°F.

Surface Preparation - Good surface preparation is essential to a satisfactory coating system. Surfaces to be coated should be clean and dry. Remove all oil, grease, mildew or other contamination by solvent or detergent cleaning or other effective means.

Steel - For best performance, application to abrasive blasted surface is recommended. "Commercial Blast Cleaning" (SSPC-SP6) is recommended as the minimum. Proper blast media and blasting equipment shall be used to produce an average profile depth of 1.5 mils minimum. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs. Prime with Armor Tech primer according to directions.

Previously Finished Surfaces - Repair all damaged areas. Remove gloss from previous paint by sanding or "Brush Blasting" (SSPC-SP7). Remove rust, corrosion products, heavy chalk and loose or peeling paint by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3). Spot prime any bare areas as required. If doubt exists concerning compatibility of this coating with the previous system, apply coating to a representative area (25 square feet minimum) and allow to cure and age several weeks. Then inspect for adhesion failure, wrinkling, lifting, blistering or any other sign of incompatibility. If there are no signs, coating work can proceed.

Mixing - This is a one component coating. Always mix thoroughly with a power agitator before application.

Tinting - Mixing bases are available to custom mix hundreds of colors using the 844-series Industrial Colorants. Follow colorant systems guide in selection of base and colorants for custom colors. Multiple coats may be required with some custom colors to obtain acceptable coverage.

Thinning - Material is supplied at airless spray viscosity and should not require thinning. Clean Air Regulations may not allow thinning of this product for certain uses. Do not thin beyond applicable regulations.

Application: Apply by conventional or airless spray. Apply at 5.3 mils wet film thickness which will yield 2.0 mils dry film thickness.

Equipment - Conventional spray - For suction feed, use DeVilbiss MBC gun with E tip and needle and 30 air cap or equivalent at 40-45 psi atomizing pressure. For pressure feed, use DeVilbiss MBC gun with E tip and needle and 704 air cap or equivalent at 40-45 psi atomizing pressure and 5-8 psi fluid pressure, 3/8" ID material hose, double regulated pressure tank with oil and moisture separator. Airless Spray - Minimum of 28:1 ratio pump, .011" - .013" tip, 1/4" ID material hose.

Cleanup - Clean all equipment immediately after use with Tech Thinner #901 or Xylene #903. Completely flush all spray equipment with either of these solvents. Occasional flushing of spray equipment during the course of the working day helps prevent buildup and possible clogging.

Safety - Safe storage, handling and use dictate that adequate health and safety precautions be observed with this product and any recommended thinners. User is specifically directed to consult the current Material Safety Data Sheet for this product as well as precautions contained on product labeling.

Notice - The technical data contained herein are true and accurate to the best of our knowledge. All products are offered and sold subject to Mobile Paint Manufacturing Company's Standard Conditions of Sale. Published technical data and instructions are subject to change without prior notice.

Acrystar3000

LIMITED WARRANTY

The successful performance of this product is highly dependent on many factors beyond our control. Results are highly dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Mobile Paint warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within one year from date of shipment, Mobile Paint will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Mobile Paint and its affiliates **MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED.** The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.