



ACRYLATED ENAMEL TOPCOAT

PRODUCT DESCRIPTION

Commercial Performance Coatings Acrylated Enamel is a single pack, premium acrylic alkyd based topcoat for all general industrial applications.

It can be applied over most properly prepared substrates including metal, fibreglass, timber and existing paintwork in sound condition. It exhibits fast through-dry, good gloss, excellent flow and levelling and good durability.

Utilising the SELEMIX® universal tinter system, Commercial Performance Coatings Acrylated Enamel is available in a range of colours from the AS2700 and RAL Classic colour ranges.

PRODUCTS

Acrylated Enamel Mixed Colour		ACE
Reducers	<i>Normal conditions</i>	AER20 Alkyd Enamel Reducer Normal
	<i>Hot conditions</i>	AER30 Alkyd Enamel Reducer Slow
Cleaners		971-9119 PROTEC® Metal Conditioner
		AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover

SUBSTRATES & PREPARATION



Commercial Performance Coatings Acrylated Enamel Topcoat can be applied over the following primers:

- EPS EtchPro, VIN Vinyl Etch, ZPH High Build Primer
- RUS Rustfighter, STR Structural Primer

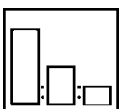


Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

For other primer options please consult the PPG Commercial Performance Coatings Technical Team.

MIXING RATIO BY VOLUME



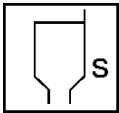
PRODUCT	PARTS
ACE Mixed Colour	100
Reducer	20 - 30%

UAE Urethane Additive

400ml per 4L

Optional

SPRAY VISCOSITY



16 - 20 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.6 mm - 1.8 mm

SPRAY PRESSURE

- CONVENTIONAL 2.0 - 2.5 bar (200 - 300 kPa, 30 - 36 psi)
- HVLP / RP 2 - 3 bar

APPLICATION & FLASH OFF



Apply 2 - 3 wet, even coats

Allow 3 - 10 minutes flash off between coats at 25°C

DRYING TIMES



AIR DRY (25°C)

- DUST FREE: 10 minutes
- TOUCH DRY: 2 - 3 hours
- DRY TO HANDLE: 12 hours
- HARD DRY: Overnight

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT



Recoat after 48 hours drying. Recommendations are based on 25°C ambient temperature.

TOTAL DRY FILM BUILD

40 - 50 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	30 - 37%, depending on colour
COVERAGE	6.0 - 9.3 metres squared per litre (m ² /L)
RESISTANCE PROPERTIES	
WEATHERING	Good
ABRASION	Good
SOLVENT	Fair
CHEMICAL	Fair
HEAT	Satisfactory up to 120°C Dry Heat
IMMERSION	Not recommended

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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