

427 Acrylic Urethane Enamel

Updated: January 2015

Specification Data

Generic Type: Aliphatic Acrylic Urethane

Description: APC0 427 is a high gloss, two part acrylic urethane enamel. It has excellent color and gloss retention properties and very fast dry times. 427 is an excellent and economical choice for high production environments. Available in a wide range of colors.

Features:

- high gloss
- VOC compliant
- Excellent color and gloss retention
- Available in a full range of colors

Solids Content: 44% by Volume

Theoretical Coverage:

- 697 mil ft²
- 232² @ 3 Mils

Allow for loss during mixing & application.

VOC Value:

- 4.00 lbs/gal per EPA Method 24
- Value is an average. And change slightly depending upon color. Refer to SDS for specific VOC

Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

Immersion Carbon Steel: Not Recommended

Non-Immersion Carbon Steel: Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 1.5-3.0 Mil.

Galvanized Steel: Not recommended

Previously painted surfaces: Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

Primer: APCO 245FP, APCO 351

Application Equipment

Spray Application:

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2001 Gun w/66 series nozzles and 565 needle.
- **Airless:** Graco 36:1 Min. 1/4" material line. Tip size .011-.013 Output PSI- 3000

Brush & Roller: Touch up only

- **Brush:** Natural Bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

Mixing & Thinning

Components: 2

Mix Ratio: 4 base Part A to 1 Activator Part B

Mixing: Mix to uniform consistency and color. Frequent stirring is required to keep aluminum pigments suspended.

Pot life: 6 hours at 75°F

Thinning:

- **Spray:** Up to 12 oz/gal with S124 if necessary
- APCO S125 May be used in hot conditions

Application

Pre-application: Flush all equipment with thinner S124 or MEK

Temperature: Application range from 50°F-110°F surface temperature. Do not apply below 50°F.

Method: Apply one coat maintaining a wet edge to achieve a WFT of 4-6 Mils. Maximum performance will be achieved with two coats totaling 4-6 mils DFT.

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Application Continued

Inspection: Visually inspect film to ensure adequate coverage.

Clean up & disposal: After use immediately flush all equipment with thinner S108 or MEK. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

Curing schedule:

Times based upon 75°F

Dry to touch: 20 Minutes

Dry to recoat: 45 minutes

Dry to cure: 24 hours

Dry times are greatly affected by weather conditions and film thickness.

Packaging & Handling:

Unit sizes: One and Five gallon units

Shipping Weight: 11.5 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII