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# ACRYLIC ENAMEL TOPCOAT SYSTEM

## **PRODUCT: Acrylic Enamel Colors**

### **FEATURES:**

- Easy to apply
- Fast dry
- Outstanding gloss
- Superior flow-out and leveling
- Excellent durability
- Excellent gloss & color retention
- Economical to use

### **SURFACE PREPARATION: ~**

- Wash surface of vehicle with soap and water to remove tree sap and road dirt
- Wipe vehicle with wax & grease remover.
- Sand area as necessary to remove any rust or corrosion
- For optimum performance, prime bare metal with US-600 Sealer primer
- Prime repaired areas with 2K urethane primer
- Block primed body work with 400 grit or finer wet or dry sandpaper
- Cleanse area to be painted with wax & grease remover
- Reseal vehicle using US-600 universal sealer
- Blow off and tack vehicle before painting

8 parts	Acrylic Enamel color
1 part	MMH-92 urethane hardener
2 parts	Enamel Reducer

### **V.O.C. INFORMATION:**

Acrylic Enamel color	V.O.C.: <569 gll (4.75 #/gal)
Less exempt solvent	V.O.C.: <569 gll (4.75 #/gal)
Mixed product	V.O.C.: <599 g/l (5.0 #/gal)

***This product may require several components and must be mixed properly to comply with V. O. C regulations. This product is not recommended as part of a multi-coat system if the V. O. C. exceeds local, state or Federal regulations.***

Continue: Acrylic Enamel

**APPLICATION INSTRUCTIONS:**

***Solid & Metallic Colors:***

- Adjust HVLP air pressure to 30 psi at the gun
- Apply 2-3 full wet coats of Acrylic enamel color
- Allow 10-15 minutes flash time between color coats
- Allow vehicle to dry overnight before exposing to weather or finessing

**•Dry Times @ 75°F:**

- Dust free: 20 minutes
- Tack Free: 4 hours
- Tape Free: 16 hours
- Delivery: overnight

For maximum paint performance, vehicle should be kept above 75°F. Temperatures below 60°F will severely retard dry times and cure of urethanes. 1/2 ounce of MMUC-211 Accelerator per mixed gallon may be added to speed up cure.

Clean equipment with a quality lacquer thinner .  
Do not leave catalyzed paint in the gun more than 4 hours.

**RECOATING PROCEDURES**

**Uncatalyzed:**

Wait a minimum of 72 hours at 75°F before attempting to repair uncatalyzed Acrylic Enamel

**Catalyzed:**

Acrylic enamel containing MMH-93 urethane hardener may be recoated after 8 hours at 75°F

**TECHNICAL DATA:**

Pot life	4 Hrs	Florida exposure	2 years
Theoretical dry film	480 sq. ft.@ 1 mil	Gloss	90%
Repair-ability	Excellent	Wt. Solids	varies by color
Mix ratio	8:1:1	Flash point	65 F.
RTS Viscosity	19-22 sec Zahn #2	Humidity	very good
Solvent resistance	very good	color retention	Excellent

**PRODUCT SAFETY INFORMATION:**

Consult Material Safety Data Sheet