Adams Paint Company



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 a 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

 $\ensuremath{\text{Pre-application:}}$ 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

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