

## ACROLON<sup>™</sup> 1850 ACRYLIC EPOXY FINISH

Revised 07/2017 Issue 5

### **PRODUCT INFORMATION**

PRODUCT DESCRIPTION					PRACTICAL APPLICATION RATES -			
A two pack Isocyanate free finish based on an acrylic epoxy binder				MICRONS PER COAT				
Endorsement			Dry	Airless Spray *	Conventional Spray	Brush #		
Complies with Norsok M501 Rev 6 System 1 as part of a three coat system. Certified for decontamination in accordance with EX07190/06/33/03.				Wet * Maximu (300µm d	125 m sag toler lry) by airle	125 rance with overla ss spray.	255 - 340 p typically 508µm wet	
<b>P</b> RODUCT <b>C</b> HARACTERISTICS				# The actual thickness within the quoted range will depend				
Finish:	High Gloss			on many variables including ambient conditions and operator				
Flash Point:	sh Point: Base 34°C Additive 33°C			additional coats may be required for safety colours.				
Colours:	White and full shade range			RECOMMENDED USE				
<b>/olume solids</b> : 59 ± 3% (ASTM-D2697-91) <b>/OC:</b> 345 gms/litre determined practically in accordance with UK				Finish coat for exterior exposed surfaces where retention of gloss is required, and the use of isocyanate products is precluded or undesirable.				
Regulations PG6/23 360 gms/litre calculated from formulation to satisfy EC Solvent Emissions Directive				Normally used in conjunction with epoxy primers and undercoats.				
252 gms/kilo content by weight from formulation, to satisfy EC Solvent Emissions Directive			<b>Recommended Application Methods</b>					
ŀ	VERAGE DRY	ING <b>T</b> IM	ES	Airless Sp Brush	oray			
	15°C	23°C	35°C	Conventio	onal Spray			
To touch:	2 hours	1 hour	½ hour	Thinning	of up to 5%	vol may be req	uired for spray application	
To recoat:	6 hours	3 hours	2 hours	Cleanser	Thinner: N	lo 5		
To handle:	12 hours	6 hours	4 hours		R	ECOMMENDED	PRIMERS	
Pot Life:	5 hours	3 hours	1 hour	Compatit Clad Epo	ole with a v oxy Primers	vide range of M s and Buildcoats	acropoxy, Dura-plate, Zinc	
These figures are	given as a guid	le only. Fa	actors such as air					
Recommended Thickness				4 days at 23°C to ensure satisfactory intercoat adhesion.				
Spreading Rate per coat:				For use with alternative undercoats please contact Sherwin- Williams				
wet microns	34	40 micror	15		RE	COMMENDED	Τορςοατς	
Dry microns	20	00 micror	IS	Indefinite	elv self-ove	rcoatable		
Theoretical Cov	erage 2.	.94 m2/ltr	*			Раскае	F	
* This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.			A two component material supplied in separate containers to be mixed prior to use					
			Pack Si	ize:	5 and 20 litre ι	inits when mixed.		
				Mixing	Ratio	2 parts base to	1 part additive by volume.	
				Weight	:	White 1.42 kg/ shade).	litre (may vary with	
				Shelf L	ife:	18 months from 'Use By' date w	n date of manufacture or vhere specified.	

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#### SURFACE PREPARATION

Ensure surfaces to be coated are clean, dry and free from all surface contamination.

#### **APPLICATION EQUIPMENT**

Airless Spray		
Nozzle Size	:	0.33mm (13 thou)
Fan Angle	:	40°
Operating Pressure	:	176ka/cm² (2500 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent with satisfactory atomisation. As conditions will vary from job to job, it is the applicators' responsibility to ensure that the equipment in use has been set up to give the best results. If in doubt Sherwin-Williams should be consulted.

#### **Conventional Spray**

Nozzle Size	:	1.27mm (50 thou)
Atomising Pressure	:	3.5kg/cm <sup>2</sup> (50 psí)
Fluid Pressure	:	0.7kg/cm <sup>2</sup> (10 psi)

The details of atomising pressure, fluid pressure and nozzle size are given as a guide. It may be found that slight variations of pressure will provide optimum atomisation in some circumstances according to the set up in use. Atomising air pressure depends on the air cap in use and the fluid pressure depends on the length of line and direction of feed i.e. horizontal or vertical.

#### Brush

The material is suitable for brush application.

#### **APPLICATION CONDITIONS AND OVERCOATING**

This material should preferably be applied at temperatures in excess of 10°C In conditions of high relative humidity, ie 80-85% good ventilation conditions are essential. Substrate temperature shall be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

Application at ambient air temperatures below 5°C is not recommended.

# Steelwork coated with ACROLON 1850 Special Finish should be protected from weather for 6 hours after application.

#### **ADDITIONAL NOTES**

Drying times, curing times and pot life should be considered as a guide only.

The curing reaction commences immediately when the two components are mixed, and since the reaction is dependent on temperature, the curing time and pot life will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.

#### Tropical Use

ACROLON 1850 at the time of mixing should not exceed a temperature of 35°C. Use of this product outside its pot life may result in inferior adhesion properties even if the material appears fit for application. Thinning the mixed product will not alleviate this problem.

It is not advisable to apply this coating when the air and substrate temperatures exceed 45°C. These conditions can introduce paint film formation defects, such as dry spray, bubbling and pinholing etc.

Numerical values quoted for physical data may vary slightly from batch to batch.

#### HEALTH AND SAFETY

Consult Product Health and Safety Data Sheet for information on safe storage, handling and application of this product.

#### WARRANTY

Any person or company using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk, and Sherwin-Williams can accept no liability for the performance of the product, or for any loss or damage arising out of such use.

The information detailed in this Data Sheet is liable to modification from time to time in the light of experience and of normal product development, and before using, customers are advised to check with Sherwin-Williams, quoting the reference number, to ensure that they possess the latest issue.

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