ACRYLIC URETHANE

K-Z6400 Series (Part A)
K-Z6415 Gloss Activator (Part B)

Acrylic Urethane is a two-component, water-based gloss coating. It is designed for high performance use in industrial and commercial environments. It offers outstanding abra-sion resistance and has excellent weathering properties.

- ✓ Retains its appearance over a wide range of chemical, weather, and mechanical conditions
- ✓ Can be applied directly to water based and solvent based organic zinc rich primers
- ✓ Non-flammable

INDUSTRIAL USE ONLY!
AS OF 01/01/2017 COMPLIES WITH:

- ☑ OTC
- ☑ EC
- ☑ SCAQMD
- ☑ CARB
- ☑ LADCO
- ☑ UTAH

krylonindustrial.com
1-800-247-3266

Revised December 2017

RECOMMENDED USES

Use this product over prepared substrates such as steel, aluminum, galvanized metal and masonry.

RECOMMENDED SYSTEM

STEEL, ALUMINUM, GALVANIZED METAL:
1 coat Iron Guard Primer
1–2 coats Krylon® Industrial Acrylic Urethane

CONCRETE BLOCK:
1 coat Krylon® Industrial Acrylic Block Filler
1–2 coats Krylon® Industrial Acrylic Urethane

CONCRETE, MASONRY:
1 coat Pratt & Lambert® Multi-Purpose Waterborne Primer
1–2 coats Krylon® Industrial Acrylic Urethane

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health e ects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fi tted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in U.S.) or contact your local health authority.

Surface must be clean, dry and in sound condition. Remove all oil, dust, grease, dirt, loose rust and other foreign materials to ensure adequate adhesion. Do not use hydrocarbon solvents for cleaning.

IRON AND STEEL:
Minimum surface preparation is Hand Tool Clean SSPC-SP2. Remove all oil and grease from surface per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3. Primer recommended for best performance.

ALUMINUM:
Remove all oil, grease, dirt, oxide and other foreign material per SSPC-SP1.

GALVANIZED METAL:
Surface should be exterior weathered for 6 months prior to painting. Remove all oil and grease per SSPC-SP1. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2. Prime clean area the same day.

CONCRETE AND MASONRY:
For surface preparation, refer to NACE 6/SSPC-SP13 or ICRI 03732, CSP 1–3. Surface should be thoroughly clean and dry. Surface temperatures must be at least 55°F before fi lling. If required for a smoother fi nish, use Krylon® Industrial Acrylic Block Filler. Filler must be thoroughly dry before topcoating per label instructions. Weathered masonry and sof or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination and to get a hard, fi rm surface. Apply one coat Krylon® Industrial Masonry Surface Conditioner, per label instructions.

MIXING INSTRUCTIONS

Mix components thoroughly with low speed agitation before use. Make certain no pigment remains on the bottom of the can. Then combine 4 parts by volume of Part A with 1 part by volume of Part B. Mix thoroughly with low speed agitation. Reduce 5-15% by volume with water for brush and roll application.

PERFORMANCE TIPS

- Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

PERFORMANCE TIPS

- When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas and pinholes. If necessary, cross-spray at a right angle.
- Spread rates are calculated based on volume solids and do not include an application loss factor due to surface profi le, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions and excessive film build.
- Reduction over 15% of material can affect film build, appearance, and adhesion.
- Do not mix previously catalyzed material with new.
- Do not apply the material beyond recommended pot life.

CLEAN UP

Clean spills and spatters immediately with soap and warm water. Clean hands and tools immediately afer use with soap and warm water. Afer cleaning, fl ush spray equipment with mineral spirits to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using mineral spirits.

TECHNICAL DATA

Vehicle	Water-based urethane		
Finish	High gloss (80+ units @ 60°F)		
Flash Point	> 230°F, Seta, catalyzed		
Volume Solids	36 ± 2% (based on Part A white/base 1)		
Weight Solids	45 ± 2% (based on Part A white/base 1)		
Weight/Gallon	9.64 lb/gal (based on Part A white/base 1)		
VOC (less exempt solvents)			
base	< 50 g/L (0.42 lb/gal) as per 40 CFR 59.406		
activator	179 g/L (1.49 lb/gal) as per 40 CFR 59.406		
Mix Ratio	4:1 by volume of Part A to Part B (K-Z6415)		
Rec. film thickness	Wet mils: 4–8		
	Dry mils: 2-4		
Spread Rate	195–390 f2/gal		
Application	Apply by airless or conventional spray, brush or roller		
Tinting	Tint Part A with Pratt & Lambert® colorants or Universal Colorants. Mix minimum 5 minutes on mechanical shaker.		
Shelf Life	36 months, unopened		
Drying Time	(@ 5 mils wet, 50% RH)		
	Drying times are temperature and humidity dependent. If maximum recoat timeis exceeded, abrade surface before recoating.		
	@ 55°F	@ 77°	@ 120°F
To Touch:	3 hours	1.5 hours	45 minutes
To Handle:	12 hours	6 hours	2 hours
To Recoat:	8 hours	5 hours	15 mins
min	16 hours	8 hours	2–4 hours
max	3 months	3 months	3 months
To Cure:	14 days	10 days	2 days
Pot Life	2.5 hours	2 hours	45 minutes

TECHNICAL DATA *CONTINUED*

Sweat In Time	None
Reduction	Water
Clean-Up	Water
Sizes	Part A, 1 gallon; Part B, 1 quart
Shelf Life	24 months, unopened

APPLICATION

Temperature	(air, surface and material) 55°F min, 120°F max, at least 5°F above dew point
Relative humidity	85% maximum
Airless Spray	
Unit	30:1 pump
Pressure	2700–3000 psi
Hose	1/4" ID
Tip	.013"–.015"
Filter	60 mesh
Conventional Spray	
Gun	DeVilbiss JGA (or equivalent)
Nozzle/Tip	765/E
Atomization Pressure	40–55 psi
Fluid Pressure	10–20 psi
Brush	Nylon/polyester
Roller	3/8" woven with solvent-resistant core

PHYSICAL TEST DATA

System Tested	
Substrate	Steel
Surface Preparation	SSPC-SP10/NACE 2
Finish	1 coat Iron Guard Primer @ 4 mils DFT
	1 coat Acrylic Urethane @ 3 mils DFT
Abrasion Resistance	
ASTM D4060, CS17 wheel, 1 kg load	25 mg loss @ 1000 cycles
Accelerated Weathering QUV	
ASTM D4587, QUV-A, 2000 hours	Passes
Corrosion Weathering	
ASTM D5894, 10 cycles, 3360 hours	Rating 10 per ASTM D610 for rusting, no more than 1/8" rust creepage at scribe
Direct Impact Resistance	
ASTM D2794	> 160 in-lb
Dry Heat Resistance	
ASTM D2485	200°F constant, 250°F intermittent
Flexibility	ASTM D522, 180° bend, 1/8" mandrel
	Passes

PHYSICAL TEST DATA

Pencil Hardness	
ASTM D3363	3H
Salt Fog Resistance	
ASTM B117, 4000 hours	Rating 9 per ASTM D610 for rusting
Thermal Shock	
ASTM D2246, 10 cycles	Passes