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 abrasion 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

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 effects, 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 fitted 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 filling. If required for a smoother filling, use Krylon® Industrial Acrylic Block Filler. Filler must be thoroughly dry before topcoating per label instructions. Weathered masonry and soft or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination and to get a hard, flat 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 profile, 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 after use with soap and warm water. After cleaning, flush 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**

<table>
<thead>
<tr>
<th>Base</th>
<th>&lt; 50 g/L (0.42 lb/gal) as per 40 CFR 59.406</th>
</tr>
</thead>
<tbody>
<tr>
<td>Activator</td>
<td>179 g/L (1.49 lb/gal) as per 40 CFR 59.406</td>
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</tbody>
</table>

**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 ft²/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**
- Wet: 4–8 hours
- Dry: 2-4 hours
- @ 5 mils wet, 50% RH

**Spread Rate**
195–390 ft²/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**
- @ 55°F: 3 hours
- @ 77°F: 1.5 hours
- @ 120°F: 45 minutes

**To Touch:**
- 12 hours
- 5 hours
- 15 min

**To Handle:**
- 18 hours
- 8 hours
- 2-4 hours

**To Recoat:**
- 48 hours
- 7 hours
- 15 mins

**To Cure:**
- 2 weeks
- 10 days
- 2 days

**Pot Life**
- 2.5 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**

<table>
<thead>
<tr>
<th>Unit</th>
<th>30:1 pump</th>
</tr>
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<tbody>
<tr>
<td>Hose</td>
<td>1/4” ID</td>
</tr>
<tr>
<td>Tip</td>
<td>.013”–.015”</td>
</tr>
<tr>
<td>Filter</td>
<td>60 mesh</td>
</tr>
</tbody>
</table>

**Conventional Spray**

<table>
<thead>
<tr>
<th>Gun</th>
<th>DeVilbiss JGA (or equivalent)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nozzle/Tip</td>
<td>765/E</td>
</tr>
<tr>
<td>Atomization Pressure</td>
<td>40–55 psi</td>
</tr>
<tr>
<td>Fluid Pressure</td>
<td>10–20 psi</td>
</tr>
<tr>
<td>Brush</td>
<td>Nylon/polyester</td>
</tr>
<tr>
<td>Roller</td>
<td>3/8” woven with solvent-resistant core</td>
</tr>
</tbody>
</table>

**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**

<table>
<thead>
<tr>
<th>ASTM D4060, CS17 wheel, 1 kg load</th>
<th>25 mg loss @ 1000 cycles</th>
</tr>
</thead>
</table>

**Accelerated Weathering QUV**

<table>
<thead>
<tr>
<th>ASTM D4587, QUV-A, 2000 hours</th>
<th>Passes</th>
</tr>
</thead>
</table>

**Corrosion Weathering**

<table>
<thead>
<tr>
<th>ASTM D5984, 10 cycles, 3360 hours</th>
<th>Rating 10 per ASTM D610 for rusting, no more than 1/8” rust creepage at scribe</th>
</tr>
</thead>
</table>

**Direct Impact Resistance**

<table>
<thead>
<tr>
<th>ASTM D2794</th>
<th>&gt; 160 in-lb</th>
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**Dry Heat Resistance**

<table>
<thead>
<tr>
<th>ASTM D2485</th>
<th>200°F constant, 250°F intermittent</th>
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</table>

**Flexibility**

<table>
<thead>
<tr>
<th>ASTM D522, 180° bend, 1/8” mandrel</th>
<th>Passes</th>
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The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of Krylon Industrial. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Krylon Industrial dealer or representative to obtain the most recent Product Data Sheet.
<table>
<thead>
<tr>
<th>Test Type</th>
<th>Specification</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pencil Hardness</td>
<td>ASTM D3363</td>
<td>3H</td>
</tr>
<tr>
<td>Salt Fog Resistance</td>
<td>ASTM B117, 4000 hours</td>
<td>Rating 9 per ASTM D610 for rusting</td>
</tr>
<tr>
<td>Thermal Shock</td>
<td>ASTM D2246, 10 cycles</td>
<td>Passes</td>
</tr>
</tbody>
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