



**Protective
&
Marine
Coatings**

ACROLON™ 218 HS ACRYLIC POLYURETHANE

PART A B65-600 GLOSS SERIES
PART A B65-650 SEMI-GLOSS SERIES
PART B B65V600 HARDENER

Revised 4/12

PRODUCT INFORMATION

5.22

PRODUCT DESCRIPTION

ACROLON 218 HS is a low VOC, polyester modified, aliphatic, acrylic polyurethane formulated specifically for in-shop applications. Also suitable for industrial applications. A fast drying, urethane that provides color and gloss retention for exterior exposure.

- Can be used directly over organic zinc rich primers (epoxy zinc primer and moisture cure urethane zinc primer)
- Color and gloss retention for exterior exposure
- Fast dry
- Outstanding application properties

PRODUCT CHARACTERISTICS

Finish: Gloss or Semi-Gloss
Color: Wide range of colors available
Volume Solids: 65% ± 2%, mixed, may vary by color
Weight Solids: 78% ± 2%, mixed, may vary by color
VOC (EPA Method 24): Unreduced: <300 g/L; 2.5 lb/gal mixed
Reduced 10% with R7K15: <340 g/L; 2.8 lb/gal mixed
Reduced 9% with MEK, R6K10: <340 g/L; 2.8 lb/gal mixed
Mix Ratio: 6:1 by volume, 1 gallon or 5 gallon mixes premeasured components

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	4.5 (112.5)	9.0 (225)
Dry mils (microns)	3.0 (75)	6.0 (150)
~Coverage sq ft/gal (m ² /L)	175 (4.3)	346 (8.5)
Theoretical coverage sq ft/gal (m ² /L) @ 1 mil / 25 microns dft	1040 (25.5)	

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 6.0 mils wet (150 microns):

	@ 35°F/1.7°C	@ 77°F/25°C 50% RH	@ 120°F/49°C
To touch:	4 hours	30 minutes	20 minutes
To handle:	18 hours	6 hours	4 hours
To recoat:			
minimum:	18 hours	8 hours	6 hours
maximum:	3 months	3 months	3 months
To cure:	14 days	7 days	5 days
Pot Life:	4 hours	2 hours	45 minutes
(reduced 5% with Reducer R7K15)			
Sweat-in-Time:	None		

If maximum recoat time is exceeded, abrade surface before recoating.
Drying time is temperature, humidity, and film thickness dependent.
Paint temperature must be at least 40°F (4.5°C) minimum.

Shelf Life*: Part A - 36 months, unopened
Part B - 24 months, unopened
Store indoors at 40°F (4.5°C) to 100°F (38°C).

*Aluminum (Part A, Rex # B65SW655) has a shelf life of 12 months.

Flash Point: 55°F (13°C), Seta, mixed
Reducer/Clean Up:
Spray: Reducer R7K15, MEK R6K10, or R7K111
Brush / Roll: Reducer #132, R7K132 or R7K111

RECOMMENDED USES

Specifically formulated for in-shop applications. For use over prepared metal and masonry surfaces in industrial environments such as:

- Structural steel
- Rail cars and locomotives
- Conveyors
- Bridges
- Wind Towers - onshore and offshore
- Offshore platforms - exploration and production
- Suitable for use in USDA inspected facilities
- Conforms to AWWA D102 Outside Coating Systems #4 (OCS-4), #5 (OCS-5) & #6 (OCS-6)
- Acceptable for use in high performance architectural applications
- A component of INFINITANK

PERFORMANCE CHARACTERISTICS

Substrate*: Steel
Surface Preparation*: SSPC-SP10/NACE 2
System Tested*:
1 ct. Macropoxy 646 @ 6.0 mils (150 microns) dft
1 ct. Acrolon 218 HS Gloss @ 4.0 mils (100 microns) dft
*unless otherwise noted below

Test Name	Test Method	Results
Abrasion Resistance ¹	ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load	43 mg loss
Adhesion	ASTM D4541	975 psi
Corrosion Weathering ²	ASTM D5894, 9 cycles, 3024 hours	Rating 10 per ASTM D610, for rusting; Rating 10 per ASTM D714, for blistering
Direct Impact Resistance ¹	ASTM D2794	50 in. lb.
Dry Heat Resistance ¹	ASTM D2485, Method A	200°F (93°C)
Flexibility ¹	ASTM D522, 180° bend, 1/8" mandrel	Passes
Humidity Resistance ²	ASTM D4585, 100°F (38°C), 1500 hours	Rating 10 per ASTM D610, for rusting; Rating 10 per ASTM D714, for blistering
Pencil Hardness	ASTM D3363	3H
Salt Fog Resistance ²	ASTM B117, 7000 hours	Rating 10 per ASTM D610, for rusting; Rating 9 per ASTM D714, for blistering

Meets the requirements of SSPC Paint No. 36, Level 3 for white and light colors. Dark colors may require a clear coat.

Complies with ISO 12944-5 C5I and C5M requirements.

Footnotes:

¹ Finish coat only tested

² Primer Zinc-Clad II Plus
Intermediate Macropoxy 646
Finish Acrolon 218 HS