



**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

## PRODUCT INFORMATION

5.22

### RECOMMENDED SYSTEMS

	Dry Film Thickness / ct.	
	Mils	(Microns)
<b>Steel:</b>		
1 ct. Macropoxy 646	5.0-10.0	(125-250)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>		
1 ct. Zinc Clad II Plus	3.0-5.0	(75-125)
1 ct. Macropoxy 646	5.0-10.0	(125-250)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>		
1 ct. Zinc Clad IV	3.0-5.0	(75-125)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>		
1 ct. Corothane I-GalvaPac Zinc Primer	3.0-4.0	(75-100)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>		
1 ct. Epoxy Mastic Aluminum II	6.0	(150)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>		
1 ct. Recoatable Epoxy Primer	4.0-6.0	(100-150)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Concrete/Masonry:</b>		
1 ct. Kem Cati-Coat HS Epoxy Filler/Sealer	10.0-20.0	(250-500)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Aluminum/Galvanizing:</b>		
1 ct. DTM Wash Primer	0.7-1.3	(18-32)
1-2 cts. Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>ISO 12944 C5M System:</b>		
1 ct. Zinc Clad III HS	3.0-5.0	(75-125)
1 ct. Tower Guard Epoxy	5.0-11.5	(125-287.5)
1 ct. Acrolon 218 HS	3.0-6.0	(75-150)

### SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

\* Iron & Steel: SSPC-SP6/NACE 3, 1-2 mil (25-50 micron) profile

\* Galvanizing: SSPC-SP1

\* Concrete & Masonry: SSPC-SP13/NACE 6, or ICRI No. 310.2, CSP 1-3

\* Primer required

#### Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted C St 2	C St 2	SP 2	-
Pitted & Rusted	D St 2	D St 2	SP 2	-
Rusted	C St 3	C St 3	SP 3	-
Power Tool Cleaning	Pitted & Rusted D St 3	D St 3	SP 3	-

### TINTING

Tint Part A with Maxitoner Colorants.

- Extra white tints at 100% tint strength
- Ultradeep base tints at 150% tint strength

Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

### APPLICATION CONDITIONS

Temperature: 35°F (1.7°C) minimum, 120°F (49°C) maximum (air and surface)  
40°F (4.5°C) minimum, 120°F (49°C) maximum (material)  
At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

### ORDERING INFORMATION

Packaging: 1 gallon (3.78L) mix; 5 gallon (18.9L) mix;  
Part A: .86 gal (3.25L) 4.29 gal (16.2L)  
Part B: .14 gal (0.53L) 0.71 gal (2.7L)  
(premeasured components)

Weight: 11.2 ± 0.2 lb/gal ; 1.3 Kg/L  
mixed, may vary with color

### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

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The systems listed above are representative of the product's use, other systems may be appropriate.