



**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

APPLICATION BULLETIN

5.22

SURFACE PREPARATIONS

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.

Iron & Steel

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (1-2 mils / 25-50 microns). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

Aluminum

Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Primer required.

Galvanized Steel

Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1. When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned or before flash rusting occurs. Primer required.

Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910. Primer required.

Follow the standard methods listed below when applicable:

ASTM D4258 Standard Practice for Cleaning Concrete.
 ASTM D4259 Standard Practice for Abrading Concrete.
 ASTM D4260 Standard Practice for Etching Concrete.
 ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.
 SSPC-SP 13/Nace 6 Surface Preparation of Concrete.
 ICRI No. 310.2 Concrete Surface Preparation.

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	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	SP 3	-

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

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up:

Spray.....Reducer R7K15, MEK R6K10, or R7K111
 Brush/RollReducer #132, R7K132, or R7K111
 If reducer is used, reduce at time of catalyzation.

Airless Spray

Pressure.....2500 - 2800 psi
 Hose.....3/8" ID
 Tip......013" - .017"
 Filter.....60 mesh
 Reduction.....As needed up to 10% by volume with R7K15 or R7K111, or up to 9% with MEK, R6K10*

Conventional Spray

GunBinks 95
 Cap63P
 Atomization Pressure.....50 - 70 psi
 Fluid Pressure.....20 - 25 psi
 Reduction.....As needed up to 10% by volume with R7K15 or R7K111, or up to 9% with MEK, R6K10*

Brush

Brush.....Natural Bristle
 Reduction.....As needed up to 10% by volume*

Roller

Cover3/8" woven with solvent resistant core
 Reduction.....As needed up to 10% by volume*

If specific application equipment is not listed above, equivalent equipment may be substituted.

* Note: Reducing more than maximum recommended level will result in VOC exceeding 340g/L