

Acrylic Lacquer

ACR-100

ACR-100 Acrylic Lacquer is a fast drying coating for interior and exterior use on properly prepared and primed metal or plastic. This product offers very good adhesion over a wide variety of plastics.

Features and Benefits:

- Very good adhesion
- Applicable on range of substrates

Associated Products:

- ACR-100 Acrylic Lacquer

Physical Constants: *All values are theoretical, depend on color and are Ready-to-Spray. Actual values could vary slightly due to manufacturing variability.*

	ACR-100 (with tints)
Weight per gallon (lbs/gal)	7.63 – 10.02
Percent solids (by weight)	28.2 – 51.0%
Percent solids (by volume)	21.4 – 31.0%
VOC (lbs/gal)	4.88 – 5.60
Flashpoint (ACR-100 only)	27°F (-4°C)
HAPs	≤2.5 lbs/gal
Photo-chemically reactive	Yes

Directions for Use:

Substrate Preparation:

The surface to be coated must be sanded and free of all contamination (including dust, dirt, oil, grease, and oxidation). A chemical treatment (or conversion coating) will improve adhesion and performance properties of the finished coat. Variability can occur with substrates, preparation, application method or environment. We recommend that adhesion and system compatibility be checked prior to full application. For optimal performance, please refer to CPC Technical Bulletin CPCTB01.

Substrate	Direct to properly treated substrate
Cold Rolled Steel	Good
Hot Rolled Steel	Good
Galvaneal	Good
Galvanized	Good
Aluminum	Fair
Plastic / Fiberglass	Surface should be free of all contamination. Because of the variability of plastic/fiberglass substrates, coating performance should be confirmed on the actual plastic/fiberglass substrate being used.

Note: *For improved performance between this topcoat and CPC primers please see the CPC Primer/Topcoat compatibility chart (CPCTB01).*

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Directions for Use (continued)

Mix Directions:



Mix Directions:	Stir thoroughly before and occasionally during use.
Thinning:	Thin 100% to 150% with medium temperature lacquer thinner. (65-85°F) NOTE: <i>Aliphatic solvents such as mineral spirits or VM&P Naptha are not compatible with this product.</i>
Pot Life @ 77°F:	N/A
Spray Viscosity Range:	#2 Zahn 12 – 20 seconds
Shelf Life: (each component)	4 years unopened, 4 years opened

Application Equipment:



Conventional:	40-50 psi 1.3 – 1.6mm
Conventional on Pressure Pot:	1.0 – 1.2mm w/ 10 – 12 oz/min fluid delivery and 40 – 50 psi at the gun, or as recommended by manufacturer
HVLP:	1.3 – 1.5mm
HVLP on Pressure Pot:	1.0 – 1.2mm w/ 10 – 12 oz/min fluid delivery and 10 psi at the cap. or as recommended by manufacturer
Airless:	Not Recommended
Air-Assisted Airless:	Not Recommended
Brush or Roll:	Not Recommended
Electrostatic:	Not Recommended

Application:



Apply:	2 – 3 medium wet coats with 10 – 15 minute flash between coats.
Recommended Wet Film Build:	3.2 – 7.0 mils
Recommended Dry Film Build:	1.0 – 1.5 mils
Coverage:	344 – 498 sq. ft. at 1.0 mil dry film per U.S. gallon (varies by color)

Dry Times:



Air Dry @ 77°F 50% RH:	
To Touch:	10 minutes
To Handle:*	45 minutes
Dry:*	24 hours
Recoat:	1 hour to 4 days
Force Dry:	N/A
Bake:	N/A

** Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.*

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Technical Data*

Performance Properties: (Results vary by color)

	Test	ASTM Method	ACR-100
BONDERITE® 1000	Chip Resistance	D3170	5 – 6
	<i>VAP-CT</i>	Gloss @ 60° Angle**	D523
ACR-100	Adhesion	D3359	4B – 5B
	In Service Temperature Limit†		180°F (82°C)

**Gloss levels can be adjusted using DX-10-FLT to achieve intermediate gloss levels.

† As you approach the In Service Temperature Limit, depending on the pigmentation, the color may change, but the film integrity will be maintained until the limit is reached.

Chemical Resistance:

	Chemical	ASTM Method	ACR-100
Bonderite 1000	MEK	D1308	Severe wrinkle
	10% NaOH (Sodium Hydroxide)	D1308	Pass
<i>VAP-CT</i>	10% HCl (Hydrochloric acid)	D1308	Pass
	10% H ₂ SO ₄ (Sulphuric acid)	D1308	Pass
ACR-100	Gasoline	D1308	Severe wrinkle
	Diesel	D1308	Pass
	Water††	D1308	Pass

†† Although resistant to intermittent exposure, not recommended for immersion.

Weather Resistance:

		ASTM Method	ACR-100
Bonderite 1000	Salt Spray – 250 hours	B117	
	Corrosion Creep	D1654	5A – 6A
	Scribe Blisters	D714	6D, 8D
	Face Blisters	D714	None
<i>VAP-CT</i>	Humidity – 100 hours	D2247	
	5 Minute Recovery Adhesion	D3359 Method B	4B – 5B
ACR-100	1 Hour Recovery Adhesion	D3359 Method B	4B – 5B
	24 Hour Recovery Adhesion	D3359 Method B	4B – 5B
	QUV-UVB: 60° angle	D4587	
	250 hour retention	D523	60 – 80%

All tests results assume proper cure and preparation of test substrates. Unless otherwise stated, all results were obtained spraying product direct to metal on *Bonderite 1000*.

* The application and performance property data above are believed to be reliable based on laboratory findings. It is for the buyer to satisfy itself on the suitability of the product for its particular use. Variation in environment, procedures of use, or extrapolation of data may cause unsatisfactory results.

Miscellaneous:

This product should not be applied to zinc substrates.

Safety:



These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment, materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness.

Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers.

Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645-1320 and in MEXICO 01-800-00-21-400. Have label information available.



Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.



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