## CHARACTERISTICS

Pro Industrial Waterbased Acrolon 100 is an advanced technology, <100 g/L VOC, waterbased, acrylic urethane. It provides performance properties comparable to premium quality solvent based urethanes. This is a high gloss, abrasion resistant urethane that has excellent weathering properties.

- Can be applied directly to water based and solvent based organic zinc rich primers
- Suitable for use in USDA inspected facilities
- Acceptable for use in high performance architectural applications

### Recommended Spread Rate per coat:

| Wet mils: | 4.0 - 8.0 |
| Dry mils: | 1.7 - 3.4 |
| Coverage: | 200 - 400 sq ft/gal |

Approximate spreading rates are calculated on volume solids and do not include any application loss. Note: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

### Drying Time @ 5.0 mils wet 50% RH:

<table>
<thead>
<tr>
<th>@ 55°F</th>
<th>@ 77°F</th>
<th>@ 120°F</th>
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</thead>
<tbody>
<tr>
<td>To touch:</td>
<td>3 hr</td>
<td>1.5 hr</td>
</tr>
<tr>
<td>To handle:</td>
<td>12 hrs</td>
<td>6 hrs</td>
</tr>
<tr>
<td>To recoat:</td>
<td>minimum: 16 hrs</td>
<td>8 hrs</td>
</tr>
<tr>
<td>maximum:</td>
<td>3 months</td>
<td></td>
</tr>
<tr>
<td>To Cure:</td>
<td>14 Days</td>
<td>10 Days</td>
</tr>
<tr>
<td>Pot Life:</td>
<td>2.5 hrs</td>
<td>2 hrs</td>
</tr>
</tbody>
</table>

Sweat-in-Time: None

Drying time is temperature, humidity, and film thickness dependent.

### Adhesion:

- Method: ASTM D4541
- Result: 1080 psi

### Corrosion Weathering:

- Method: ASTM D5894, 10 cycles
- Result: Rating 10, per ASTM D610 for rusting, no more than 1/8” rust creepage at scribe

### Flexibility:

- Method: ASTM D522, 180° bend, 1/8” mandrel
- Result: Pass

### Pencil Hardness:

- Method: ASTM D3363
- Result: 3H

### Salt Fog Resistance: System Tested

(Zinc Clad IV, 2 coats Water Based Acrolon 100)

- Method: ASTM B117, 4000 hours
- Rating: 9 per ASTM D610 for rusting

### Scrub Resistance:

- Method: ASTM D2486, 5000+ cycles, with no visible wear

### RECOMMENDED SYSTEMS

### System Tested: (*unless otherwise indicated below)

**Substrate:** Steel

**Surface Preparation**: SSPC-SP10

1 ct. Waterbased Tile-Clad Primer @ 4.0 mils (100 microns) dft
1 ct. Pro Industrial Waterbased Acrolon 100 @ 3.0 mils (75 microns) dft

**Concrete:** (high performance)

1 ct. Kem Cat-Coat HS Epoxy Filler/Sealer
1-2cts. Pro Industrial Waterbased Acrolon 100

**Concrete/Masonry:**

1 ct. Loxon Concrete & Masonry Primer
1-2cts. Pro Industrial Waterbased Acrolon 100

**Galvanizing:**

1 ct. DTM Wash Primer
1-2cts. Pro Industrial Waterbased Acrolon 100

**Pre-Finished Siding:** (Baked-on finishes)

1 ct. Bond-Plex WB Acrylic
1-2cts. Pro Industrial Waterbased Acrolon 100

### System Tested:

- OTC Yes
- LEED® 09 CI Yes
- SCAQMD Yes
- LEED® 09 NC Yes
- CARB Yes
- LEED® 09 CS Yes
- CARB SCM 2007 Yes
- CalGreen 2013 Yes
- MPI No
- NSGS Yes

As of 01/21/2016, Complies with:

<table>
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<th>OTC</th>
<th>LEED® 09 CI</th>
<th>SCAQMD</th>
<th>LEED® 09 NC</th>
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</table>

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

### Accent Orange B65EW0724/B65V00720

VOC (less exempt solvents): Mixed/Unreduced: 97 g/L - 0.81 lb/gal

As per 40 CFR 59.406 and SOR/2009-264, s.12

**Mix Ratio:** 4:1 by volume

**Volume Solids:** 42 ± 2%

**Weight Solids:** 49 ± 2%

**Weight per Gallon:** 9.43 lb

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**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 US) 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 material to ensure adequate adhesion. Recognize that any surface preparation short of total removal of the old coating may compromise the service life of the system.

**Do not use hydrocarbon solvents for cleaning.**

**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 Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 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 per SSPC-SP1. Primer required.

**Galvanizing** - 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-SP16 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. Primer required.

**Concrete and Masonry** - For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3. Surfaces should be thoroughly cleaned and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Surface temperatures must be at least 55°F(12.8°C) before filling. 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. Primer required.

**Pre-Finished Siding: (Fluorocarbon, Silicone Polyester, and Polyester Polymers)** Remove oil, grease, dirt, oxides, and other contaminants from the surface by cleaning per SSPC-SP1 or water blasting per NACE Standard RP-01-72 (caution: excessive blasting pressure may cause warping, use caution). Always check for compatibility of the previously painted surface with the new coating by applying a test patch of 2 - 3 square feet. Allow to dry thoroughly for 1 week before checking adhesion. Use recommended primer.

**APPLICATION PROCEDURES**

Mix separate 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.

Apply paint at the recommended film thickness and spreading rate as indicated on front page. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

**SAFETY PRECAUTIONS**

Refer to the Safety Data Sheets (SDSs) before use. Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

**PERFORMANCE TIPS**

Stripe coat crevices, welds, and sharp angles to prevent early failure in these areas.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

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.

**CLEANUP INFORMATION**

Clean spills, spatters, hands and tools immediately after use with soap and warm water. After cleaning, flush spray equipment with compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer’s safety recommendations when using solvents.

**APPLICATION**

**Temperature:** 55°F(13°C) minimum

**Relative humidity:** 85% maximum

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 compatible with the existing environmental and application conditions. Reduction over 15% of material can affect film build, appearance, and adhesion.

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.

**Reducer:** Water

**Airless Spray**

**Unit:** .................................................. 30:1 Pump

**Pressure:** ............................................ 2700-3000 psi

**Hose:** .................................................. 1/4" ID

**Tip:** ................................................. 013" - 015"

**Filter:** .............................................. 60 mesh

**Reduction** As needed up to 15% by volume

**Conventional Spray**

**Gun:** .................................................. DeVilbiss JGA

**Fluid Nozzle:** ........................................ E

**Air Nozzle:** ......................................... 765

**Atomization Pressure** 45-55 PSI

**Fluid Pressure** 10-20 PSI

**Reduction** As needed up to 15% by volume

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with water.

**Brush** .............................................. Nylon / polyester

**Roller** .................................................. 3/8" woven

**Reduction** As needed up to 15% by volume

With water, 5-15% minimum reduction required for brush and roll

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

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative or visit www.paintdocs.com to obtain the most current version of the PDS and/or an SDS.