

# Polybond Ltd

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## 2 Pack Acrylic Enamel - Technical Datasheet

### Product Function

This high quality Two Pack Acrylic Enamel avoids the use of isocyanates but still affords many of the important properties of urethane systems. The finish may be used on metal and glass reinforced (GR) Phenolic board and the cured film has good resistance to many chemicals and to mechanical damage. Its durability and excellent colour retention make this product ideal for exterior as well as interior use.

### Preparation

Gr Phenolic Board	The substrate must be thoroughly clean and free from mould release agents. Cleaning with Acron Panel Degreasing Solvent is recommended.
Metal	The substrate must be thoroughly clean and free from contaminants, corrosion and grease. Conventional degreasing methods may be employed but for maximum efficiency, vapour degreasing with Acron Degreasing Solvent is recommended.

### Filling

Gr Phenolic Board	Because of the porous nature of the substrate, it is recommended that a thin guide coat of Two Pack Epoxy Primer is applied which will identify the areas to be filled using Two Pack Polyurethane Paste Filler.
Metal	Deep hole filling may be carried out by knifing Two Pack Polyester Paste Stopper Grey.

### Priming

Gr Phenolic Board	The recommended primer is Two Pack Epoxy Primer.
Metal	In the presence of a chemical pre-treatment the recommended primer is Two Pack Self Etching Primer.

### Finishing Application

Two Pack Acrylic Enamel may be applied by the following method.

### Conventional Spraying

To the blend of mixed material (see mixing ratio). Thinners may be added up to 105 volume to obtain a viscosity of 35 to 40 seconds at application temperature using a BS B4 viscosity cup.

### Force Drying

When it is required to accelerate the drying process, a 'flash off' period of approximately 10 minutes should follow the application to allow the solvents to evaporate, a typical curing schedule would then be 2 to 3 hours at 60°C. Temperatures of over 60°C will require a longer 'flash off' period.

### Properties

Packaging	6 litre packs.
Flashpoint	21 to 32°C, Tested to BS 3900.
Storage	6 months in sealed containers stored between 10 to 15°C. Storage not considered outside this range.
Mixing Ratio	2Pk Acrylic Enamel must be mixed with curing agent in the ratio of 4 parts finish to 1 part curing agent by volume.
Mixture Pot Life	The mixed material will remain useable for a period of upto 8 hours under normal working conditions at 20°C.
Coverage	9 to 10m <sup>2</sup> per litre at 25 microns spraying mixed material (90 to 100 ft <sup>2</sup> ). Coverage will vary according to individual conditions.
Film Thickness	A wet film thickness of 50 to 60 microns will result in a dry film thickness of approx. 20 to 25 microns. These film thicknesses should not be exceeded.
Drying Times	These times are assuming that application takes place with a temp of 20°C. Surface Touch Dry : 10 to 15 minutes Hard Dry : 2 to 4 Hours Full Cure : 7 days Lower temperatures will significantly increase the drying times.
Cleaning	Use High Flash Gun Cleaning Solvent for cleaning all equipment after use.