



## ACRYLEX WATER REDUCIBLE PAINT APPLICATION GUIDE –

**PRODUCT TYPE:** THIS IS A LOW V.O.C. WATER REDUCIBLE ACRYLIC ENAMEL COATING. SINCE IT IS A COATING SYSTEM CONTAINING WATER, FULL CURE TIME WILL VARY DEPENDING ON THE HUMIDITY, TEMPERATURE, AND THE THICKNESS OF THE COATING APPLIED.

**CUSTOMER SERVICE TOLL FREE NUMBER:** 1 (888) 429-5832

**TYPICAL CURE SCHEDULE:**  
(AT 1.5 TO 2.0 MILS THICKNESS)

**DRY TO TOUCH:** 15 - 20 MINUTES (50% REL. HUMIDITY, 70F)

**DRY TO RECOAT:** 1 ½ HOURS (50% REL. HUMIDITY, 70F)

**DRY TO HANDLE:** 2 - 4 HOURS (50% REL. HUMIDITY, 70F)

**100% FULL CURE:** 36 - 48 HOURS

**SURFACE PREP:** THE CYLINDER SURFACE SHOULD BE CLEAN, FREE FROM DIRT AND OIL. THIS COATING IS DESIGNED TO BE APPLIED DIRECT TO BARE SHOT BLASTED CYLINDERS OR COMPATIBLE ACRYLEX BRAND PRIMER PAINTED CYLINDERS. PAINTING OVER OTHER FINISH COATINGS IS POSSIBLE, BUT SHOULD BE TESTED ON A CYLINDER FIRST, AS INCOMPATIBILITY BETWEEN OTHER COATING SYSTEMS MAY CAUSE ADHESION OR DURABILITY PROBLEMS.

**PRIMER:** THIS IS A DIRECT TO METAL COATING SYSTEM, SO PRIMER IS NOT NECESSARY. BUT, IF YOU USE A PRIMER, USE A COMPATIBLE PRIMER SUCH AS ACRYLEX BRAND WATER REDUCIBLE PRIMER.

### ACCEPTABLE APPLICATION METHODS:

#### 1. SPRAY:

DO NOT THIN THE PAINT, AS IT IS READY TO SPRAY RIGHT FROM THE PAIL. ALWAYS MIX THE PAINT THOROUGHLY BEFORE STARTING TO SPRAY PAINT CYLINDERS. APPLY THE 1<sup>ST</sup> COAT TO THE CYLINDER. A 1 MIL THICK 1ST COAT IS RECOMMENDED. ALLOW A MINIMUM OF 1 ½ HOUR DRY TIME, AND APPLY SECOND 1 MIL COAT IF NECESSARY FOR PROPER COVERAGE. A FINISH COATING THICKNESS OF 2 MIL IS RECOMMENDED. CHECK ABOVE CURE SCHEDULE FOR TYPICAL FULL CURE TIME.

**2. PIPE ROLLER:** IF YOU CAN NOT SPRAY THIS COATING, (SPRAY IS HIGHLY RECOMMENDED) USE A SEGMENTED PIPE ROLLER FOR ROLL APPLICATION. DO NOT USE A CONVENTIONAL STRAIGHT ROLLER OR BRUSH. PRE-CONDITION THE ROLLER IN THE TRAY BY ROLLING IT IN THE PAINT TO ELIMINATE NAP. ALWAYS MIX THE PAINT THOROUGHLY BEFORE STARTING TO PAINT CYLINDERS. APPLY ONE EVEN COAT TO THE CYLINDER, ALLOW A MINIMUM OF 1 ½ HOUR DRY TIME. ONLY APPLY THE SECOND COAT IF NECESSARY FOR PROPER COVERAGE, BUT KEEPING THE COATING THICKNESS DOWN TO LESS THAN 2 MILS IS DESIRED. A THICKER COATING WILL ONLY INCREASE THE DRY TIME AND ALLOW FOR THE COATING TO CHIP OFF THE CYLINDER IN THE FIELD. CHECK ABOVE CURE SCHEDULE FOR TYPICAL FULL CURE TIME.

**SAFETY PRECAUTIONS:** CONSULT MSDS