

# Marine Coatings Technical Data




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<b>Product Name</b>	Acrythane XSC High Solids 2K Topcoat
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





Issue date	7/19/2004
Formula Number	3500 Series
Product code	TOPXSCCOL

<b>Packaging</b>
Available in 1 liter, 5 liter and distributor packed sizes. Colors as per color card and many more via distributor mixing system

<b>Product Description &amp; Function</b>
Acrythane XSC is a higher solids 2 pack acrylic/urethane system especially designed for marine applications, giving 75 % solids at spray viscosity. It offers outstanding properties including rapid drying, high gloss and simplicity of usage. Acrythane XSC affords excellent protection against harsh weather conditions, sun exposure, atmospheric pollution, dirt and harsh cleaning agents. Acrythane XSC can be repaired and colors blended using a specially formulated HMG Blending Agent, maintaining the "new" boat appearance far into the future. Acrythane XSC can be routinely maintained with appropriate polishing systems such as 3M™ Finesse-It™ when required.

<b>Substrates &amp; Preparation</b>	
 <b>Aluminum</b>	Follow instructions on Primer TDS
<b>Steel</b>	Follow instructions on Primer TDS
<b>Previously painted</b>	Sand with P180-P320g in non critical applications and apply 2 coats of Acrythane XSC
<b>GRP/Gel Coat</b>	Follow instructions on Primer TDS
<b>Special Notes</b>	When overcoating Polykote Primers or DG144, Acrythane XSC can be applied any time from 1 hr to 36 hrs without the need to sand. When sanding is needed, use P220 - P320 grit sandpaper. When overcoating Epi-prime epoxy primer, sanding must be carried out before applying Acrythane XSC.

<b>Cleaning</b>
 All surfaces should be pre cleaned prior to preparation and prior to application of primer. HMG SAH 270 degreaser is highly recommended as a wipe on wipe off cleaner. Cleaning between sanded coats, Contec ProSat wipes are recommended. Always CLEAN BEFORE SANDING

<b>Application</b>		<b>HVLP</b>	<b>Pressure Pot</b>	<b>Brush/Roller</b>
 <b>Mixing Ratio</b> Acrythane XSC Hardener		4 parts 1 Part (7500/7502)	4 parts 1 Part (7500/7502)	4 parts 1 Part (7510/7512) up to 20% - But additions may be necessary to suite applicators preferences
<b>Reducer (see options)</b>		2 - 2.5	2 - 2.5	
 <b>Spray Viscosity</b>		16 - 18 sec (Zahn 2 @ 72°F)	16 - 18 sec (Zahn 2 @ 72°F)	
 <b>Gun Set Up</b>		See gun recommendations	Pot pressure 8 -12 lbs	See recommended equipment
<b>No of Coats</b>		2 full coats minimum for maximum performance		2 full coats for maximum performance
 <b>Flash Off</b>		15 - 30 min @ 72°F		
<b>Drying</b>		2 hours @ 72°F		
<b>Pot Life</b>		2 hours @ 72°F		
<b>Film Build</b>		1.5 - 2 mils DFT per coat		
 <b>Overcoating</b>		Can be overcoated any time after flash off but will require sanding or abrading if left more than 36 hours		Can be overcoated after overnight dry or a minimum of 8 hours. Light sanding should be carried out
 <b>Sanding</b>		When sanding is required between coats (if left for more than 36 hours or for best results) use P320 grit sand paper and tack off. Contec ProSat wipes help to reduce static and provide a clean substrate ready for painting.		
<b>VOC (Ready for Use)</b>		<480g/l		

**Reducer Options**

Acrythane XSC Reducer CB122	V. Fast	(small jobs)	} Dependant on temperature or size of vessel to enable a Wet Edge to be retained. The choice of correct reducer will give optimum lay down and ease of application. Reducers can be mixed if desired.
Acrythane XSC Reducer CB122 (RTD)	Fast	(winter)	
Acrythane XSC Reducer Medium	Medium	(winter/summer)	
Acrythane XSC Reducer A788	Slow	(summer)	
Acrythane XSC Reducer Brushing	Extra Slow Reducer		

**Hardener Options**

Acrythane XSC Spraying (7500/7502)	All season hardener. Can be accelerated by the addition of A212 (substitute 10% of the reducer when adding)
AcrythaneXSC Brushing (7510/7512)	A superlative brushing hardener for all job sizes. Can be used with XSC Clear for superior brushing varnish

Acrythane XSC hardeners were updated in August 2004 - DO NOT use previous hardeners at these stated mix ratios.

**Always use the mix ratio as stated on the hardener can.**

**Technical Information**

<b>Solids</b>	Approx 75% by weight
<b>Flashpoint</b>	Between 72 - 90°F
<b>Storage</b>	12 Months in Original sealed containers
<b>Equipment Cleaning</b>	HMG Acrythane Reducers or Acetone
<b>Coverage</b>	488 sq.ft per US Gallon (theoretical)
<b>VOC (Unmixed)</b>	422g/l approx

**Special Properties**

Acrythane XSC21 are available in a variety of sheen levels when blended with HMG Matting Agent.

**Special notice - prevailing weather conditions**

Acrythane XSC should not be applied in temperatures below 50 °F as curing times become extended beyond practical limits. Painting late in the day may result in condensation forming on the paint film that leads to loss of gloss and potential blistering problems in the cured coating. Space heaters can create moisture and worsen the situation. DO NOT apply paint if the temperature is going to drop below the dew point within 6 - 8 hrs after painting is complete.

**Health & Safety**

Refer to "Material Safety Data Sheet" and can label prior to use. Contains isocyanates

FOR PROFESSIONAL USE ONLY. PAINT APPLICATORS ARE ASSUMED TO BE EXPERIENCED IN THE HANDLING AND APPLICATION OF THESE PRODUCT TYPES

KEEP OUT OF THE REACH OF CHILDREN

Wear suitable respiratory equipment. When spraying use air fed respirator.

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