

## 231 Fast Dry Acrylic

Updated: January 2015

### Specification Data

**Generic Type:** Solution Acrylic

**Description:** APCO 231 Fast dry Acrylic is a solution acrylic enamel. Very fast dry times are possible with APCO 231. Provides tight barrier protection to properly prepared steel surfaces. Attractive semi-gloss finish helps hide imperfections. Formulated for use on power transmission equipment

**Features:**

- Semi-gloss
- Very fast dry times

**Solids Content:** 36% by Volume

**Theoretical Coverage:**

- 577 mil ft<sup>2</sup>
- 230 ft<sup>2</sup> @ 2.5 DFT

Allow for loss during mixing & application.

**VOC Value:**

- 4.6 lbs/gal per EPA Method 24

**Color:** 1046 ANSI-70 Gray, 3018 Padmount Green

### Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

**Immersion Carbon Steel:** Not Recommended

**Non-Immersion Carbon Steel:** Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 1.5-3.0 Mil.

**Galvanized Steel:** Not recommended

**Previously painted surfaces:** Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

**Primer:** APCO 255 Epoxy Ester Primer

### Application Equipment

**Spray Application:**

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2001 Gun w/66 series nozzles and 565 needle.
- **Airless:** Graco 36:1 Min. 1/4" material line. Tip size .011-.013 Output PSI- 3000

**Brush & Roller: Touch up only**

- **Brush:** Natural Bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

### Mixing & Thinning

**Components:** One

**Mixing:** Mix to uniform consistency and color. Frequent stirring is required to keep aluminum pigments suspended.

**Thinning:** Normally not required

- **Spray:** Up to 12 oz/gal with S100 if necessary

### Application

**Pre-application:** Flush all equipment with thinner S100 or xylene

**Temperature:** Application range from 50°F-110°F surface temperature. Do not apply below 50°F.

**Method:** Apply one coat maintaining a wet edge to achieve a WFT of 4-6 Mil. Maximum performance will be achieved with two coats totaling 4-6 mils DFT.

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### **Application Continued**

**Inspection:** Visually inspect film to ensure adequate coverage.

**Clean up & disposal:** After use immediately flush all equipment with thinner S100 or xylene. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

**Curing schedule:**

Times based upon 75°F

Dry to touch: 20 minutes

Dry to recoat: 20 minutes

Dry through: 1 hour

Dry times are greatly affected by weather conditions and film thickness.

**Packaging & Handling:**

Unit sizes: Ones & Fives

Shipping Weight: 9.5 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII