WATERBORNE ACRYLIC ENAMEL

K-Z6600 Series (Satin)
K-Z6700 Series (Semi-Gloss)
K-Z6800 Series (Gloss)

Waterborne Acrylic Enamel, is a high gloss, 100% acrylic, waterborne, corrosion resistant coating for light to moderate industrial use. Designed for new construction or maintenance use and can be used directly over prepared substrates.

- ✓ Early rust and moisture resistant
- ✓ Flash rust resistant
- ✓ Corrosion and chemical resistant
- ✓ Fast dry
- ✓ Single component
- ✓ Interior/exterior use

INDUSTRIAL USE ONLY!
AS OF 01/01/16 COMPLIES WITH:

- ☑ OTC
- ☑ CARB
- ☑ EC
- ☑ LADCO
- ☑ SCAQMD

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Revised June 2016

RECOMMENDED USES

For use over prepared substrates in industrial environments.

- Steel
- Iron
- Aluminum
- Galvanized Metal
- Concrete Block
- Masonry
- Wood
- Drywall
- Previously Painted Surfaces

RECOMMENDED SYSTEM

Steel (with primer):

1 coat Krylon® Industrial Universal Metal Primer
2 coats Krylon® Industrial Waterborne Acrylic Enamel

Steel (unprimed):

2 coats Krylon® Industrial Waterborne Acrylic Enamel
(White/Base 1 or custom tints from White/Base 1 only. Deeper colors require a primer. Note that application over unprimed bare steel may cause pinpoint rusting.)

Aluminum, Galvanized Steel:

1 coat Krylon® Industrial Iron Guard Primer
2 coats Krylon® Industrial Waterborne Acrylic Enamel

Pre-Finished Siding (Baked-on Finishes):

1 coat Krylon® Industrial Acrylic Waterborne Bonding Primer
2 coats Krylon® Industrial Waterborne Acrylic Enamel

Concrete, Masonry:

1 coat Krylon Industrial® Iron Guard Primer
2 coats Krylon® Industrial Waterborne Acrylic Enamel

Concrete Block:

1 coat Krylon® Industrial Acrylic Block Filler
2 coats Krylon® Industrial Waterborne Acrylic Enamel

Wood:

1 coat Krylon Industrial® Iron Guard Primer
2 coats Krylon® Industrial Waterborne Acrylic Enamel

Previously Painted Surfaces:

2 coats Krylon® Industrial Waterborne Acrylic Enamel

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 U.S.) 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 materials to ensure adequate adhesion. **Do not use hydrocarbon solvents for cleaning.**

Safety colors and colors tinted from Base 2/Deep and Base 3/Neutral require a prime coat for maximum durability, adhesion and corrosion protection.

Iron and Steel:
Minimum surface preparation is Hand Tool Clean SSPC-SP2. Remove all oil and grease from surface per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6. Primer recommended for best performance.

Aluminum:
Remove all oil, grease, dirt, oxide and other foreign material per SSPC-SP1.

APPLICATION *CONTINUED*

Galvanizing:
Surface should be exterior weathered for 6 months prior to painting. Remove all oil and grease per SSPC-SP1. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2. Prime clean area the same day with Krylon® Industrial Universal HP Acrylic Primer.

Concrete and Masonry:
For surface preparation, refer to NACE 6/SSPC-SP13 or ICRI 03732, CSP 1–3. Surface should be thoroughly clean and dry. Surface temperatures must be at least 55°F before filling. If required for a smoother finish, use Krylon® Industrial Acrylic Block Filler. Filler must be thoroughly dry before topcoating per label instructions. Weathered masonry and soft or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination and to get a hard, firm surface. Apply one coat Krylon® Industrial Masonry Surface Conditioner, per label instructions.

Wood:
Surface must be clean, dry and sound. Prime with recommended primer. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped, sanded and spot primed before a full coat of primer is applied. All nail holes or small openings must be properly caulked.

Pre-Finished Siding:
Clean per SSPC-SP1 or water blasting per NACE Standard RP-01-72. 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. Prime with Krylon® Industrial Acrylic Waterborne Bonding Primer.

Previously Painted Surfaces:
If in sound condition, clean surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.

CLEAN-UP

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

TECHNICAL DATA

Vehicle	Acrylic
Finish	36 months, unopened, at 77°F
Tinting	Satin: 10–20 units @ 85°F
	Semi-Gloss: 35–50 units @ 60°F
	Gloss: 70+ units @ 60°F

TECHNICAL DATA *CONTINUED*

Volume Solids			
satin	37 ± 2%		
Semi-Gloss	36 ± 2%		
Gloss	36 ± 2%		
Weight Solids			
satin	45 ± 2%		
Semi-Gloss	50 ± 2%		
Gloss	44 ± 2%		
Weight/Gallon			
satin	9.6 lb/gal		
Semi-Gloss	9.5 lb/gal		
Gloss	9.5 lb/gal		
VOC (less exempt solvents)	< 50 g/L (0.42 lb/gal) as per 40 CFR 59.406		
Rec. film thickness	Wet mils: 6–12		
	Dry mils: 2.5–4		
Spread Rate	140–225 ft²/gal		
Shelf Life	36 months		
Application	Apply by airless or conventional spray, brush or roller		
Drying Time	@ 7 mils wet, 50% RH		
	Note: Drying times are temperature, humidity and film thickness dependant.		
	@ 50°F	@ 77°F	@ 120°F
To Touch:	1 hour	30 mins	5 mins
Tack Free:	8 hours	5 hours	15 mins
To Recoat:	8 hours	5 hours	15 mins
To Cure:	30 days	30 days	30 days
Reduction	Water		
Clean-Up	Soap and Water		
Tinting	Universal Colorants		
Sizes	1 gallon, 5 gallon		

APPLICATION

Temperature (air, surface and material)	50°F min, 120°F max, at least 5°F above dew point
Relative humidity	85% maximum
Reducer/Clean-up	Lacquer Thinner
Airless Spray	
Pressure	1500 psi
Hose	1/4" ID
Tip	.017"–.021"
Filter	60 mesh
Reduction	Not recommended

APPLICATION *CONTINUED*

Conventional Spray	
Gun	Binks 95 (or similar)
Fluid Nozzle	66
Air Nozzle	63PBB
Atomization Pressure	50 psi
Fluid Pressure	15-20 psi
Reduction	As needed up to 12.5% by volume
Brush	
Brush	Nylon/polyester
Reduction	Not recommended
Roller	
Cover	3/8" woven
Reduction	As needed up to 5% by volume

PHYSICAL TEST DATA

System Tested	
Substrate	Steel
Surface Preparation	SSPC-SP10
Finish	2 coats Waterborne Acrylic Enamel
Adhesion	
Method	ASTM D4541
Result	1386 psi
Corrosion Weathering	over Universal Metal Primer
Method	ASTM D5894, 3360 hrs, 10 cycles
Result	Blistering: rating 10, per 5 cycles ASTM D714
	Corrosion: rating 9 per ASTM D1654
Direct Impact Resistance	
Method	ASTM D2794
Result	160 in-lb
Dry Heat Resistance	
Method	ASTM D2485
Result	250°F
Flexibility	over Universal Metal Primer
Method	ASTM D4585, 1500 hours
Result	Passes
Humidity Resistance	
Method	ASTM D4585, 1500 hours
Result	Blistering: rating 10 per ASTM D714
	Corrosion: rating 10 per ASTM D1654
Pencil Hardness	
Method	ASTM D3363
Result	2B

PHYSICAL TEST DATA *CONTINUED*

Salt Fog Resistance	over Acrylic WB Primer
Method	ASTM B117, 1500 hours
Result	Bistering: rating 10 per ASTM D714
	Corrosion: rating 9 per ASTM D1654
Thermal Cycling	
Method	ASTM D2246, 5 cycles
Result	Passes