

APPLICATION:

1. Adjust the air pressure at the gun to: 40-50 psi for siphon-feed gun
40-50 psi for pressure-feed gun with 5-10 psi at the pot.
2. Apply **2-3** medium wet coats of ACRYLYD® Acrylic Enamel at a gun distance of **8-10** inches, allowing each coat to become hand slick before applying the next coat. Spray to hiding. To uniform metallic colors apply immediately a mist coat by increasing the gun distance to **10-12** inches. Note: Recommended dry film thickness is **2.0-2.5** mils

RECOMMENDED GUNS:

<u>Spray Gun Type</u>	<u>Manufacturer</u>	<u>Spray Gun Model</u>	<u>Nozzle</u>	<u>Air Cap</u>	<u>Gun Pressure</u>
HVLP Gravity Feed	Sata	NR2000	1.3 mm	Use one supplied	*9-10 psi at cap
HVLP Gravity Feed	Sata	NR95	1.3 mm	Use one supplied	*10 psi at cap
HVLP Gravity Feed	DeVilbiss	GTI Millennium	1.3 mm	#2000	*10 psi at cap
HVLP Gravity Feed	Sharpe	Titanium T1	1.4-1.5 mm	Use one supplied	*10 psi at cap
Conv. Gravity Feed	Sata	Jet 90	1.3 mm	Use one supplied	40-50 psi

**Use specific spray gun manufacturer air cap test kit to verify the appropriate air cap pressure for proper atomization.*

**Adjust fluid control for proper delivery and atomization.*

Note: 1.4 mm and 1.5 mm nozzle sets can be used if desired.

DRYING SCHEDULE:

Dry times are based on the recommended dry film thickness of 2.0 – 2.5 mils.

**ACRYLYD®
at 8:4*:1 with V6V241/V6V247**

▪ Air Dry Times:	Dust Free	1 hour
	To Buff	Overnight
▪ Force Dry Times:	120°F	1 hour
	140°F	45 minutes

**(4*) -- Use 3 parts of exempt reducer (ES15 or ES20) to 1 part of the appropriate standard reducer (R7K227 or R7K244). ES15 is to be used with only R7K227. ES20 is to be used with only R7K244.*

Note: Refer to the vehicle manufacturer for maximum allowable force dry temperature of vehicle.

RECOATING:

ACRYLYD® with a Hardener may be recoated at any time.

NOTES:

Pressure sensitive decals may be applied after ACRYLYD® is tape free (see drying schedule above). Large, thick, or foil backed decals should be applied after 16 hours.

PRODUCT AT-A-GLANCE

PRODUCT

ACRYLYD® Acrylic Enamel System

Prefix 35, F8, F10, F11, J5, JX

USE

- For spot, panel, or overall refinishing of automobiles and fleets.
- Available in intermix or factory package colors.
- Dries quickly to a tough yet flexible film with 50% better durability than enamels.
- Uses POLASOL V6V241 or POLASOL PLUS V6V247 Urethane Hardeners.

BASECOAT SUITABLE SUBSTRATES

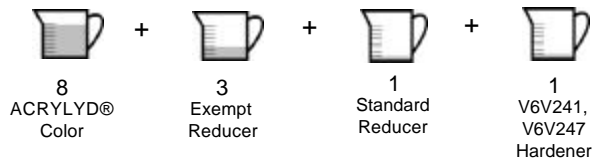
- OEM topcoats
- OEM Lacquers
- Refinish Enamels
- Refinish Lacquers
- G.B.P.® Etching Filler
- SuperCOMBO® Primer-Surfacer
- ULTRA -FILL® Primer-Surfacer
- ULTRA -FILL® II Primer-Surfacer
- ULTRA -FILL® II Sealer
- JET SEAL®
- COLOR PRIME®

SURFACE PREPARATION

- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with the appropriate solvent cleaner, and wipe dry with a clean cloth.
- **Grind** repair area to remove paint and all rust as needed.
- **Apply body filler** to clean bare metal as needed.
- **Sand** all areas to be refinished and feather edge all broken film areas.
- **Treat** bare metal with an appropriate metal conditioner or etching primer.
- **Surface** with ULTRA -FILL® Primer-Surfacer. Finish sand with 320 grit sandpaper.

MIXING

- Stir or shake ACRYLYD® color thoroughly before mixing.
- Mix by volume. Maximum VOC less exempt as applied at 8:4*:1 is 4.98 lbs/gal (598 g/l).



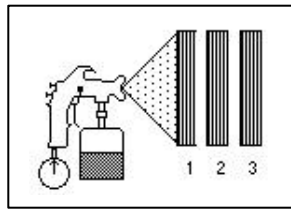
Pot life: 6 hours

(4) -- Use 3 parts of exempt reducer (ES15 or ES20) to 1 part of the appropriate standard reducer (R7K227 or R7K244). ES15 is to be used with only R7K227. ES20 is to be used with only R7K244.

APPLICATION

Siphon Feed

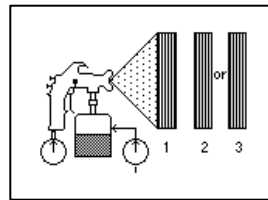
Apply 2-3 medium wet double coats. Allow each coat become hand slick.



40-50 psi

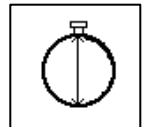
Pressure Feed

Apply 2-3 medium wet double coats. Allow each coat to become hand slick.



40-50 psi Pot Pressure: 5-10psi

Time to Recoat
Anytime



RECOAT

- Decals may be applied after ACRYLYD® is tape free (see drying schedule). Large decals should be applied after 16 hours.

NOTES

- If fisheyes are a problem add to sprayable gallon of color, 1/2 ounce of The LEVELER® Fisheye Eliminator V3K780.
- For additional flow in hot/humid weather add up to 2 ounces of Universal Urethane Retarder R7K6252 when using V6V247. Use up to 1 ounce R7K6252 when using V6V241.
- Recommended dry film thickness is 2.0-2.5 mils. Cracking may occur with low film thickness.

PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a positive air respirator or when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, shoe covers, coveralls and latex gloves, stretch hood when using this product.

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