

**PRODUCT DESCRIPTION:**

ACRYLYD PLUS® is a high-quality polyurethane of exceptional gloss and Distinctness of Image (DOI). Designed primarily for overall refinishing, ACRYLYD PLUS® is simple to use, easy to apply, with performance characteristics associated with polyurethane finishes. ACRYLYD PLUS® when mixed 4:1 with V6-V440 meets U.S. National Rule Requirement of 5.0 lbs/gal (599 g/l) maximum ready-to-spray VOC (volatile organic compounds).

**TECHNICAL DATA:**

• Viscosity (sprayable)	#4 Ford Cup	16-18 sec	• Flexibility over 1/8" conical mandrel*	Excellent
	#2 Zahn Cup	20-25 sec	• Pencil hardness at 1 week air dry	B
• Flash point	ACRYLYD PLUS®	46°F T.O.C.	• Humidity resistance* at 100 hrs	Excellent
	V6V440	77°F PM	• Solvent resistance (1 week air dry)	
			Unleaded gasoline	Excellent
			Diesel Fuel	Excellent
• Coverage rate per sprayable gallon (white) at 1 mil dry with V6V440		490 sq ft/gal	• Dielectric strength over steel	2000 volts per mil
• Gloss*	60°	93 minimum	• Max VOC as applied	5.0 lbs/gal (599 g/l)
	20°	85 minimum	(Total and Less Exempt)	
	DOI	80 minimum – 94 maximum	* After one week air dry.	

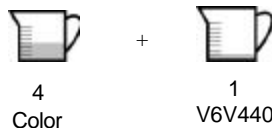
**SURFACE PREPARATION:**

(Refer to respective product labels or data pages for complete information.)

- Final sand repair area when sealing with P400 grit or finer sandpaper. When directly topcoating over primer surfacer, final sand repair area with P600 or finer sandpaper. Sanding can be done either wet or dry.
- Solvent clean area to be refinished with appropriate Sherwin-Williams surface cleaner. Wipe dry with a clean cloth.
- Treat sand throughs to bare metal with appropriate Sherwin-Williams metal treatment system.
- If a sealer is required, use any of the following: SpectraSeal™, ULTRA-FILL® II Sealers, or S65 2K Basecoat Transparent / Adhesion Promoter.

**MIXING:**

- Stir or shake ACRYLYD PLUS® Polyurethane Enamel color thoroughly before using.
- Mix by volume. Maximum VOC less exempt as applied 5.0 lbs/gal (599 g/l).



**Pot life: 6-8 hours**

- For **flexible parts**: Mix by volume 4 parts color to 1 part ACRYLYD PLUS® Activator, stir, then add 1 part MULTI-FLEX™ Flexible Additive V6V299. Pot life – 6 hours.
- If **fisheyes** are a problem add up to 1 ounce (1 full pump) of SILA-CHEK® Silicone Additive V3K265 per sprayable gallon of color.
- To improve flow/leveling in **hot/humid** conditions add **1-2 ounces** of Universal Urethane Retarder R7K6252 per sprayable quart.

**APPLICATION:**

**Non-Metallics:**

- Adjust the air pressure at the gun to 50-55 psi for siphon-feed gun  
50-55 psi for pressure-feed gun with 5-7 psi at the pot
- Apply 2-3 medium wet coats of ACRYLYD PLUS® at a gun distance of 8-10 inches, allowing each coat to become hand slick before applying the next coat. Spray to hiding. **Note:** Recommended dry film thickness is 2.0-2.5 mils.

**Metallics:**

1. Adjust the air pressure at the gun to 55-60 psi for siphon-feed gun  
55-60 psi for pressure-feed gun with 5-7 psi at the pot.
2. Apply 2 medium wet coats of ACRYLYD PLUS® at a gun distance of 8-10 inches, allowing the first coat to become hand slick before applying the next coat. If a third coat is required to even out the metallic, the second and third coats should be applied back to back (wet on wet) panel to panel. **Note:** Recommended dry film thickness is 2.0-2.5 mils. *Note: These are recommendations only, adjustments for spray technique and conditions may be necessary.*

**GUN AND EQUIPMENT RECOMMENDATIONS:**

<u>Spray Gun Type</u>	<u>Manufacturer</u>	<u>Gun Model</u>	<u>Nozzel</u>	<u>Air Cap</u>
Siphon Feed	DeVilbiss	JGA Series	EX	80
Siphon Feed	Sharpe	975/971	1.8 mm	1-71-02MO
Gravity Feed	SATA	SATA Jet 90	1.6 mm	Nozzle Set
HVLP Gravity	DeVilbiss	GTI	1.6 mm	Supplied
HVLP Gravity	SATA	Jet/B-NR95	1.5 mm	Nozzle Set
HVLP Gravity	Sharpe	Titanium T1	1.4-1.5 mm	Supplied
Conv. Pressure Pot	SATA	Jet K	1.1 mm	Supplied
Conv. Pressure Pot	DeVilbiss	JGA Series	1.1 mm	80/777

**DRYING SCHEDULE:**

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

**ACRYLYD PLUS®  
WITH V6V440**

- **Air Dry Times:** Dust Free 30 minutes  
Tack Free 8 hours  
Tape Free 16 hours
- **Force Dry Times:** 120°F 2 hours  
(tape free) 140°F 60 minutes  
160°F 30 minutes

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

**RECOATING:**

ACRYLYD PLUS® can be recoated at anytime without the fear of lifting. It can also be recoated up to 72 hours later without the need for scuffing or sanding. Older films should be scuff sanded with no-fill type sandpaper to insure good adhesion of new topcoat to old.

**REPAIRABILITY:**

ACRYLYD PLUS® should be repaired with ACRYLYD PLUS®. This will insure that the repair will match the high gloss and appearance of the rest of the vehicle.

ACRYLYD PLUS® is not suitable for repairing OEM or most other quality finishes because the repaired area(s) will be higher in gloss than the rest of the vehicle. ACRYLYD PLUS® is designed as an approximate match for overall refinishing and is not designed for spot/panel repairs to match original color.

ACRYLYD PLUS® should be allowed to dry for 1 month before buffing. Premature buffing could cause loss of gloss. ACRYLYD PLUS® should be checked for buffability on an inconspicuous, lower portion.

**CLEARCOATING:**

DO NOT Clearcoat ACRYLYD PLUS®.

**NOTES:**

Pressure-sensitive decals may be applied after ACRYLYD PLUS® is tape free (see drying s chedule on previous page). Large, thick, or foil backed decals should be applied after 16-72 hours.

# PRODUCT AT-A-GLANCE

## PRODUCT

ACRYLYD PLUS®

Prefix 37, P10, P11, P5, PX

Polyurethane Enamel System

## USE

- For overall finishing.
- Available in intermix colors.
- Simple to use and easy to apply.
- Superb gloss and through dry.

## BASECOAT SUITABLE SUBSTRATES

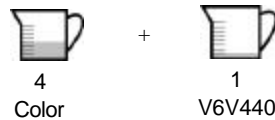
- OEM Enamel
- Refinish Enamels
- G.B.P.® Etching Filler
- SuperCOMBO® Primer-Surfacer
- ULTRA -FILL® Primer-Surfacer
- ULTRA -FILL® II Primer-Surfacer
- ULTRA -FILL® HS/NP Primers
- ULTRA -FILL® II Sealer
- JET SEAL®
- COLOR PRIME®

## 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® or ULTRA -FILL II® Primer-Surfacers. Finish sand with 400 grit sandpaper.
- **Seal** with appropriate sealer for best results.

## MIXING

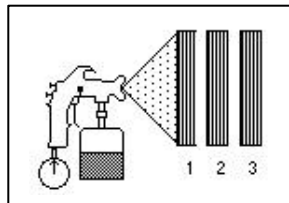
- Stir or shake ACRYLYD PLUS® color thoroughly before mixing.
- Mix by volume 4 parts of Color with 1 part Activator V6V440.



## APPLICATION

### Siphon Feed

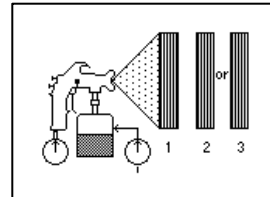
Apply 2-3 medium wet double coats.  
Allow each coat to become hand slick.



**50-60 psi**  
Pot life: 6-8 hours

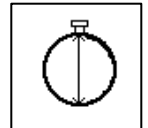
### Pressure Feed

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



**50-60 psi**  
Pot Pressure: 5-10 psi  
Pot life: 6-8 hours

### Time to Recoat



## RECOAT

- ACRYLYD PLUS® can be recoated at any time without the fear of lifting. It can also be recoated up to 72 hours later without the need for scuffing or sanding. Older films should be scuff sanded with no-fill type sandpaper to insure good adhesion of new topcoat to old.

## NOTES

- If fisheyes are a problem add up to 1 ounce (1 full pump) of V3K265 SILA-CHECK Silicone Additive to sprayable gallon of color.
- For flexible parts add MULTI-FLEX® V6V299.
- 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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