Pro Industrial™ Acrolon™ 100

Waterbased Urethane High Gloss

B65–920 Series (Part A), B65V00620 (Part B)

CHARACTERISTICS

Pro Industrial Waterbased Acrolon 100 is an advanced technology, less than 100 grams per litre V.O.C., waterbased, acrylic urethane. It provides performance properties comparable to premium quality solvent-based urethanes. This is a high gloss, abrasion resistant urethane that has excellent weathering properties.

- Can be applied directly to water based and solvent based organic zinc rich primers
- Suitable for use in Canadian Food Processing facilities (B65W921, B65T924, B65R928, B65Y927 & B65V620): Non-Food contact areas.
- Easy application & cleanup
- Ultradeep Tint Base (B65T00924) can be used as clear coat
- Suitable for use in USDA inspected facilities

Finish: 80° + units @ 60° High Gloss
Color: Most Colors

Recommended Spreading Rate per coat:

Wet mils:	4.0-8.0
Dry mils:	1.5-3.0
Coverage:	200-400 sq. ft. per gallon
Theoretical Coverage:	593 sq. ft. per gallon @ 1 mil dry

Approximate spreading rates are calculated on volume solids and do not include any application loss.
Note: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 5.0 mils wet, @ 50% RH: Drying and recoat times are temperature, humidity, and film thickness dependent.

	@55°F	@77°F	@120°F
To touch:	3 hrs.	1.5 hrs.	45 min.
To handle:	12 hrs.	6 hrs.	2 hrs.
Minimum recoat:	16 hrs.	8 hrs.	2-4 hrs.
Maximum recoat*:	3 months	3 months	3 months
To Cure:	14 days	10 days	2 days
Pot Life:	3 hrs.	2.5 hrs.	1 hour
Sweat-In-Time:	non required		

Mix Ratio: **2 components, 6:1 by volume**
*If maximum recoat time is exceeded, abrade surface before recoating.
Tinting Part A with CCE: Use the 100% tint strength formula pages. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

Extra White B65W00921/B65V00620
(may vary by color)
V.O.C. (less exempt solvents):
As mixed 6:1 unreduced
86 grams per litre; 0.72 lbs. per gallon
As per 40 CFR 59.406

Volume Solids:	37 ±2%
Weight Solids:	46 ±2%
Weight per Gallon:	9.58 lbs
Flash Point:	106°F TCC
Vehicle Type:	Acrylic Urethane
Shelf Life:	24 months, unopened

COMPLIANCE

As of 11/06/2024, Complies with:

OTC	Yes
OTC Phase II	Yes
S.C.A.Q.M.D.	Yes
CARB	Yes
CARB SCM 2007	Yes
CARB SCM 2020	Yes
Canada	Yes
LEED® v4 & v4.1 Emissions (CDPH v1.2-B65W921/B65V620)	Yes
LEED® v4 & v4.1 V.O.C.	Yes
EPD-NSF® Certified	No
MIR-Manufacturer Inventory	No
MPI®	No

APPLICATION

Temperature:

minimum	55°F / 13°C
maximum	120°F / 49°C
	air, surface, and material
	At least 5°F / -15°C above dew point

Relative humidity: 85% maximum
The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.
Reducer: Water
In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with water.
Airless Spray:

Pressure	2000 p.s.i.
Hose	¼ inch I.D.
Tip	.013-.015 inch
Filter	60 mesh

Reduction: As needed up to 15% by volume
Brush: Nylon-polyester
Roller Cover: 3/8 inch woven
Reduction: As needed up to 15% by volume with water, 5-15% minimum reduction required for brush and roll.
If specific application equipment is listed above, equivalent equipment may be substituted.

Apply paint at the recommended film thickness and spreading rate as indicated. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material loss during mixing, spillage, over thinning, climatic conditions, and excessive film build.

Mix separate components thoroughly with low speed agitation before use. Make certain no pigment remains on the bottom of the can. Then combine 6 parts by volume of Part A with 1 part by volume of Part B. Mix thoroughly with low speed agitation. Reduce 5% - 15% by volume with water for brush and roll application. Re-stir before using. If reducer is used, add only after both components have been thoroughly mixed together. Do not apply the material beyond recommended pot life. Do not mix previously catalyzed material with new.

Stripe coat crevices, welds, and sharp angles to prevent early failure in these areas. When using spray equipment, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. Apply coating evenly while maintaining a wet edge to prevent lapping. If necessary, cross spray at a right angle.

SPECIFICATIONS

Steel:
1 coat Pro Industrial Pro-Cryl® Primer
or
1 coat Pro Industrial Kem Bond HS®
1-2 coats Pro Industrial Waterbased Acrolon 100

Steel:
1 Zinc Clad® IV
1-2 coats Pro Industrial Waterbased Acrolon 100

Steel:
1 Zinc Clad IV
1 coat Macropoxy® 646-100
1-2 coats Pro Industrial Waterbased Acrolon 100

Aluminum & Galvanizing:
1 coat Pro Industrial DTM Wash Primer
1-2 coats Pro Industrial Waterbased Acrolon 100

Concrete Block (CMU):
1 coat Pro Industrial Heavy Duty Block Filler
or Loxon® Acrylic Block Surfacer
1-2 coats Pro Industrial Waterbased Acrolon 100

Concrete (high performance):
1 coat Kem-Cati-Coat® HS Epoxy Filler-Sealer
or Cement-Plex® 875 WB Block Filler
1-2 coats Pro Industrial Waterbased Acrolon 100

Concrete and Masonry Smooth:
1 coat Loxon Concrete and Masonry Primer
1-2 coats Pro Industrial Waterbased Acrolon 100

Drywall:
1 coat ProMar® 200 Zero V.O.C. Primer
2 coats Pro Industrial Waterbased Acrolon 100

Drywall – Bare, Healthcare Cleanroom
1 coat ProMar 200 Zero V.O.C. Primer
2 coats Pro Industrial Water Based Catalyzed Epoxy
1 coat Pro Industrial Waterbased Acrolon 100

Drywall – Previously Coated, Healthcare Cleanroom
1 coat Extreme Bond® Interior-Exterior Bonding Primer
2 coats Pro Industrial Water Based Catalyzed Epoxy
1 coat Pro Industrial Waterbased Acrolon 100

Pre-Finished Siding: (Baked-on finishes)
1 coat Pro Industrial Bond-Plex® Waterbased Acrylic
1-2 coats Pro Industrial Waterbased Acrolon 100

The systems listed above are representative of the product's use, other systems may be appropriate.

continued on back

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Waterbased Urethane High Gloss

SURFACE PREPARATION

WARNING! If you scrape, sand or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a clean water rinse. Do not use hydrocarbon solvents for cleaning.

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Iron & Steel – Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. For better performance, use Near White Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum profile (2 mils / 50 microns). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

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

Galvanizing - Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1. When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP16 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2. Primer required.

Concrete Block - Surface should be thoroughly clean and dry. Air, material, and surface temperatures must be at least 50°F (10°C) before filling. Use Pro Industrial Heavy Duty Block Filler or Loxon Acrylic Block Surfacer. The filler must be thoroughly dry before topcoating.

Concrete and Masonry – For surface preparation, refer to SSPC-SP13/NACE 6. Or ICRI No. 310.2R, CSP 1-3. Surfaces should be thoroughly cleaned and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Surface temperature must be at least 55°F (13°C) before filling. Surface must be free of laitance, concrete dust, dirt and form release agents, moisture curing membranes, loose cement, and hardeners. Fill big holes, air pockets and other voids. Primer required.

Pre-Finished Siding: (Fluorocarbon, Silicone Polyester, and Polyester Polymers) – Remove oil, grease, dirt, oxides, and other contaminants from the surface by cleaning per SSPC-SP1 or water blasting per NACE Standard RP-01-72 (caution: excessive blasting pressure may cause warping, use caution). 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. Use recommended primer.

SURFACE PREPARATION

Mildew - Prior to attempting to remove mildew, it is always recommended to test any cleaner on a small, inconspicuous area prior to use. Bleach and bleaching type cleaners may damage or discolor existing paint films. Bleach alternative cleaning solutions may be advised.
Mildew may be removed before painting by washing with a solution of 1 part liquid bleach and 3 parts clean water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with clean water and allow the surface to dry before painting. Wear protective eyewear, waterproof gloves, and protective clothing. Quickly wash off any of the mixture that comes in contact with your skin. Do not add detergents or ammonia to the bleach-water solution.

PERFORMANCE

Extra White B65W00921/B65V00620
System Tested: (unless otherwise indicated)
Substrate: **Steel**
Surface Preparation: **SSPC-SP10**
Finish: 1 coat Pro Industrial Pro-Cryl Primer @ 3.0 mils D.F.T.
1 coat Pro Industrial Waterbased Acrolon 100 @ 4.0 mils D.F.T.
Dry Time: 7 day ambient cure

Abrasion Resistance:
Method: ASTM D4060
Result: 15.8 mg loss

Adhesion:
Method: ASTM D4541
Result: 1330 p.s.i.

Corrosion Weathering: 1000 Hours
Method: ASTM D5894
Result: Rating 10, per ASTM D714 for Blistering
Rating 10, per ASTM D1654 for corrosion

Salt Fog Resistance: 1000 Hours
Method: ASTM B117
Result: Rating 10, per ASTM D714 for Blistering
Rating 10, per ASTM D1654 for corrosion

Moisture Condensation Resistance: 1000 Hours
Method: ASTM D4585
Result: Rating 8, per ASTM D714 for Blistering
Rating 10, per ASTM D1654 for corrosion

Direct Impact Resistance:
Method: ASTM D2794
Result: 160 inch per pound

Flexibility:
Method: ASTM D522, 1/8 inch mandrel
Result: Pass

Pencil Hardness:
Method: ASTM D3363
Result: 6H

Dry Film Heat Resistance:
Method: ASTM D2485
Result: 250°F

Water Vapor Permeance (US):
Method: ASTM D1653
Result: 10.62 grains/(hr ft2 in Hg)

Chemical Resistance Rating:
Extra White B65W00921/B65V00620
(1-hour direct exposure to dry film, incidental contact)

5% Phosphoric Acid	Pass
10% Hydrochloric Acid	Pass
25% Sodium Hydroxide	Pass
50% Sulfuric Acid	Pass
Isopropyl Alcohol	Pass
Ammonia	Pass
Bleach Solution	Pass
Methanol	Pass
Mineral Spirits	Pass
Motor Oil	Pass
Vegetable Oil	Pass
Transmission Fluid	Pass
Salt Solution	Pass

SAFETY PRECAUTIONS

Before using, carefully read **CAUTIONS** on label.

Refer to the Safety Data Sheets (SDS) before use.

FOR PROFESSIONAL USE ONLY.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

CLEANUP INFORMATION

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

HOTW 11/06/2024 B65W00921/B65V00620 06 86