



TECHNICAL DATA SHEET

ACRYL-GLO ACRYLIC ENAMEL TOPCOAT

The ACRYL-GLO single-stage acrylic enamel paint system provides a durable finish that is easy to apply and suitable for both commercial and passenger vehicle refinishing work. This high-quality topcoat system is a popular choice, combining economic value with long lasting durability and ease of use. Available in 44 stock, pre-mixed, factory-packaged colors ranging from common solid fleet colors to brighter metallic and pearlescent combinations.

Designed to be used in a single-stage application with or without a hardener, or in combination with a urethane clearcoat for additional durability and gloss.

- ◆ National Rule Compliant
- ◆ Wide assortment of factory packaged colors
- ◆ Excellent flow and leveling
- ◆ Long-lasting enamel gloss

COATING TYPE:

Acrylic Enamel Topcoat (single-stage)

PRODUCT CODES:

KS Prefix

HARDENERS:

K-1606 Super Wet Look A/E Hardener
K1607 Wet Look A/E Hardener

REDUCERS:

R-7910/7920 (Fast)
R-7911/7921 (Medium)
R-7912/7922 (Slow)

WEIGHT PER GALLON:

Varies by color

PACKAGE MEASURE:

1 US Gallon / 128 fl. oz. / 3.785 Liters

RTS VOC:

Varies by color (will not exceed 5.0 lbs/gallon)

RTS Viscosity:

20-22 seconds, #2 Zahn cup

SUITABLE SUBSTRATES:

Black Diamond Low-VOC 2K Urethane Primer Surfacer
PERFECT PRIME 2K Urethane Primer Surfacer
RAPID PRIME 2K Urethane Primer Surfacer
DIRECT PRIME DTM 2K Urethane Primer Surfacer
ENDURO PRIME DTM Epoxy Primer Surfacer

Properly prepared, OE finishes and other fully cured automotive-grade primers may also be suitable.



SURFACE PREP

Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Abrade substrate with 600-800 grit, to ensure sufficient adhesion. Re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

ACRYL-GLO may also be applied "wet on wet," over certain freshly applied undercoats including Kirker's DIRECT PRIME, PERFECT Prime and RAPID Prime 2K Urethane Primer Surfacer after approximately 30 minutes flash time; or ENDURO PRIME DTM Epoxy Primer after 30-45 minutes flash. Be sure to mask all adjacent panels to prevent dry overspray.

COLOR

Please note that while every attempt for color consistency is made, there may be some difference in shade from one batch to the next. If using multiple cans of the same color for the same job, be sure to check for a common batch code before starting. This can be identified by the five-digit number marked either on the lid or face of the can. If batches are not the same, all materials should be blended prior to use to ensure color consistency.

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MIXING

Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts ACRYL-GLO Color with one (1) part of the appropriate Acrylic Enamel Reducer (R-7910/7920, R-7911/7921, R-7912/7922) depending on shop temperature and other conditions). Additional reduction may be necessary to improve flow and leveling.

BELOW 70°	70-80°	ABOVE 80°
FAST	MEDIUM	SLOW
R-7910 (gallon)	R-7911 (gallon)	R-7912 (gallon)
R-7920 (quart)	R-7921 (quart)	R-7922 (quart)

Though not required, it is highly recommended that one of Kirker's Acrylic Enamel Hardeners (K1606 Super Wet Look A/E Hardener or K-1607 Wet Look A/E Hardener) be used. The addition of a hardener will speed up the dry time, increase the gloss in the finished film and extend the durability of the acrylic enamel paint. One (1) pint (16 oz) of Hardener should be mixed with each gallon of Acrylic Enamel Paint and quart of Acrylic Enamel Reducer, resulting in an 8:2:1 mix ratio: 8 parts paint, 2 parts reducer, 1 part hardener. Caution: Mix only as much material as will be needed to complete the immediate job.

TO MIX	11 oz	22 oz	33 oz
A/E COLOR	8 oz	16 oz	24 oz
REDUCER	2 oz	4 oz	6 oz
HARDENER	1 oz	2 oz	3 oz

POT LIFE

Approximately two hours at 70°F.

Mix only as much material as is needed to complete the immediate job.

GUN SETTINGS

Always refer to gun manufacturer's recommendations for additional

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon	1.4-1.8 mm	50-60 psi
Conventional Gravity	1.4-1.6 mm	50-60 psi
HVLP	1.2-1.4 mm	8-10 psi

details on suggested tip size, air pressure and other adjustments.

APPLICATION

Apply ACRYL-GLO in two (2) to three (3) medium wet coats as necessary to achieve the desired coverage, allowing each coat to dry hand-slick before applying next coat. A dry film thickness of 2 mils is recommended.

When applying a low-hiding pearl or metallic color, choice of undercoat color becomes more important. Less pigment must be used in certain colors to maintain pearlescent and/or metallic effects. Those colors may require additional coats to achieve full coverage. In these situations, a uniform undercoat color, or even a solid color ground coat will significantly improve the appearance and hiding efficiency of ACRYL-GLO topcoats. When applying metallic colors in a single-stage application, consistent application technique is critical to prevent mottling. Uneven coats resulting in wet/dry areas will create the appearance of striping or spotting.

DRY TIMES

Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70-75°F.

	WITH HARDENER	WITHOUT HARDENER
Dust Free:	20 min.	1 hour
Tack Free:	1 hours	2 hours
Tape:	24 hours	1 week
Polish:	24-48 hours	1 month
Deliver:	24 hours	36 hours

FORCE DRY

ACRYL-GLO (with A/E Hardener) may be force dried after a 20-30 minute flash period. Bake for approximately 30 minutes at 140°F. After sufficient cool-down, acrylic enamel will be cured and may be taped, handled or polished. If clearcoating or recoating after the bake cycle, Acrylic Enamel surface must be scuff sanded with 600-800 grit to promote adhesion.

DO NOT force dry acrylic enamel in situations where no hardener was used.

RECOAT

ACRYL-GLO may be recoated for up to three (3) hours after the previous coat has dried hand-slick. After three hours (approximate, at 70-75°F), Acrylic Enamel paint enters a sensitive recoat window during which time it should not be topcoated. When an Acrylic Enamel Hardener is used, this No Recoat Window lasts about 24 hours. If no Hardener is used, paint should be allowed to set for about a week before recoating.

CAUTION: Recoating over Acrylic Enamel during this sensitive window may result in significant surface defects including, but not limited to, wrinkling, lifting, cracking, loss of gloss and soft paint film.

After recoat window has safely passed, ACRYL-GLO may be clearcoated or recoated, but only after the surface has first been abraded with 600-800 grit to promote adhesion.

POLISH

In single-stage applications when an acrylic enamel hardener is used, ACRYL-GLO may be polished after 24 to 48 hours. Start by sanding finish with 1500 grit or finer to abrade surface and / or remove dust nibs and other surface imperfections such as orange peel, then finish sand with 2000 grit or finer to remove all 1500-grit sand scratches.

Use a wool pad or foam pad in combination with a high-quality finishing compound, following material manufacturer's instructions. Follow with a high-quality finishing glaze applied either by hand, or variable-speed buffer.

When no hardener is used, ACRYL-GLO should not be buffed for at least one month.

CLEANUP

Close all containers tightly after each use. Clean gun and spray equipment with Kirker's VOC Compliant Gun Wash (670) or other appropriate solvent products immediately after application to prevent damage.

HEALTH / SAFETY

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY. READ ALL WARNINGS ON ALL LABELS BEFORE USING.

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Safety Data Sheet for additional health and safety information.

WARRANTY

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

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