



Tech Data

Excel Acrylic Enamel

Excel Acrylic Enamel is a quick dry, good hiding, high gloss factory pack line of many popular colors. Various OEM colors are available. Ideal for overall application.

Application

Surface Preparation

For dry sanding, a final sanding step of P500-P600 grit is recommended using a maximum 100 grit step difference or less throughout the taken sanding steps. For wet sanding, a final sanding step of P800-P1000 grit is recommended using a maximum of 200 grit step difference or less throughout the sanding steps. Clean area with a good grade wax and grease remover such as Excel 910 and wipe dry with a clean cloth. Wipe area with tack cloth to remove any dust or dirt particles.

Mixing Directions

Excel Acrylic Enamel can be used as an air dry finish or can be used with an activator for improved gloss, hardness, and improved long term weatherability.

Mix Ratio

- 8 Parts - Acrylic Enamel
- 2 Parts - Reducer Excel #151, 152, 153
- 1 Part - Wet Look Hardener Excel #200 (Optional)

Spray Gun

<u>Set-up Spray Gun:</u>	<u>Fluid tip:</u>	<u>Application pressure:</u>
Gravity feed	1.3-1.5mm	30 PSI at the spray gun air inlet
Gravity feed HVLP	1.3-1.5mm	10 PSI max at air cap
Siphon feed	1.6-1.8mm	40-50 PSI

Application

Apply 2 - 4 single coats or until full coverage is achieved. Apply smooth even coats not to exceed 5 mils wet, as wrinkling (loss of gloss) and slowing of dry may occur from excessive one coat thickness.

Drying Schedule

- Tack Free: 15 to 20 minutes at 70°F.
- To Recoat: 4 to 6 hours at 70°F
- To Dry Hard: 8 to 16 at 70°F

For best results, application of additional coats should take place within 24 hours. Prolonged delays may require cleaning and roughening of the undercoat to ensure optimum inter-coat adhesion. This can fluctuate depending on temperature, film thickness, and drying conditions. Test a small area first.

Cleaning of Equipment

Clean equipment immediately with lacquer thinner.

Technical Data

Mixing Ratio	8:2:1 by vol.
Pot life	6 to 12 hours
Viscosity @ Gun	13 - 15 sec #4 Zahn
Recommended Film Thickness	Approx. 1.5 to 2.0 mil
Flash Point	45°F TCC
Air Pressure @ Gun	30 PSI gravity feed, 10 PSI max at cap HVLP, 40-50 PSI siphon feed
Volume Solids:	36% packaged
Coverage @ 1 mil	580 sq ft/g