**Product Information**

**Product Description**

ACROLAN 218 HS is a low VOC, polyester modified, aliphatic, acrylic polyurethane formulated specifically for in-shop applications. Also suitable for industrial applications. A fast drying, urethane that provides color and gloss retention for exterior exposure.

- Can be used directly over organic zinc rich primers (epoxy zinc primer and moisture cure urethane zinc primer)
- Color and gloss retention for exterior exposure
- Fast dry
- Outstanding application properties

**Product Characteristics**

| Finish: | Gloss or Semi-Gloss |
| Color: | Wide range of colors available |
| Volume Solids: | 65% ± 2%, mixed, may vary by color |
| Weight Solids: | 78% ± 2%, mixed, may vary by color |
| VOC (EPA Method 24): | Mixed Reduced 10% with R7K15: <340 g/L; 2.8 lb/gal |
| Mix Ratio: | 6:1 by volume, 1 gallon or 5 gallon mixes |

**Recommended Uses**

Specifically formulated for in-shop applications. For use over prepared metal and masonry surfaces in industrial environments such as:

- Structural steel
- Rail cars and locomotives
- Conveyors
- Bridges
- Wind Towers - onshore and offshore
- Offshore platforms - exploration and production
- Suitable for use in USDA inspected facilities
- Conforms to AWWA D102 Outside Coating Systems #4 (OCS-4), #5 (OCS-5) & #6 (OCS-6)
- Acceptable for use in high performance architectural applications
- A component of INFINITANK

**Performance Characteristics**

| Substrate*: Steel |
| Surface Preparation*: SSPC-SP10/NACE 2 |
| System Tested*: |
| 1 ct. Macropoxy 646 @ 6.0 mils (150 microns) dft |
| 1 ct. Acrolon 218 HS Gloss @ 4.0 mils (100 microns) dft |

*unless otherwise noted below

**Footnotes:**

- 1 Finish coat only tested
- 2 Primer: Zino-Clad II Plus
- Intermediate: Macropoxy 646
- Finish: Acrolon 218 HS

Meets the requirements of SSPC Paint No. 36, Level 3 for white and light colors. Dark colors may require a clear coat.

Complies with ISO 12944-5 C5I and C5M requirements.

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ACROLON™ 218 HS
ACRYLIC POLYURETHANE

PART A B65-600 GLOSS SERIES
PART A B65-650 SEMI-GLOSS SERIES
PART B B65V600 HARDENER

PRODUCT INFORMATION

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. Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:
* Galvanizing: SSPC-Sp1
* Concrete & Masonry: SSPC-SP13/NACE 6, or ICRI No. 310.2, CSP 1-3
* Primer required

TINTING
Tint Part A with Maxitoner Colorants.
* Extra white tints at 100% tint strength
* Ultradeep base tints at 150% tint strength
Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

APPLICATION CONDITIONS
Temperature: 35°F (1.7°C) minimum, 120°F (49°C) maximum (air and surface)
40°F (4.5°C) minimum, 120°F (49°C) maximum (material)
At least 5°F (2.8°C) above dew point
Relative humidity: 85% maximum
Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION
Packaging: 1 gallon (3.78L) mix: 5 gallon (18.9L) mix:
Part A: .86 gal (3.25L) 4.29 gal (16.2L)
Part B: .14 gal (0.53L) 0.71 gal (2.7L)
(premeasured components)
Weight: 11.2 ± 0.2 lb/gal ; 1.3 Kg/L mixed, may vary with color

SAFETY PRECAUTIONS
Refer to the MSDS sheet before use.
Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

DISCLAIMER
The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

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

SHERWIN WILLIAMS
www.sherwin-williams.com/protective
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.

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 Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (1-2 mils / 25-50 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 by Solvent Cleaning per SSPC-SP1. Primer required.

Galvanized Steel
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-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned or before flash rusting occurs. Primer required.

Concrete and Masonry
For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910. Primer required.

Follow the standard methods listed below when applicable:
ASTM D4258 Standard Practice for Cleaning Concrete.
ASTM D4259 Standard Practice for Abrading Concrete.
ASTM D4260 Standard Practice for Etching Concrete.
ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.
SSPC-SP 13/Nace 6 Surface Preparation of Concrete. ICRI No. 310.2 Concrete Surface Preparation.

Application Details

**Surface Preparation Standards**

<table>
<thead>
<tr>
<th>Condition of Surface</th>
<th>ISO 8501:1</th>
<th>Swedish Std.</th>
<th>SSPC</th>
<th>NACE</th>
</tr>
</thead>
<tbody>
<tr>
<td>White Metal</td>
<td>Sa 3</td>
<td>Sa 3</td>
<td>SP 5</td>
<td>2</td>
</tr>
<tr>
<td>Near White Metal</td>
<td>Sa 2.5</td>
<td>Sa 2.5</td>
<td>SP 10</td>
<td>2</td>
</tr>
<tr>
<td>Commercial Blast</td>
<td>Sa 2</td>
<td>Sa 2</td>
<td>SP 1</td>
<td>3</td>
</tr>
<tr>
<td>Brush-Off Blast</td>
<td>Sa 1</td>
<td>Sa 1</td>
<td>SP 7</td>
<td>4</td>
</tr>
<tr>
<td>Hand Tool Cleaning</td>
<td>Rusted</td>
<td>Rusted</td>
<td>D St 2</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Rusted</td>
<td>Rusted</td>
<td>D St 2</td>
<td></td>
</tr>
<tr>
<td>Power Tool Cleaning</td>
<td>Rusted</td>
<td>Rusted</td>
<td>D St 3</td>
<td></td>
</tr>
</tbody>
</table>

**Application Conditions**

<table>
<thead>
<tr>
<th>Temperature:</th>
<th>35°F (1.7°C) minimum, 120°F (49°C) maximum (air and surface)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Relative humidity:</td>
<td>85% maximum</td>
</tr>
</tbody>
</table>

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 compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

**Reducer/Clean Up:**
- Spray: Reducer R7K15, MEK R6K10, or R7K111
- Brush/Roll: Reducer #132, R7K132, or R7K111

If reducer is used, reduce at time of catalyzation.

**Application Equipment**

- **Airless Spray**
  - Pressure: 2500 - 2800 psi
  - Hose: 3/8” ID
  - Tip: .013” - .017”
  - Filter: 60 mesh
  - Reduction: As needed up to 10% by volume with R7K15 or R7K111, or up to 9% with MEK, R6K10

- **Conventional Spray**
  - Gun: Binks 95
  - Cap: 63P
  - Atomization Pressure: 50 - 70 psi
  - Fluid Pressure: 20 - 25 psi
  - Reduction: As needed up to 10% by volume with R7K15 or R7K111, or up to 9% with MEK, R6K10

- **Brush**
  - Natural Bristle
  - Reduction: As needed up to 10% by volume

- **Roller**
  - Cover: 3/8” woven with solvent resistant core
  - Reduction: As needed up to 10% by volume

If specific application equipment is not listed above, equivalent equipment may be substituted.

*Note: Reducing more than maximum recommended level will result in VOC exceeding 340g/L
Surface preparation must be completed as indicated. Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine six parts by volume of Part A with one part by volume of Part B (premeasured components). Thoroughly agitate the mixture with power agitation. Re-stir before using.

If reducer is used, add only after both components have been thoroughly mixed.

Apply paint at the recommended film thickness and spreading rate as indicated below:

<table>
<thead>
<tr>
<th>Recommended Spreading Rate per coat:</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet mils (microns)</td>
<td>4.5 (112.5)</td>
<td>9.0 (225)</td>
</tr>
<tr>
<td>Dry mils (microns)</td>
<td>3.0 (75)</td>
<td>6.0 (150)</td>
</tr>
<tr>
<td>Coverage sq ft/gal (m²/L)</td>
<td>175 (4.3)</td>
<td>346 (8.5)</td>
</tr>
<tr>
<td>Theoretical coverage sq ft/gal (m²/L)</td>
<td>1040 (25.5)</td>
<td></td>
</tr>
</tbody>
</table>

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 6.0 mils wet (150 microns):

- @ 35°F/1.7°C  @ 77°F/25°C  @ 120°F/49°C
- 50% RH
- To touch: 4 hours 30 minutes 20 minutes
- To handle: 18 hours 6 hours 4 hours
- To recoat: minimum: 18 hours 8 hours 6 hours
- maximum: 3 months 3 months 3 months
- To cure: 14 days 7 days 5 days
- Pot Life: 4 hours 2 hours 45 minutes
- (reduced 5% with Reducer R7K15)
- Sweat-in-Time: None
- If maximum recoat time is exceeded, abrade surface before recoating.
- Drying time is temperature, humidity, and film thickness dependent.
- Paint temperature must be at least 40°F (4.5°C) minimum.

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

Clean spills and spatters immediately with Reducer #132, R7K132. Clean tools immediately after use with Reducer #132, R7K132. Follow manufacturer's safety recommendations when using any solvent.

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