

*Industrial
and
Marine
Coatings*

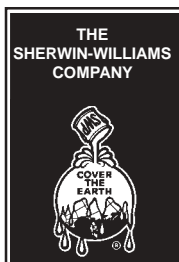


DTM ACRYLIC COATING

B66-100 SERIES
B66-200 SERIES

GLOSS
SEMI-GLOSS

INDUSTRIAL & MARINE COATINGS		PRODUCT INFORMATION		Revised 8/02																				
PRODUCT DESCRIPTION		RECOMMENDED USES																						
<p>DTM ACRYLIC COATING is a 100% acrylic, water reducible, corrosion resistant coating for light to moderate industrial use. Designed for new construction or maintenance use and can be used directly over prepared substrates.</p> <ul style="list-style-type: none"> • Chemical resistant • Fast dry • Flash rust/early rust resistant • Suitable for use in USDA inspected facilities • Interior/exterior use • Corrosion resistant • Low odor 		<p>For use over prepared:</p> <ul style="list-style-type: none"> • Steel • Aluminum • Zinc rich primers • Galvanizing • Concrete • Wood • Masonry • Drywall <p>Examples:</p> <ul style="list-style-type: none"> • Buildings • Machinery • Power plants • Select Marine Structures • Storage Tanks • Equipment • Piping • Water treatment plants • New Construction • Structural Steel 																						
PRODUCT CHARACTERISTICS		PERFORMANCE CHARACTERISTICS																						
<p>Finish: Gloss or Semi-Gloss</p> <p>Color: Wide range of colors including safety colors</p> <p>Volume Solids: 38% ± 2%, may vary by color Ultra White</p> <p>Weight Solids: 50% ± 2%, may vary by color Ultra White</p> <p>VOC (EPA Method 24): 208 g/L; 1.73 lb/gal Extra White</p> <p>Recommended Spreading Rate per coat:</p> <p>Wet mils: 6.5 - 10.0 Dry mils: 2.5 - 4.0 Coverage: 155 - 250 sq ft/gal approximate</p> <p>NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.</p> <p>Drying Schedule @ 8.0 mils wet 50% RH:</p> <table border="1"> <thead> <tr> <th></th> <th>@ 50°F</th> <th>@ 77°F</th> <th>@ 110°F</th> </tr> </thead> <tbody> <tr> <td>To touch:</td> <td>1½ hours</td> <td>1 hour</td> <td>30 minutes</td> </tr> <tr> <td>Tack free:</td> <td>6 hours</td> <td>4 hours</td> <td>2 hours</td> </tr> <tr> <td>To recoat:</td> <td>6 hours</td> <td>4 hours</td> <td>2 hours</td> </tr> <tr> <td>To cure:</td> <td>30 days</td> <td>30 days</td> <td>30 days</td> </tr> </tbody> </table> <p>Drying time is temperature, humidity, and film thickness dependent.</p> <p>Shelf Life: 36 months, unopened, at 77°F</p> <p>Flash Point: >200°F, PMCC</p> <p>Reducer/Clean Up: Water</p>			@ 50°F	@ 77°F	@ 110°F	To touch:	1½ hours	1 hour	30 minutes	Tack free:	6 hours	4 hours	2 hours	To recoat:	6 hours	4 hours	2 hours	To cure:	30 days	30 days	30 days	<p>System Tested: (unless otherwise indicated) Substrate: Steel Surface Preparation: SSPC-SP10 2 cts. DTM Acrylic Coating @ 3 mils dft/ct</p> <p>Abrasion Resistance: Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load Result: 107 mg loss</p> <p>Accelerated Weathering: Method: ASTM D4587, QUV-A, 5,000 hours Results: passes</p> <p>Adhesion: Method: ASTM D4541 Result: >500 psi</p> <p>Corrosion Weathering: Method: ASTM D5894, 15 cycles, 5,040 hours Result: Rating 10 per ASTM D714 for blistering Rating 9 per ASTM D610 for rusting</p> <p>Direct Impact Resistance: Method: ASTM D2794 Result: >160 in. lbs</p> <p>Dry Heat Resistance: Method: ASTM D2485 Result: 300°F</p> <p>Exterior Durability: Method: 1 year, 45° South Result: Excellent</p> <p>Flexibility: Method: ASTM D522, 180° bend, 1/8" mandrel Result: Passes</p> <p>Moisture Condensation Resistance: Method: ASTM D4585, 100°F, 300 hours Result: Passes</p> <p>Pencil Hardness: Method: ASTM D3363 Result: 2B</p> <p>Salt Fog Resistance: Method: ASTM B117, 500 hours Result: Excellent</p> <p>Flame Spread Rating: Method: ASTM E84-91a Result: Flame Spread Index - 5 Smoke Density Index - 0</p> <p>Provides performance comparable to products formulated to federal specification: Mil-P-28578B, TT-P-1511B, and Paint Specification: SSPC-Paint 23.</p>		
	@ 50°F	@ 77°F	@ 110°F																					
To touch:	1½ hours	1 hour	30 minutes																					
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PRODUCT INFORMATION

RECOMMENDED SYSTEMS

Steel:

- 1 ct. DTM Acrylic Primer/Finish @ 2.5 - 5.0 mils dft
- or Kem Bond HS @ 2.0 - 5.0 mils dft
- or Zinc Clad Primer @ 3.0 - 5.0 mils dft
- or ProCryl Primer @ 2.0 - 4.0 mils dft
- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Steel:

- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct
(Application of coating on unprimed bare steel may cause pinpoint rusting.)

Aluminum:

- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Aluminum:

- 1 ct. DTM Wash Primer, @ 0.7 - 1.3 mils dft
- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Galvanizing:

- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Concrete Block:

- 1 ct. Heavy Duty Block Filler @ 10.0 - 18.0 mils dft
- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Concrete/Masonry:

- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Drywall:

- 1 ct. PrepRite 200 Latex Primer @ 1.0 - 1.5 mils dft
- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Prefinished Siding: (Baked-on finishes)

- 1 ct. DTM Bonding Primer @ 2.0 - 5.0 mils dft
- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Wood, exterior:

- 1 ct. A-100 Exterior Oil Wood Primer @ 1.5 mils dft
- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Wood, interior:

- 1 ct. PrepRite Wall & Wood Primer @ 1.5 mils dft
- 2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Safety Colors, Deep Base, and Ultradeep colors require a prime coat of DTM Acrylic Primer/Finish, B66W1, for maximum durability, adhesion, and corrosion protection.

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

SURFACE PREPARATION

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.

Do not use hydrocarbon solvents for cleaning.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

- * Iron & Steel: SSPC-SP2
- Aluminum: SSPC-SP1
- Galvanizing: SSPC-SP1
- Concrete & Masonry: SSPC-SP13/NACE 6
- * Wood: Dry and sanded smooth
- * Primer required. When using Pure White or Ultra White on metal, no primer is required.

TINTING

Tint with Blend-A-Color Toner or EnviroToner at 100% tint strength, using the respective tinting formula pages. Better performance will be achieved with EnviroToners. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

Tinting can affect the flash/early rust resistance of the coating.

APPLICATION CONDITIONS

- Temperature: 50°F minimum, 110°F maximum
(air, surface, and material)
At least 5°F above dew point
- Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

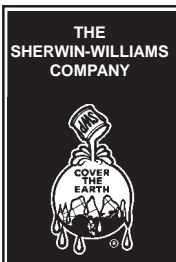
ORDERING INFORMATION

- Packaging: 1 and 5 gallon containers
- Weight per gallon: 10.2 ± 0.2 lb, may vary by color

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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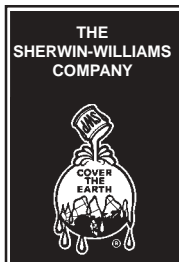


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INDUSTRIAL & MARINE COATINGS	APPLICATION BULLETIN		Revised 8/02
SURFACE PREPARATION	APPLICATION CONDITIONS		
<p>Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.</p> <p>Do not use hydrocarbon solvents for cleaning.</p> <p>Iron & Steel Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Steam Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6. Primer required except when using Pure White or Ultra White.</p> <p>Aluminum Remove all oil and grease by Steam Cleaning per SSPC-SP1. Self-priming.</p> <p>Galvanizing The surface should be weathered for 6 months prior to painting. Remove all oil and grease by Steam Cleaning per SSPC-SP1. Self-priming.</p> <p>Concrete and Masonry For surface preparation, refer to SSPC-SP13/NACE 6. Surfaces should be thoroughly cleaned and dry. Surface temperatures must be at least 55°F before filling. Use Heavy Duty Block Filler. Filler must be thoroughly dry before topcoating per manufacturer's recommendations.</p> <p>Wood Surface must be clean, dry and sound. Prime with recommended primer. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped, sanded and spot primed before full coat of primer is applied. All nail holes or small openings must be properly caulked.</p> <p>Previously Painted Surfaces If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.</p>	<p>Temperature: 50°F minimum, 110°F maximum (air, surface, and material) At least 5°F above dew point</p> <p>Relative humidity: 85% maximum</p>		
	APPLICATION EQUIPMENT		
	<p>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 existing environmental and application conditions.</p> <p>Reducer/Clean Up Water</p> <p>Airless Spray</p> <p>Pressure 1500 psi Hose 1/4" ID Tip017" - .021" Filter 60 mesh Reduction As needed up to 12½% by volume</p> <p>Conventional Spray</p> <p>Gun Binks 95 Fluid Nozzle 66 Air Nozzle 63PB Atomization Pressure ... 50 psi Fluid Pressure 15-20 psi Reduction As needed up to 12½% by volume</p> <p>Brush</p> <p>Brush Nylon / polyester Reduction Not recommended</p> <p>Roller</p> <p>Cover 3/8" woven with phenolic core Reduction Not recommended</p> <p>If specific application equipment is listed above, equivalent equipment may be substituted.</p>		



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APPLICATION BULLETIN

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mixing Instructions: Mix paint thoroughly by boxing and stirring before use.

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

Recommended Spreading Rate per coat:

Wet mils:	6.5 - 10.0
Dry mils:	2.5 - 4.0
Coverage:	155 - 250 sq ft/gal approximate

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

Drying Schedule @ 8.0 mils wet 50% RH:

	@ 50°F	@ 77°F	@ 110°F
To touch:	1½ hours	1 hour	30 minutes
Tack free:	6 hours	4 hours	2 hours
To recoat:	6 hours	4 hours	2 hours
To cure:	30 days	30 days	30 days

Drying time is temperature, humidity, and film thickness dependent.

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

PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. If possible, plan painting schedules to avoid these influences during the first 16-24 hours of curing.

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 lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Safety Colors, Deep Base, and Ultradeep colors require a prime coat of DTM Acrylic Primer/Finish, B66W1, for maximum durability, adhesion, and corrosion protection.

Application temperature above 95°F may cause dry spray, uneven sheen, and poor adhesion.

Application temperature below 50°F may cause poor adhesion and lengthen the drying and curing time.

DTM Acrylic Coating is extremely sensitive to hydrocarbon containing solvents. When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent followed by a water rinse.

Do not use hydrocarbon solvents for cleaning.

Refer to Product Information sheet for additional performance characteristics and properties.

CLEAN UP INSTRUCTIONS

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

NOTE: If coating is allowed to "set-up", Reducer #54, R7K54, may be required for cleaning. Follow manufacturer's safety recommendations when using Reducer #54.

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