

ACRYL-GLO

Acrylic Enamel Topcoat



TECHNICAL DATA SHEET

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 refinish 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
- Excellent flow and leveling
- Good economic value
- Fast drying
- Good gloss retention and color holdout

COATING TYPE:

Acrylic Enamel Paint (Single-stage)

PRODUCT CODE:

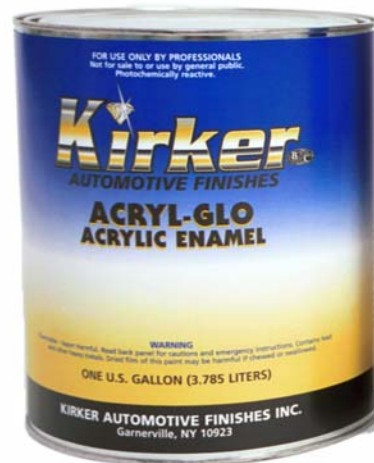
"KS" prefix; Factory-pack colors (see color chart)

HARDENERS:

K-1606 – Super Wet Look A/E Hardener
K-1607 – Wet Look A/E Hardener

REDUCERS:

R-7910 / R-7920 – Fast (Less than 65° F)
R-7911 / R-7921 – Medium (Between 65° - 80° F)
R-7912 / R-7922 – Slow (Above 85° F)
UE-8000 – Universal VOC-Exempt Reducer



PHYSICALS:

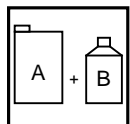
Appearance:	Paint (color varies)
Weight per Gallon:	Varies with color
Package Measure:	1 U.S. gallon / 128 fl. oz. (3.785 liters)
RTS VOC:	Maximum VOC of 5.0 lbs/gallon



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 cleaner (such as Kirker's 600 Surface Wash).

ACRYL-GLO may be applied "wet on wet," over certain freshly applied undercoats including Kirker's PERFECT Prime (2K urethane primer surfacer – overall) and RAPID Prime (Kirker's 2K urethane primer surfacer – spot/panel) after approximately 30 minutes flash time; or ENDURO Prime (Kirker's 2-part epoxy primer) after 30-45 minutes flash. Be sure to mask all adjacent panels to prevent dry overspray.



MIXING:

Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts ACRYL-GLO color with at least one (1) part of the appropriate Reducer (R-7910, R-7911 or R-7912), depending on air flow and shop temperatures.

Temperature range	Less than 70° F	Between 70° F - 80° F	More than 80° F
Reducer (Gallon)	R-7910	R-7911	R-7912
Reducer (Quart)	R-7920	R-7921	R-7922
Speed	Fast	Medium	Slow

Additional reduction may be required to improve flow and leveling. Use one of Kirker's acrylic enamel reducers (R-7910 / R-7920, R-7911 / R-7921 or R-7912 / R-7922), depending on shop temperature, or Universal Zero-V.O.C. Reducer, UE-8000. WARNING: With further reduction beyond the recommended 4:1 mix ratio, ACRYL-GLO may no longer be VOC compliant for your area. Using UE-8000 will not increase the VOC. Caution: Mix only as much material as you will need to complete the immediate job.

4:1

WITHOUT HARDENER:

KS Color	4oz	12 oz.	20 oz.	28 oz.
Acrylic Enamel Reducer	1 oz.	3 oz.	5 oz.	7 oz.
TOTAL MIXTURE	5 oz.	15 oz.	25 oz.	35 oz.

Though not required, it is highly recommended that one of Kirker's acrylic enamel hardeners (K-1606 Super Wet Look A/E Hardener or K-1607 Wet Look A/E Hardener) be used. The use of a hardener will speed the dry time, increase gloss in the finished film and extend the durability of the acrylic enamel paint job. One (1) pint (16 oz.) of hardner 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 you will need to complete the immediate job.

8:2:1

WITH HARDENER:

KS Color	4oz	8 oz.	16 oz.	24 oz.
Acrylic Enamel Reducer	1 oz.	2 oz.	4 oz.	6 oz.
Acrylic Enamel Hardener	½ oz.	1 oz.	2 oz.	3 oz.
TOTAL MIXTURE	5.5 oz.	11 oz.	22 oz.	33 oz.

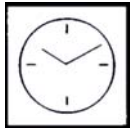
ACRYL-GLO paints may also be mixed with Kirker's LAZER DRY Basecoat Stabilizer, which converts the acrylic enamel enabling it to be used in a basecoat / clearcoat combination. LDS cuts the recoat time while flattening the finish and immobilizing any aluminum flake that may be present in metallic colors, making it much simpler to apply those products in a uniform pattern without mottling.

When using LAZER DRY, no additional reduction is required, though an acrylic enamel hardener must be used in a 4:4:1 mix ratio, or, for every one (1) gallon of acrylic enamel paint, add one (1) gallon of LAZER DRY Basecoat Stabilizer and two (2) pints of acrylic enamel hardener (either K-1606 or K-1607). Caution: Mix only as much material as you need to complete the immediate job.

AS A BASECOAT:

4:4:1

KS Color	4oz	8 oz.	12 oz.	16 oz.
LAZER DRY	4 oz.	8 oz.	12 oz.	16 oz.
Acrylic Enamel Hardener	1 oz.	2 oz.	3 oz.	4 oz.
TOTAL MIXTURE	9 oz.	18 oz.	27 oz.	36 oz.



POT LIFE:

Approximately 3 hours at 70°F

Caution: Pot life is significantly shorter at elevated temperatures and in humid conditions. These environmental factors also may affect flow and leveling during the application process.



GUN SETTINGS:

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon Feed:	1.4 mm – 1.8mm	50-60 psi at the gun
Conventional Gravity Feed:	1.4 mm – 1.6 mm	50-60 psi at the gun
HVLP	1.2 mm – 1.4 mm	8-10 psi at the tip

Always refer to gun manufacturer's recommendations for additional 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:

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

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

FORCE DRY:

ACRYL-GLO (with a hardener) may be force dried after 20-30 minute flash period, 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, acrylic enamel must first be scuff sanded with 600-800 grit to promote sufficient adhesion.

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

**CLEANUP:**

Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

Shelf life of K-1606 and K-1607 acrylic enamel hardeners is limited once cans have been opened. These products are extremely susceptible to oxygenation and exposure to moisture. Therefore, containers should be closed tightly after each use, with a clean seal, as quickly as possible. Also, activators should be stored at a consistent temperature to prevent the formation of potentially damaging condensation inside of the can.

**RECOAT WINDOW:**

ACRYL-GLO may be recoated for up to three (3) hours (at 70° - 75°F), after the previous coat has dried hand-slick. After three hours, Acrylic enamel paint enters a sensitive period, during which time it should not be recoated. When an acrylic enamel hardener is used, this "No Recoat Window" lasts until 24 hours after application. If no hardener is used, this sensitive recoat window may extend for one week.

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

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

**HEALTH / SAFETY PRECAUTIONS:**

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted fresh-air-supplied NIOSH/MSHA-approved respirator (TC-19C or equivalent) as directed by the manufacturer. Protect hands with impervious nitrile gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. 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 Material 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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