



# Product Data

## Zinc Modified Conversion Coat Primer ACWP Series

**Description:** **ACWP Series** is a water-borne three component organic zinc rich modified polyurethane primer that meets the properties of conventional chromate conversion coating products. Formulated for use in the industrial OEM and aviation market for Type II (non-hexavalent chromium coatings), Class 1A & Class 3. Primary features include excellent adhesion to aluminum and steel substrates, corrosion resistance, water resistance and rapid recoat ability. Salt fog results of 2,000+ hours can be achieved with a 2 mil D.F.T.

**Recommended Uses:** A general purpose zinc primer for use over structural aluminum, stainless steel, aviation parts and blasted steel. This primer is recommended for industrial applications such as railcars, water and waste treatment plants, petrochemical and offshore oil production. Other uses include commercial applications where a durable, corrosion resistant finish is a primary requirement.

### PHYSICAL CONSTANTS

*(Subject to normal manufacturing tolerances)*

**Finish:** Flat

**Color / Shade:** Available in 3 colors: Coral (ACWP-500)      Gray (ACWP-700)      Green (ACWP-200)

**Components:** 3 (three)

**Mixing Ratio:** 3:1:1 Base to Activator to Zinc

**Volume Solids:** 47% / US Gallon **mixed** (depending on color)

	To Touch	Tack Free	Dry Hard	Fully Cured
<b>Dry Time @77° F. and 55% RH:</b>	30 - 45 minutes *	1 hour *	2 hours *	7 days *

\* Dry times may be significantly reduced with the utilization of plural component equipment and/or the reduction of the pot life.

**Theoretical Coverage:** 377 sq. ft. / US gallon @ 2 mils DFT (no loss)

**Recommended DFT:**                    **Industrial Applications:** 2.0 mils or according to specification  
   **Aircraft Applications:** 0.5 - 1 mil

**Shelf Life:** 9 months when stored indoors @ 75° F. (24° C.)

**Storage Temp:** 45° - 110° F. (7° - 43° C.)

**Clean Up:** Water

**VOC:** 0.598 lbs. / US gallon (depending on color)

**POT LIFE:** 45 minutes @ 70° - 80° F. @ 50% R.H.



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**Surface Preparation:** Remove all oil, grease and other contaminants by washing with solvent or surface cleaner/degreaser in accordance with SSPC-SP 1. Allow to dry prior to painting. Minimum Surface Preparation: Hand tool or power tool clean to remove all loose rust, paint, dirt, etc. in accordance with SSPC-SP 2. For optimum performance: Commercial blast with a 1 - 2 mil blast profile.

**Application Conditions:**

Surface Condition	Surface Temperature	Ambient Temperature	Humidity
Normal	60°-85° F (16°-29° C)	60°-90° F (16°-32° C)	0-80%
Minimum	45° F (2° C)	45° F (2° C)	0%
Maximum	110° F (52° C)	100° F (43° C)	90%

The surface must be dry at the time of application and the temperature must be above the dew point @ 55° - 100° F. @ 50% R.H. to avoid condensation. Minimum temperature for curing is 55° F.

**Application Equipment:** Plural Component spray is desired due to pot life. May also be applied with conventional and airless.

**Mixing Instructions:** Mix three (3) Parts A (color base) to one (1) Part B (activator). Stir thoroughly making sure no pigment remains on the bottom of the can and the color is uniform. While constantly stirring, add one (1) Part C (zinc) - mix thoroughly. Do not mix more material than will be used within pot life time.

**Thinning:** Not recommended.

<b>Packaging:</b>	<b>1 Gallon (4 gal./case) Pt A</b>	Approx. Shipping Weight:	46.00 lbs.
	<b>1 Gallon (4 gal./case) Pt B</b>	Approx. Shipping Weight:	54.00 lbs.
	<b>1 Gallon (4 gal./case) Pt C</b>	Approx. Shipping Weight:	39.00 lbs.

**Compatibility:** If unsure about the compatibility of this product with other commodities, please contact an Excalibur technical service representative at 877-392-2542.

### PRECAUTIONS

\*\*\*\*\* SAFETY \*\*\*\*\* Packings are provided with applicable safety labels which should be observed. In addition, national and local regulations should be followed.

As a general rule, inhalation of solvent vapors or paint mist and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory skin and eye protection are always recommended when painting. See complete Material & Safety Data Sheets for detailed health hazards and safety information.

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