

# Product Data

## Excala - Cryl Acrylic Enamel AE Series

**Description:** **AE Series** acrylic polyurethane enamel is a high quality, low VOC, single stage acrylic enamel topcoat formulated as a high quality OEM or maintenance finish. It exhibits extremely high gloss and depth of image while providing a durable, rust inhibitive finish that can be air or force dried. This durable and versatile coating is user friendly and offers protection against weather, moisture, petroleum solvents and mild industrial fumes. Unlike a normal maintenance enamels, ultraviolet light (sunlight) either reflects off the surface or penetrates through without causing damage to the paint film providing good gloss retention and resistance to chalking.

**Recommended Uses:** Formulated as an economical industrial OEM or maintenance finish for drilling rigs, farm & ranch, implements, machinery and equipment.

### PHYSICAL CONSTANTS *(Subject to normal manufacturing tolerances)*

**Finish:** High Gloss - 92+  
**Color / Shade:** Variety of Colors  
**Components:** One  
**Mixing Ratio:** N/A  
**Volume Solids:** 37% / US gallon (depending on color)

Dry Time @77° F. and 55% RH:	To Touch	Tack Free	Dry Hard	Fully Cured	Recoat
	30-45 minutes	1-2 hours	8 hours	24 hours	Less than 4 hours or greater than 24 hours

**Theoretical Coverage:** 237 sq. ft. / US gallon @ 2½ mils DFT (no loss)

**Recommended DFT:** 2 - 3 mils or according to specification

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

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

**Clean Up:** Excalibur R-030 reducer.

**VOC:** 3.34 lbs. / US gallon (depending on color)



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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 Heavy Duty Industrial Use** abrasive blast to a near white finish in accordance with SSPC-SP 10 and obtain a 1.5 - 3 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	35° F (2° C)	35° F (2° C)	0%
Maximum	125° F (52° C)	110° F (43° C)	90%

Surface temperature **MUST** be 5° above the dew point to avoid condensation which can cause flash rusting and interfere with adhesion.

**Recommended Primers:** [Excalibur PIU-101](#) single component phenolic or [Excalibur ProPoxy](#) epoxy primer.

**Application Equipment:** Conventional • Airless/air assisted airless • Brush (touch-up only)

**Mixing Instructions:** Stir thoroughly making sure no pigment remains on the bottom of the can and the color is uniform.

**Thinning:** Excalibur's R-025 (Fast), R-030 (Medium) or R-035 (Slow), depending on temperature.

<b>Packaging:</b>	<b>1 Gallon (4 gal./case)</b>	Approx. Shipping Weight:	38.00 lbs./cs.
	<b>5 Gallon</b>	Approx. Shipping Weight:	45.00 lbs./ea.
	<b>55 Gallon Drum</b>	Approx. Shipping Weight:	535.00 lbs./ea.

**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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