SANCRYL 300

ACRYLIC ENAMEL COATING: AIR DRY OR HEAT CURE

SERIES A300

SINGLE-COMPONENT, UV-RESISTANT

SANDSTROM PRODUCTS COMPANY

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DESCRIPTION

Sancryl 300 is a tough, durable acrylic enamel with excellent resistance to UV degradation.

OUTSTANDING FEATURES/BENEFITS

- Excellent exterior durability
- Good flexibility
- Low gloss with no reflective glare

TYPICAL USES

Sancryl 300 is designed for use as a coating for signs, scoreboards, instrument panels and other exterior and interior applications over aluminum, primed steel and most plastics. Use where long life and protection from UV damage is important. For best results outdoors, prime the surface with Sandstrom Aqua-Poxy 914.

NOTICE

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet (MSDS), and Technical Data Sheet.

LIMITATIONS

- **DO NOT** apply at temperatures below 50°F.
- Applying at temperatures below 60°F and humidity levels above 70% will result in greatly prolonged drying and curing times and may affect appearance and/or performance. Curing for 10 minutes at 140°F to 180°F is recommended for faster handling and optimum cure.
- Protect from rain for at least 24 hours after curing.
- Aluminum needs to be primed with 0.3 to 0.5 mils of Aqua-Poxy 914 primer for maximum durability.
- Steel must be primed with Aqua-Poxy 914 for corrosion resistance (2+ mils).

COMPOSITION AND PHYSICAL PROPERTIES

Net Weight per gallon* *ASTM D1475*	9.6 – 11.7 lbs.	**Vehicle**	Acrylic
Weight Solids*	51 – 61%	**Color**	Black, White, & Gray Custom color upon request
Volume Solids*	41 – 47% (Theoretical)	**Finish**	Flat
VOC - water	1 - 1.2 lbs./gallon (145 g/L) (Theoretical)	**Gloss** *ASTM D523*	2 – 7 (60° meter)
Odor	Alcohol/Ammonia	**Drying Time:**	@77°F ± 5°F; ≤ 70% relative humidity; adequate ventilation
pH	8.8 – 9.5	*Tack Free*	15 – 30 minutes
Viscosity	60 – 70 KU @ 77°F	*Between Coats*	1 hour
Shelf Life	1 year from date of shipment in unopened container	*Dry to Handle*	1 hour
Storage Conditions	50°F – 100°F	*Complete Cure*	7 days
Freeze/Thaw Stability	KEEP FROM FREEZING	**Force Cure:**	
Coverage Rate** *ASTM D1400*	360 sq. ft./gallon @ 5 mils wet 360 sq. ft./gallon @ 2 mils dry	*Flash Time*	10 -30 minutes @77°F ± 5°F; ≤ 70% relative humidity
		Oven Bake	10 minutes @ 140°F – 180°F

*Varies by color.
**Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.

PERFORMANCE AND FUNCTIONAL PROPERTIES

Accelerated Weathering QUV:	UVA-340 bulbs	**Flexibility (Mandrel)**	1/8 inch*^
3000 hrs	1 Delta E color change (Typical); White, black, & gray perform twice as well	**Impact Resistance**	8 inch-pound*^
		Pencil Hardness	HB*^
Adhesion (X Cut)	5A*^	* Over Sandstrom E914 Primed CRS ^ Over Sandstrom E914 Primed Aluminum	

GENERAL
For maximum service, the APPLICATION INSTRUCTIONS MUST BE CLOSELY FOLLOWED.

COVERAGE
One gallon of this material will cover 360 sq. ft. with a dry film thickness of 0.002 inches. Coverage depends upon method of application and other variables such as overspray and type of surface to be coated. Above coverage rates are based on 100% efficiency.

SURFACE PREPARATION
Surfaces should be clean, dry, and free of all dirt, grease, wax, loose or peeling paint, oil, and other contaminants. For maximum adhesion, use a cleaner/etcher designed for aluminum or fiberglass OR clean the substrate with Sanpro® Easy Clean and prime with Aqua-Poxy 914 Primer.

IMPORTANT! ***DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION.*** Whenever possible, treat both contact surfaces (i.e., the shaft and the bearing).

THINNING
Apply as is for HVLP application, or thin 20 parts Sancryl 300 to 1 part RO/DI water for conventional air spray, viscosity of 60 – 70” #2 Zahn Cup (ASTM D4212).

APPLICATION
Sancryl 300 is formulated for conventional spray or HVLP spray application. Roller application is possible under ideal conditions.

CLEANUP
Clean equipment immediately with water.

REMOVAL
In the event it is necessary to remove Sancryl 300, physical removal is best (such as grit blasting, sanding or grinding).