

PCS-4400 WATERBORNE ACRYLIC DTM

DESCRIPTION: PCS-4400 is a water based acrylic enamel developed for Direct-to-Metal application over properly prepared surfaces. It has excellent color and gloss retention, therefore providing outstanding long-term weatherability and service life.

USES: Due to the versatility of this product, it can be manufactured to exact specification of OEM finishing lines for production facilities or as a heavy bodied coating for field application. PCS-4400 is ideal for use on tanks, bridges, siding, rolling stock, OEM finishing, and structural steel exposed to mild or moderately corrosive environments. It should be considered where lower V.O.C. requirements have to be met. It is not recommended for use with strong solvents or immersion service.

SURFACE PREPARATION: OEM Applications: The use of a two-stage washer and preferably that of a three- to five-stage washer is recommended. Where PCS-4400 is applied to difficult surfaces such as polished metals, the use of a seal coat during the cleaning process is highly recommended.

Field Application: New Steel: In order of decreasing effectiveness:

1. Abrasive blast to SSPC-SP10 Near White
2. Abrasive blast to SSPC-SP6 Commercial Blast

Previously Painted Surfaces: In order of decreasing effectiveness:

1. Abrasive blast to SSPC-SP7 Brush Blast
2. SSPC-SP3 Power Tool Clean

For most applications, hand cleaning followed by spot priming with PCS-12295 is suitable. Existing finishes in sound condition, but contaminated with grease and oils, should be cleaned by detergent washing or solvent rinse.

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VOC as supplied:

135 gms/liter (1.13 lbs/gal) excluding water.

54 gms/liter (0.45 lbs/gal) including water.

VOLUME SOLIDS: 33 +/- 2%

GLOSS: 70+ or as requested.

COLOR: Standard colors, special colors available upon request.

THEORETICAL COVERAGE: 530 sq. ft. per mil per gallon at 100% transfer efficiency.

APPLICATION TEMPERATURE:

50°F - 100°F

DRY TIME: To Touch: 10-15 minutes; To Handle: 20-25 minutes. These conditions are based upon 1-1.5 mil DFT at 77°F and 80% relative humidity. Cure times will be lengthened at a higher film thickness. On days when the temperature is approximately 80°F and spraying dry films of 4 mils, it may take 2 hours to dry at 80%+ relative humidity or as little as 1 hour when the relative humidity is below 45%.

CLEAN-UP: Soap and water. Where coating has set up, the use of a solvent such as MEK will be required.

SHELF LIFE: 12 months minimum when properly stored in unopened containers between 40°F minimum and 120°F maximum.

PACKAGING: 5-gallon pails; 55-gallon drums; 330-gallon totes available upon request.

APPLICATION: OEM Finishing: PCS-4400 will be manufactured as required to the design parameters of the finishing line. **Field Application** - Stir well before using. **For airless or air assisted airless spray**, a 30:1 ratio pump is recommended with a 0.013" orifice and 60° fan pattern. Fluid pressures should be about 1800 psi. **PCS-4400** will appear to be heavy bodied compared to solvent-based systems; do not reduce unless necessary to achieve atomization and then do so sparingly--no more than ½ pint of water per gallon as a start. A 9-mil wet film will yield about 3 mils DFT. **For conventional spray**, use a DeVilbiss MBC-510 gun with E needle and a #704 air cap or equivalent. Reduce no more than one pint of water per gallon.

PCS-4400 may be applied to damp surfaces. Remove standing water with clean air before coating. Block or dike off area to be coated to stop water from re-entering application area.

CLEAN-UP: Use soap and water. Do not delay clean-up as the coating develops some toughness as soon as the water has evaporated and started to cure.

CAUTIONS: **PCS-4400** is not flammable. Components of this product, when combined, may be skin irritants and/or skin sensitizers. Rubber gloves should be worn to minimize skin contact. Avoid breathing vapors of heated material. If swallowed, do not induce vomiting. Call a physician immediately. For eye contact, flush with lots of water. In case of skin contact, wash thoroughly with soap and water.

See Material Safety Data Sheet for full precautions prior to use.

PCS-4400 is intended for **INDUSTRIAL USE ONLY**.