Riley Paint Company

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PRODUCT DATA SHEET

PRODUCT DESCRIPTION: Riley's 2-Component Acrylic Polyurethane is intended for use on properly prepared and/or primed metal surfaces for finishing or refinishing. Suitable applications include agricultural, construction, and industrial equipment, castings, and general metal fabrications. This is a superdurable gloss and color retention system where superior performance paint is required.

ADVANTAGES:

WIDE BALANCE OF PERFORMANCE PROPERTIES:

- Full Film Appearance
- High Gloss with Excellent DOI
- Fast Recoat Time
- Superior Gloss and Color Retention
- Superior Weather Durability
- Superior Flexibility And Film Toughness
- Superior Adhesion and Flexibility
- Film hardness
- Virtually any new or existing color standard can be quickly and precisely matched
- Gloss can be matched to customer specifications
- Can be formulated for lower Hazardous Air Pollutants—HAP's

SOLVENT REDUCTION DATA:

Solvent	Comparative Spot Dry	Reduction Strength
Toluene	1 min. 5 sec.	Strong
Xylene	2 min. 40 sec.	Strong
D-100	6 min. 30 sec.	Average
D-150	22 min.	Average
N-Butyl-Acetate	2 min. 7 sec.	Strong
Methyl Ethyl Ketone	35 sec.	Strong. Used to enhance electrostatic wrap.

CHARACTERISTICS:

GLOSS: Full
VOLUME SOLIDS: 30-50% Varies by color
VISCOSITY: 25-55 Seconds Zahn #2

SPREADING RATE: 480-800 SQ. FT./GAL. At 1 Mil, No Application Loss

PACKAGE LIFE: 2 Years

DRYING: Air Dry @ 77°F (25°C) 45% RH
To Touch: 90 MINUTES
To Handle: 6-12 HOURS
To Recoat: After 40 minutes and less than 6 hours
To Pack: 24 HOURS
FORCE DRY: Up to 200°F for 30 minutes for most colors.

RECOMMENDED FILM THICKNESS:
WET: 3.0-6.0 MILS
DRY: 1.0-2.0 MILS

REDUCTION: Xylene, Toluene, D-100, D-150, N-Butyl-Acetate

CLEAN UP: Toluene or Xylene. WARNING. Residue from clean up is flammable.

PRODUCT LIMITATIONS:

1. Must be mixed at specified mix ratio.
2. Pot life of 2-4 hours.
3. Should be recoated within 6 hours of ambient cure. When recoating over cured polyurethane sanding with fine sandpaper is necessary.
4. For improved corrosion resistance or film build such as on sand blasted or rough surfaces, use an epoxy or polyurethane primer.
5. Blocking or sticking may occur when flat surfaces are stacked before adequate cure. Allow at least 24 to 48 hours drying before stacking depending on dry film thickness.
6. For best application of applying paint to a substrate the temperature of the paint should be between 65-90°F (18-32°C). If specified temperature is not met poor atomization can result.
7. Stir thoroughly before and during use. Stirring is critical to maintaining consistent coating material parameters.

APPLICATION:

APPLICATION PRECAUTIONS AND LIMITATIONS: Apply only when air, product or surface temperature is above 50°F (10°C) and when surface temperature is at least 5°F (3°C) above the dew point. Condensation will cause paint film failure.

SURFACE PREPARATION:
METAL: Apply to properly cleaned or treated metal surface. A solvent wipe to remove contaminates or sandblasting will work. Sand blasted metal may require more dry film thickness to fully cover blasted profile. Priming metal prior to topcoating is recommended for best overall properties. Preprimed surfaces may need to be lightly sanded and tacked off for best inner coat adhesion. Chemical treatment will improve the adhesion and performance properties of the paint. Treatment may consist of an iron phosphate chemical pretreatment. Riley manufactures several chemicals for surface preparation.

ALUMINUM AND GALVANIZED IRON (UNTREATED): Prime with a vinyl wash primer then coat with an epoxy or urethane primer followed by a topcoat.

WOOD (INTERIOR): No primer is required for properly prepared, previously painted surfaces. For new wood priming is recommended. Riley has specialty wood coating products that may work better.

CONVENTIONAL SPRAY: Reduce to the desired viscosity using a solvent that has the appropriate reduction strength and dry time. Add with agitation. Spray at 40-60 psi atomizing pressure and 15-20 psi fluid pressure. Plural component spray equipment is recommended. Viscosity 20-35 seconds #2 EZ. WARNING. Over spray residue will spontaneously combust.

AIRLESS SPRAY: Not recommended. Airless or Air Assisted Airless spray equipment tends to cause micro pinholes in 2-component polyurethanes.

DIP: Not recommended due to pot life.

KEEP OUT OF REACH OF CHILDREN
Consult MSDS for more information. **Revised 9-07-06**