



**TAB 18 A
IMA – 709**

**ACRYLIC EPOXY
ENAMEL
138 Series**

Type	Sheen	Spread Rate	Recommended Application	Thinner	Clean Up	DRY TIME		
						Tack Free	Re-coat	Cure
Alkyd Epoxy	Gloss & Semi – Gloss	Up to 450 Sq Ft Per Gallon	Brush, Roller Or Spray	Clean Water	Warm Soapy Water	2 Hours	12 Hours	7 Days
PRODUCT NAME: ACRYLIC EPOXY ENAMEL 138 SERIES		This is a two component water thinned coating system which combines the resistance properties of epoxies with the color and gloss retention of acrylics. Both components are lead and mercury free, low in odor, and meet most local air quality standards. This coating cleans easily and is abrasion and stain resistant. It can be applied by spray, roller or brush, for best results it is recommended that two coats be applied. Acrylic Epoxy is available in both a gloss and semi-gloss finish.						
WHERE TO USE:		Metal Drywall On interior or exterior areas such as metal buildings, machinery, halls, restrooms, Masonry Plaster equipment and concrete floors. Wood						
Surface Preparation:		Substrate should be thoroughly dry and free of dust, grease, oil, wax, mildew, soap or powdery residue, mill scale, rust and other contaminants. Patch voids and cracks in masonry. Remove loose or chalky coatings and level surface projections. Remove grease, form oil, or parting compound with Sur-Prep 1. Rake mortar joints clean. Fill voids and pores in concrete block with a block filler. Remove chemical contamination by water wash. Sandblast steel to at least SSPC-SP 6-63 (commercial blast.) Glossy surfaces must be dulled by sanding. Primers: Ferrous Metal – Metal Primer 36-11, 35-111, 35-147 or 35-153. Non-Ferrous Metal – Perma Bond 100-10. Galvanized – Apply directly to galvanized metal 36-11. Wood Interior – Use Undercoat 37-11 Wood Exterior – Use 560 Drywall/Plaster – Use 1190 or 50 Concrete – Use 138 Line as self-priming or use Masonry Sealer 48-11						
Mixing:		The proper mixing ratio is 6 parts of Component A to one part of Component B. The contents of cans are pre-measured to achieve this ratio. To mix, empty the full contents of the short filled quart container of “B” Component into the short filled gallon container of “A” Component and mix thoroughly. Allow to stand for 15 minutes. Thinning is not necessary. When mixed, the yield will be one gallon.						
Tinting:		Acrylic Epoxy may be tinted with the 896 Aqua Chem Colorants. Additionally, the 138-1 can be tinted with up to 4 ounces of glycol based colorant. Colorant should be added to the “A” component prior to mixing with the “B” component.						
Application:		May be applied by nylon or polyester brush, roller or spray at a rate of up to 450 sq ft per gallon. If thinning is necessary, use clean water, up to 5%. Apply only when surface and air temperatures are between 50°F and 90°F.						
NOTE: Formulated without mercury or lead.								

FINISH	GLOSS FINISH 138-XXA with 236-250B	SEMI-GLOSS FINISH 138-XXA with 236-251B
Resin Type:	Acrylic Epoxy	Acrylic Epoxy
Solids:	Weight – 49.7% Volume – 37.5%	Weight – 50.0% Volume – 37.6%
Weight Per Gallon:	10.36 lbs ± 0.20	10.38 lbs ± 0.20
Viscosity:	85 – 90 KU	85 – 90 KU
Flash Point:	2000 F or over (Seta)	2000 F or over (Seta)
Specular Gloss:	75 – 85% (@ 600 degrees	45 – 55% @ 60 degrees
Sag Rating:	8 Wet min.	8 Wet min.
Recommended Film Thickness:	Wet – 4.0 to 5.0 mils Dry – 1.5 to 1.8 mils	Wet – 4.0 to 5.0 mils Dry – 1.5 to 1.8 mils
Light Reflectance:	90% (White or lightest colors)	90% (White or lightest colors)
Pot Life:	6 hours @ 70° F	6 hours @ 70° F
Dry Heat Resistance:	250° F	250° F
Mixing Ratio:	6 to 1	6 to 1
Cautions:	DO NOT FREEZE !	
VOC / VOS Statement:	This product contains a maximum of 230 lbs. of VOC / VOS per liter of coating. (1.9 lbs. per gallon)	
Chemical Abstract Number:	INGREDIENT: Acrylic Resin Epoxy Emulsion Diethylene Glycol Methyl Ether Diethylene Glycol Butyl Ether Titanium Dioxide Water	CAS. NO. Proprietary Proprietary 111-77-3 112-34-5 13463-67-7 7732-18-5

USDA/FDA Approval:	138 Line is approved by the U.S.D.A. and F.D.A.
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