



TAB 18
IMA – 606
DIRECT TO METAL
ACRYLIC COATING
SYSTEM
 180 Series Gloss
 182 Series Semi-Gloss

Type	Sheen	Spread Rate	Recommended Application	Thinner	Clean Up	DRY TIME		
						Tack Free	Re-coat	Cure
Acrylic	Gloss & Semi - Gloss	200-425 Sq. Ft. Per Gallon	Brush, Roller, or Spray	Water	Warm Soapy Water	30 Minutes	2 Hours	7 - 10 Days
PRODUCT NAME: 180 & 182 Series DTM Acrylic		O'Leary Direct to Metal Acrylic Enamel is a high performance, rust inhibiting coating system that can be applied to bare steel, galvanized steel or a variety of other substrates. DTM Acrylic Enamel is designed for light to moderate industrial exposure and is suitable for most institutional or commercial applications. This product is available in 180 Series Gloss Finish, 182 Series Semi-Gloss finish and is accompanied with 180-11 or 182-147 High Performance Acrylic Rust Inhibiting Primer to provide unparalleled corrosion performance in normal atmospheric environments. O'Leary DTM Acrylic Enamel is a low odor, low VOC coating that provides excellent adhesion, corrosion protection, gloss and color retention, as well as ease of application and clean up being a waterborne system.						
WHERE TO USE:		Interior / Exterior. DTM Acrylic Enamel is suitable for coating steel, galvanized metal, concrete, masonry, plaster, drywall, primed wood, etc., in plants, schools, warehouses, mills, hospitals, hotels and restaurants. DTM Acrylic may be applied to structural members, tanks, towers, machinery, pipes, duct work, doors, railings, siding or walls.						
Surface Preparation:		<p>The surface to be coated must be clean and free of loose rust, dirt, chalk, grease, oil, mildew, loose, flaking paint or any other contamination that could affect positive adhesion. The preferred method of preparation for steel is to abrasive blast to SSPC-SP6 Commercial Blast. This provides optimum product performance. If this method is not possible, use adequate power tool cleaning to SSPC-SP3. O'Leary DTM Acrylic Enamel may be applied to sound, tight adhering rust, but loose or severe rust must be removed. All grease, oil, blood, animal fat or dirt should be cleaned with Sur-Prep I Emulsifier. Follow all label instructions. Chalk residue or zinc oxidation, on galvanized metal, should be removed by power washing. Mildew should be cleaned by washing the surface with a solution of one part bleach to six parts water. Rinse thoroughly after mildew wash with clean water and allow to dry. Extremely glossy paints should be dulled by sanding, to improve adhesion.</p> <p>PRIMING – (New or bare surfaces) STEEL – DTM Acrylics are self-priming when applied in two coats. For maximum product performance, apply a first coat of 180-11 or 180-147 High Performance Rust Inhibiting Primer. GALVANIZED – Product is self-priming. MASONRY – Self-priming or O'Leary 48-11 Masonry Sealer. CONCRETE – Self-Priming or O'Leary 946-11 Latex Block Filler. DRYWALL – Use O'Leary 1190 Wash-N-Wear. PLASTER – Use O'Leary 50 Block-It. WOOD – Use O'Leary 560 Primer for exterior wood and 37-11 for interior wood. ALUMINUM – Self Priming, 180-11 or 180-147 High Performance Rust Inhibitive Primer.</p>						
Application:		<p>Stir product thoroughly before applying. O'Leary DTM Acrylics can be applied by brush, roller, air-atomized or airless spray at up to 425 sq ft per gallon. Apply these coatings when material, air and surface temperatures are between 55°F and 100°F. The substrate must be at least 5°F above dew point. Relative humidity should be below 90%. For brush or roller application, thinning is normally not required. For best application results, use a quality synthetic filament brush or a short nap roller cover. For airless spray application, thin material up to 10% with clean water. Do not apply DTM Acrylic Finishes if rain is threatening. If heavy night dew is forecast, stop painting at least 6 hours before dew point is achieved. DTM Acrylics will dry to the touch in 30 minutes and may be re-coated in 2 hours. High humidity and low temperature conditions will extend normal dry and re-coat times.</p> <ul style="list-style-type: none"> IMPORTANT NOTE: A minimum of 6 dry mils (two coats) is required over tightly adhering rust to prevent rust staining. Should rust staining occur, apply an additional coat. 						
Storage:		Always store DTM Acrylics in a dry, well-ventilated area. Storage temperatures should be between 40° and 120°F. Do not let material freeze.						
NOTE: Formulated without mercury or lead.								

Resin Type:	Acrylic									
Solids:	<table> <tr> <td></td> <td style="text-align: center;">180 – 1</td> <td style="text-align: center;">182 – 1</td> </tr> <tr> <td>Weight -</td> <td style="text-align: center;">46.8%</td> <td style="text-align: center;">54.8%</td> </tr> <tr> <td>Volume -</td> <td style="text-align: center;">36.2%</td> <td style="text-align: center;">42.6%</td> </tr> </table>		180 – 1	182 – 1	Weight -	46.8%	54.8%	Volume -	36.2%	42.6%
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Volume -	36.2%	42.6%								
Weight Per Gallon:	180 – 1: 9.9 lbs. 182 – 1: 10.5 lbs.									
Viscosity:	90 ± 5 (Krebs Units)									
Flash Point:	200°F or over (TT-P-141, Method 4293)									
Specular Gloss:	180 – 1: 80% 182 – 1: 50 ± 5%									
Sag Rating:	Pass 8 mils (Lenetta)									
Recommended Film Thickness:	<table> <tr> <td></td> <td style="text-align: center;">Tight Rust</td> <td style="text-align: center;">Clean Metal</td> </tr> <tr> <td>Wet -</td> <td style="text-align: center;">7.0 to 8.0 mils</td> <td style="text-align: center;">4.0 to 5.0 mils</td> </tr> <tr> <td>Dry -</td> <td style="text-align: center;">2.8 to 3.4 mils</td> <td style="text-align: center;">1.6 to 2.0 mils</td> </tr> </table>		Tight Rust	Clean Metal	Wet -	7.0 to 8.0 mils	4.0 to 5.0 mils	Dry -	2.8 to 3.4 mils	1.6 to 2.0 mils
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Abrasion Resistance: Adhesion: Flexibility: Accelerated Weathering: Salt Fog Resistance:	ASTM D 4060 – 100 mg. loss after 1,000 cycles (CS-17 Wheel) ASTM D 3359 – Pass 5B ASTM D 1737 – Pass 1/8" Mandrel ASTM G 53 – 90% Gloss Retention @ 500 hours ASTM B 1117 – 1,000 hours (two coats over 360-11 Primer) Rating – 10, Rust Area – 0.00%									
VOC – VOS Statement:	This product contains a maximum of 275 grams of VOC/VOS per liter of coating (2.3 lbs per gallon)									