

SunCryl® 325 Series Acrylic Enamel



DESCRIPTION

SunCryl 325 Series is a single stage Acrylic Enamel. It may be applied with or without hardener. Add 325C000 or 325C007 hardener to enhance appearance, durability and recoatability.



COMPONENTS

- SunCryl 325 Color
- 325C000 Hardener
- 325C007 Enhanced Hardener
- 181 Fast Reducer up to 75°F (24°C)
- 182 Medium Reducer 75-85°F(24-29°C)
- 183 Slow Reducer 85-95°F(29-35°C)
- 184 Very Slow Reducer 95°F(35°C) plus



MIXING RATIO

10 - 15% reduction with 181 - 184 Reducers.
With hardener: 8 parts color to 1 part 325C000 or 325C007 (recommended). (8:1:10-15%)



POT LIFE @ 77°F (25°C)

Indefinite without hardener
4 Hours with hardener



CLEAN UP

Valspar Refinish 100 Thinner
(Check local regulations)



ADDITIVES

ACCELERATOR: N/A
FISHEYE: T152 1 oz. per gallon.
FLEX ADDITIVE: N/A

Note: Do not spray when surface temperature is below 50°F (10°C).



SURFACE PREPARATION

USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING RECOMMENDED PROCEDURES.

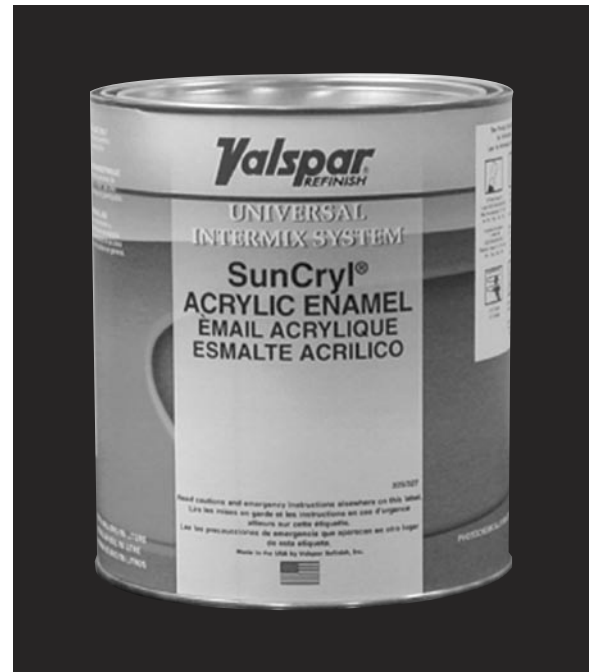


- Finish sand with 360-400 grit wet or dry sandpaper or equivalent.
- Mask all adjacent areas to prevent over spray problems.



SUBSTRATES

- AquaPrime 9
- 87N
- DTM 2000
- Properly Prepared OEM Finish
- VP Series Epoxy Primer
- Valspar Polyurethane Primer/Sealers





APPLICATION

Spray two to three coats allowing 20 minutes between coats. Do not mist coat.



FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash between coats	20 Minutes
Tape Time without Hardener	Overnight
Tape Time with Hardener	Overnight
To Deliver	Next Day



FORCE DRY

Flash before Force Dry	20 Minutes
Force Dry Time	30 Min. @ 130°F (54°C)
To Tape	After Cool Down (1-2 Hours)
To Topcoat	After Cool Down (1-2 Hours)



GUN SETUPS CONVENTIONAL

Gravity Feed	1.6 mm - 1.8 mm
Siphon Feed	1.6 mm - 1.8 mm

HVLP

Gravity Feed	1.3 mm - 1.5 mm
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AIR PRESSURES

CONVENTIONAL @ GUN

	PANEL	OVERALL
Gravity Feed	30 - 35 psi	35 - 40 psi
Siphon Feed	30 - 45 psi	40 - 50 psi

HVLP @ Cap	6 - 8 psi	8 - 10 psi
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PHYSICAL DATA

VOC (Unreduced)	4.4 - 4.7 lbs. per gallon
VOC (Reduced)	5.0 lbs. per gallon
Volume Solids	36 - 38% (Average)
Theoretical Coverage	570 - 606 sq. ft. per mil per gallon
Recommended DFT	1 - 3 mils.
Zahn #2 Viscosity (RTS)	19 - 20 seconds