

AQUACRON® MV380 Series Waterborne Acrylic Enamel

HIGHLIGHTS:

- Adhesion to wide variety of substrates
- Very fast drying
- Very good block resistance
- Excellent flexibility & chemical resistance
- VOC compliant to 2.10 lbs./gal. (less exempts)
- The MV380 can be textured / spattered to hide surface imperfections on metal & plastic substrates

RECOMMENDED
TOPCOATS / PRIMERS:

MV390-9300 WB Acrylic Primer

PRODUCT CODES / COLORS:

MV380-1 / White
 MV380-9 / Black
 MV380-91 / Medium Gray
 MV380-92 / Light Gray
 Custom Colors

EXAMPLE PRODUCT USES

- Metal entry doors & jambs
- Metal racking
- Process equipment (pumps and blowers)
- Electrical equipment (switch gear & pad mounted transformers)

DESCRIPTION:

The AQUACRON® MV380 Series is a waterborne acrylic modified enamel with excellent exterior color & gloss retention. It can be used as a topcoat for metal entry doors & jambs, metal shelves & racking, electrical & process equipment.

TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT
Adhesion	ASTM D3359	5B
Gloss (60° angle)	ASTM D523	30 - 70 units for custom colors (70+ units for factory pack colors)
Humidity Resistance	ASTM D2247	150 hrs.
Pencil Hardness	ASTM D3363	F - H
Salt Spray Resistance	ASTM B117	1,000 hrs.* (using MV380 topcoat & MV390-9300 at 3.5-4.0 mils DFT) 250 hrs. av. (over non-chrome sealer)
Solvent Resistance (>50 DR w/Xylene, MEK & IPA)	ASTM D5402	Slight softening but recovers

* Performance tests were done on CRS B-1000 panels with a chrome sealer

PHYSICAL PROPERTIES:

PROPERTY	VALUE
Coverage (@ 1 mil, no loss)	545 - 577 sq. ft./gal.
Flash Point	201°F
Shelf Life	1 year
VOC	1.9 - 2.10 lbs./gal. (less exempts)
VOE	< 1.0/gal. (average - color dependent)
Volume Solids	34% (average - color dependent)
Weight per Gallon	9.5 lbs./gal. (approximate - color dependent)
Weight Solids	40.0 % (approximate - color dependent)

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SUBSTRATES:

Aluminum	A fluoride containing pretreatment is required for adhesion
CRS, HRS	A pretreatment is required for adhesion & corrosion resistance
Fiberglass	Surface must be sanded or abraded to obtain adhesion
Galvaneal	A pretreatment is required for adhesion
Galvanized Steel	A pretreatment is required for adhesion
Plexiglas	Surface must be sanded or abraded to obtain adhesion
PVC Plastic	Surface must be sanded or abraded to obtain adhesion

CURE SCHEDULE:

To Touch*	20 - 30 min.
To Handle*	1 hr.
To Recoat*	1 hr.
Force Dry	10 - 30 min. @ 150 - 220°F

*assumes 77°F & 50% relative humidity

ADDITIONAL INFO:

- Minimum cure temperature is 50°F
- Avoid exposure to ponding water for 5 - 7 days
- If parts are force dried ponding water exposure times can be shortened
- Test precoated surfaces for adhesion
- Sand glossy surfaces for best adhesion
- Adhesion to aluminum, fiberglass, galvanized, galvaneal and plastic substrates may require sanding and/or a pretreatment for adhesion. A test sample is recommended before application.
- A textured finish can be achieved by first spraying a smooth coat on the part and letting it flash for approximately 30 minutes. The second coat is applied by lowering the atomization pressure to approximately 5-10 PSI and spattering the spray mist over the smooth coat in a overlapping pattern.

SURFACE PREPARATION:

Surface must be clean and free of all surface contamination such as oil, dirt, rust and foreign matter. A 3-stage iron phosphate chemical pretreatment such as a PPG Chemfos® Cleaner and Chemseal Sealer system or similar conversion coating system will improve adhesion and performance properties of the total coating system over cold rolled steel substrates. A conversion coating is required for adhesion on aluminum substrates. The MV390-9300 WB Acrylic Primer is required to achieve 1000 hour salt spray performance. A conversion coating containing fluoride is required for adhesion on aluminum substrates.

APPLICATION DATA:

APPLICATION	INSTRUCTION
Mixing Instructions	Stir thoroughly before using
Wet Film Thickness (mils)	3.0 - 4.5
Dry Film Thickness (mils)	1.0 - 1.5
Reduction Rate	5 - 10%
Reducer	Water or TFA880-70 Aquathin Refresher
Clean Up	Water or MV398C Equipment Cleaner
Viscosity	20 - 30" Zahn #5 cup

SPRAY APPLICATION:

Spray Application	Spray Equipment	Tip	Fluid Pressure (psi)	Atomization Pressure (psi)	Fluid Nozzle	Air Nozzle
Conventional	Graco Air Pro Gun*	NA	30	35	1.4 mm (0.055")	289-784
Electrostatic	Graco Xs3 Gun*	NA	32	50	1.5 mm (0.055")	24A376
Air Assisted Airless	Graco G15 Gun & Merkur 15:1 Pump*	M409	1050	20	NA	249-596
HVLP	Graco Air Pro Gun*	NA	30	50** (inlet)	1.4 mm (0.055")	289-047
Airless	Graco Ultimate 695*	RAC X LTX-517	1700	NA	NA	NA

*or equivalent

**atomization pressure should be <10 psi

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