

STIC-ADHESIVE Products Co., Inc.

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Technical Data Sheet

STIC-KOTE 1800 Series DTM Acrylic Paint

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DESCRIPTION

STIC-KOTE 1800 Acrylic Paint is a low VOC, water-based, direct-to-metal coating for industrial and architectural applications. This product utilizes a modified-acrylic emulsion that provides protection against corrosion, weathering, and harsh environmental elements. It may be used on both exterior and interior surfaces, dries quickly, and is for areas subject to salt spray, water exposure, or corrosive environments.

This top coat is intended for use on most steels, including galvanized steel, aluminum, masonry, wood, drywall, and concrete. STIC-KOTE 1800 series DTM Acrylic Paints are recommended to be used with STIC-KOTE 900 Primer.

APPLICATION PROPERTIES

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| 1) Volatile Organic Compound:
(VOC EPA Method 24) | < 140 g/L, 1.2 lb/gal |
| 2) Color: | White
(available in most Fed Std. 595 colors) |
| 3) Finish: | Semi-gloss, High-gloss |
| 4) Weight Solids: | 51% ± 2% |
| 5) Volume Solids: | 39% ± 2% |

USE PROPERTIES

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| 1) Shelf Life: | 3 years from date of manufacture (if unopened)
store indoors |
| 2) Flash Point (SETA): | > 212°F (100° C) |
| 3) Reducer: | Water (do not use organic solvents) |
| 4) Tinting: | Use standard commercially available tinting colors. Some tinting products can affect corrosion, adhesion, weathering, and other physical properties. Always test first. Use a mechanical shaker for at least 4-5 minutes to mix in the tint. |
| 5) Clean Up: | Water (do not use organic solvents) |
| 6) Application Equipment: | Brush, roller, and airless or conventional spray |
| 7) Application Temperature: | 50°-110°F (10°- 43° C) for surface, paint and ambient air |
| 8) Application Humidity: | Maximum of 85% relative humidity |
| 9) Storage: | Store product in accordance with local, state and federal regulations. Keep container tightly sealed and store indoors in dry conditions at 45°-100°F (7°-38°C). |

TECHNICAL DATA SHEET

RECOMMENDED USAGE

Steel, Aluminum, Galvanized, Wood,
Masonry & Concrete:

1 coat STIC-KOTE 900 DTM Primer, applied at 3-5 mils (75-125 microns) dry thickness; and
1-2 coats STIC-KOTE 1800 Series DTM Paint, applied at 3-4 mils (75-100 microns) dry thickness. Note: 2 coats top coat provides best protection.

Notes regarding Masonry & Concrete:

Best results if surface is smooth and without porous gaps. If necessary, prepare surface with mastic filler to cover gaps and holes.

SURFACE PREPARATION

Surface must be clean, dry and in sound condition, free from loose mill scales, dirt, dust, rust, oil and grease. Remove all loose scales, peeling, flaking paint, rust, corrosion and chalk from the surface before painting.

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| 1) Steel, Iron | Hand-tool clean per SSPC-SP1 (removing all loose mill scale, loose rust, loose paint, and other foreign material) |
| 2) Galvanized, Aluminum | Solvent clean per SSPC-SP1 (removing oil, grease, dirt, and other soluble foreign material) |
| 3) Masonry & Concrete | Prepare surface to be clean and uniform per SSPC-SP13/NACE No. 6 (removing laitance, dust, loose concrete, and foreign contaminants) |

RECOMMENDED COVERAGE PER COAT (DRY FILM)

1) Coverage	<u>ft²/gal</u>	<u>m²/L</u>
Minimum:	155 ± 20 sq.ft.	3.8 ± 0.5 sq. meters
Maximum:	205 ± 20 sq.ft.	5.1 ± 0.5 sq. meters
2) Wet Film Thickness per coat:	6 - 8 mils (min/max)	150 - 200 microns (min/max)
3) Dry Film Thickness per coat:	3 - 4 mils (min/max)	75 - 100 microns (min/max)
4) Theoretical Coverage of Dry Film:		
Dry film thickness	1 mil	620 ft ² /gal
Dry film thickness	25 micron	15 m ² /L

Note: Brush or roller application may require multiple coats to achieve maximum film thickness.

RECOAT SCHEDULE @ 3 mil (75 microns) DRY FILM - 6 mil (150 microns) WET FILM

Temperature:	<u>50 ± 10°F</u> (10 ± 5°C)	<u>77 ± 10°F</u> (25 ± 5°C)
1) Touch Time:	2 hours	1 hour
2) Recoat Time:	8 hours	4 hours
3) Dry Hard Time:	24 Days	14 Days

TECHNICAL DATA SHEET

PERFORMANCE PROPERTIES

<u>Property</u>	<u>Test Method</u>	<u>Results</u>
Adhesion	ASTM D-3359	Excellent 5/5 (rating: 0-5 (5=best)) steel, aluminum
Flexibility	ASTM D-522	Passes
Impact Resistance	ASTM D-4226	>170 in/lb. direct and indirect impact
Corrosion, Rust, Adhesion, Humidity, Blistering, and Condensation Resistance	ASTM D-2247(500 hours) ASTM D-610/D-714	Excellent 10/10 (rating: 0-10 (10=best))
Accelerated Weathering Resistance	ASTM D-4587; (1,000 hours) QUV	Passes with gloss retention >80%
Salt Spray	ASTM B117 (500 hours) ASTM D-610/D-714	Excellent 9/10 (rating: 0-10 (10=best))
Working Property	ASTM D-2932	Passes
Condition in Container	low temp: 40°F ± 3° (2 weeks) high temp: 100°F ± 3° (2 weeks)	Passes Passes

SAFETY

Refer to the Material Safety Data Sheet (MSDS) before using this product, for safe use, handling and storage.

OTHER INFORMATION

HEALTH AND SAFETY INFORMATION:

Refer to Material Safety Data Sheet for health and safety information before using this product. Also, for additional information, please visit the website at www.sticadhesive.com.

LIMITATION OF REMEDIES AND LIABILITY:

If the STIC-ADHESIVE product is proved to be defective, the exclusive remedy, at STIC-ADHESIVE'S option, shall be to refund the purchase price or replace the defective product. STIC-ADHESIVE shall not otherwise be liable for loss or damages, regardless of the legal theory, including but not limited to contract, negligence, warranty, or strict liability.

DISCLAIMER:

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