The ACRYL-GLO single-stage acrylic enamel paint system provides a durable finish that is easy to apply and suitable for both commercial and passenger vehicle refinish work. This high-quality topcoat system is a popular choice, combining economic value with long lasting durability and ease of use. Available in 44 stock, pre-mixed, factory-packaged colors ranging from common solid fleet colors to brighter metallic and pearlescent combinations.

Designed to be used in a single-stage application with or without a hardener, or in combination with a urethane clearcoat for additional durability and gloss.

- National Rule Compliant
- Wide assortment of factory packaged colors
- Excellent flow and leveling
- Long-lasting enamel gloss

**COATING TYPE:**
Acrylic Enamel Topcoat (single-stage)

**PRODUCT CODES:**
KS Prefix

**HARDENERS:**
K-1606 Super Wet Look A/E Hardener
K1607 Wet Look A/E Hardener

**REDUCERS:**
R-7910/7920 (Fast)
R-7911/7921 (Medium)
R-7912/7922 (Slow)

**WEIGHT PER GALLON:**
Varies by color

**PACKAGE MEASURE:**
1 US Gallon / 128 fl. oz. / 3.785 Liters

**RTS VOC:**
Varies by color (will not exceed 5.0 lbs/gallon)

**RTS Viscosity:**
20-22 seconds, #2 Zahn cup

**SURFACE PREP**
Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker’s 650 Wax & Grease Remover). Abrade substrate with 600-800 grit, to ensure sufficient adhesion. Re-clean with final wash cleaner (such as Kirker’s 600 Surface Wash).

ACRYL-GLO may also be applied “wet on wet,” over certain freshly applied undercoats including Kirker’s DIRECT PRIME, PERFECT Prime and RAPID Prime 2K Urethane Primer Surfacers after approximately 30 minutes flash time; or ENDURO PRIME DTM Epoxy Primer after 30-45 minutes flash. Be sure to mask all adjacent panels to prevent dry overspray.

**COLOR**
Please note that while every attempt for color consistency is made, there may be some difference in shade from one batch to the next. If using multiple cans of the same color for the same job, be sure to check for a common batch code before starting. This can be identified by the five-digit number marked either on the lid or face of the can. If batches are not the same, all materials should be blended prior to use to ensure color consistency.
ACRYL-GLO ACRYLIC ENAMEL TOPCOAT

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MIXING
Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts ACRYL-GLO Color with one (1) part of the appropriate Acrylic Enamel Reducer (R-7910/7920, R-7911/7921, R-7912/7922) depending on shop temperature and other conditions. Additional reduction may be necessary to improve flow and leveling.

<table>
<thead>
<tr>
<th>BELOW 70°</th>
<th>70-80°</th>
<th>ABOVE 80°</th>
</tr>
</thead>
<tbody>
<tr>
<td>FAST</td>
<td>MEDIUM</td>
<td>SLOW</td>
</tr>
<tr>
<td>R-7910</td>
<td>R-7911</td>
<td>R-7912</td>
</tr>
<tr>
<td>(gallon)</td>
<td>(gallon)</td>
<td>(gallon)</td>
</tr>
<tr>
<td>R-7920</td>
<td>R-7921</td>
<td>R-7922</td>
</tr>
<tr>
<td>(quart)</td>
<td>(quart)</td>
<td>(quart)</td>
</tr>
</tbody>
</table>

Though not required, it is highly recommended that one of Kirker’s Acrylic Enamel Hardeners (K1606 Super Wet Look A/E Hardener or K1607 Wet Look A/E Hardener) be used. The addition of a hardener will speed up the dry time, increase the gloss in the finished film and extend the durability of the acrylic enamel paint. One (1) pint (16 oz) of Hardener should be mixed with each gallon of Acrylic Enamel Paint and quart of Acrylic Enamel Reducer, resulting in an 8:2:1 mix ratio: 8 parts paint, 2 parts reducer, 1 part hardener. Caution: Mix only as much material as will be needed to complete the immediate job.

TO MIX

<table>
<thead>
<tr>
<th>A/E COLOR</th>
<th>REDUCER</th>
<th>HARDENER</th>
</tr>
</thead>
<tbody>
<tr>
<td>11 oz</td>
<td>2 oz</td>
<td>1 oz</td>
</tr>
<tr>
<td>22 oz</td>
<td>4 oz</td>
<td>2 oz</td>
</tr>
<tr>
<td>33 oz</td>
<td>6 oz</td>
<td>3 oz</td>
</tr>
</tbody>
</table>

POT LIFE
Approximately two hours at 70°F.

GUN SETTINGS
Always refer to gun manufacturer’s recommendations for additional details on suggested tip size, air pressure and other adjustments.

<table>
<thead>
<tr>
<th>GUN TYPE</th>
<th>TIP SIZE</th>
<th>AIR PRESSURE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Conventional Siphon</td>
<td>1.4-1.8 mm</td>
<td>50-60 psi</td>
</tr>
<tr>
<td>Conventional Gravity</td>
<td>1.4-1.6 mm</td>
<td>50-60 psi</td>
</tr>
<tr>
<td>HVLP</td>
<td>1.2-1.4 mm</td>
<td>8-10 psi</td>
</tr>
</tbody>
</table>

DRY TIMES
Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70-75°F.

<table>
<thead>
<tr>
<th>WITH HARDENER</th>
<th>WITHOUT HARDENER</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust Free</td>
<td>20 min.</td>
</tr>
<tr>
<td>Tack Free</td>
<td>1 hours</td>
</tr>
<tr>
<td>Tape</td>
<td>24 hours</td>
</tr>
<tr>
<td>Polish</td>
<td>24-48 hours</td>
</tr>
<tr>
<td>Deliver</td>
<td>24 hours</td>
</tr>
</tbody>
</table>

FORCE DRY
ACRYL-GLO (with A/E Hardener) may be force dried after a 20-30 minute flash period. Bake for approximately 30 minutes at 140°F. After sufficient cool-down, acrylic enamel will be cured and may be taped, handled or polished. If clearcoating or recoating after the bake cycle, Acrylic Enamel surface must be scuff sanded with 600-800 grit to promote adhesion.

DO NOT force dry acrylic enamel in situations where no hardener was used.

RECOAT
ACRYL-GLO may be recoated for up to three (3) hours after the previous coat has dried hand-slick. After three hours (approximate, at 70-75°F), Acrylic Enamel paint enters a sensitive recoat window during which time it should not be topcoated. When an Acrylic Enamel Hardener is used, this No Recoat Window lasts about 24 hours. If no Hardener is used, paint should be allowed to set for about a week before recoating.

CAUTION: Recoating over Acrylic Enamel during this sensitive window may result in significant surface defects including, but not limited to, wrinkling, lifting, cracking, loss of gloss and soft paint film.

After recoat window has safely passed, ACRYL-GLO may be clearcoated or recoated, but only after the surface has first been abraded with 600-800 grit to promote adhesion.

POLISH
In single-stage applications when an acrylic enamel hardener is used, ACRYL-GLO may be polished after 24 to 48 hours. Start by sanding finish with 1500 grit or finer to abrade surface and/or remove dust nibs and other surface imperfections such as orange peel, then finish sand with 2000 grit or finer to remove all 1500-grit sand scratches.

Use a wool pad or foam pad in combination with a high-quality finishing compound, following material manufacturer’s instructions. Follow with a high-quality finishing glaze applied either by hand, or variable-speed buffer.

When no hardener is used, ACRYL-GLO should not be buffed for at least one month.

APPLICATION
Apply ACRYL-GLO in two (2) to three (3) medium wet coats as necessary to achieve the desired coverage, allowing each coat to dry hand-slick before applying next coat. A dry film thickness of 2 mils is recommended.

When applying a low-hiding pearl or metallic color, choice of undercoat color becomes more important. Less pigment must be used in certain colors to maintain pearlescent and/or metallic effects. Those colors may require additional coats to achieve full coverage. In these situations, a uniform undercoat color, or even a solid color ground coat will significantly improve the appearance and hiding efficiency of ACRYL-GLO topcoats. When applying metallic colors in a single-stage application, consistent application technique is critical to prevent mottling. Uneven coats resulting in wet/dry areas will create the appearance of striping or spotting.
**CLEANUP**

Close all containers tightly after each use. Clean gun and spray equipment with Kirker’s VOC Compliant Gun Wash (670) or other appropriate solvent products immediately after application to prevent damage.

**HEALTH / SAFETY**

**THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY. READ ALL WARNINGS ON ALL LABELS BEFORE USING.**

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Safety Data Sheet for additional health and safety information.

**WARRANTY**

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

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