Iron Guard® DTM Acrylic Enamel, is a high gloss, 100% acrylic, waterborne, corrosion resistant coating for light to moderate industrial use. Designed for new construction or maintenance use and can be used directly over prepared substrates.

**ADVANTAGES**
- Breakthrough acrylic technology
- Low VOC
- Compliant everywhere
- Direct to new & clean metal without a primer
- Chemical resistant
- Fast drying
- Outstanding early moisture resistance
- Flash rust/early rust resistant
- Corrosion resistant
- Low odor
- Outstanding adhesion

**RECOMMENDED USE**
For use over prepared substrates in industrial environments.

- Ornamental Iron
- Tanks & cylinders
- Steel fabricated parts
- Equipment
- Machinery
- Metal Buildings
- Select marine structures
- Piping
- Hand Rails

**RECOMMENDED SUBSTRATES**
- Steel
- Iron
- Aluminum
- Galvanizing
- Concrete
- Masonry
- Wood
- Zinc rich primers
- Cement Board/Fiber Board

**SPECIFICATIONS**

**RECOMMENDED SYSTEM**

**Steel (DTM):**
2 cts. Iron Guard® DTM Acrylic Enamel (K110 Series)
@ 2.5 - 4.0 mils dft/ct

**Steel (w/Primer):**
1 ct. Iron Guard® Primer (K11008251/K11006951)
@ 2.5 - 4.0 mils dft or Water-Reducible Alkyd Primer (K00022764 or K00022793) @ 1.0 - 1.3 mils dft.
1 - 2 cts. Iron Guard® DTM Acrylic Enamel (K110 Series)
@ 2.5 - 4.0 mils dft/ct

**Aluminum:**
2 cts. Iron Guard® DTM Acrylic Enamel (K110 Series)
@ 2.5 - 4.0 mils dft/ct

**Galvanizing:**
2 cts. Iron Guard® DTM Acrylic Enamel (K110 Series)
@ 2.5 - 4.0 mils dft/ct

**Concrete Block:**
1 ct. Heavy Duty Block Filler (K00261646)
@ 10.0 - 18.0 mils dft
1-2 cts. Iron Guard® DTM Acrylic Enamel (K110 Series)
@ 2.5 - 4.0 mils dft/ct

**Concrete/Masonry:**
1 - 2 cts. Iron Guard® DTM Acrylic Enamel (K110 Series)
@ 2.5 - 4.0 mils dft/ct

**Wood (Exterior):**
1 ct. Rust Tough® Alkyd Primer @ 1.5 mils dft/ct

**Prefinished Siding (Baked-on Finishes):**
1 ct. WB Smooth Surface Primer (K00021380)
@ 2.0 - 5.0 mils dft
2 cts. Iron Guard® DTM Acrylic Enamel @ 2.5 - 4.0 mils dft/ct

Use full body for best results. Thinning is not normally required. However, if conditions require thinning, reduce up to 12.5% (1 pint) with water.
Mix paint thoroughly by mechanical shaker or stirring.

**SURFACE PREPARATION**
Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

**PREVIOUSLY PAINTED SURFACES**
If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.

**IRON AND STEEL**
Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Steam Cleaning per SSPC-SP1, do not use hydrocarbon solvents. For better performance, use Commercial Blast Cleaning per SSPC-SP6.

**ALUMINUM**
Remove all oil and grease by Steam Cleaning per SSPC-SP1, do not use hydrocarbon solvents. Self-priming.

**GALVANIZING**
The surface should be weathered for six months prior to painting. Remove all oil and grease by Steam Cleaning per SSPC-SP1, do not use hydrocarbon solvents. Self-priming.

**CONCRETE & MASONRY**
Surfaces should be thoroughly cleaned and dry. Surface temperatures must be at least 55°F before filling. Use Heavy Duty Block Filler (K00261646). Filler must be thoroughly dry before topcoating per manufacturer’s recommendations.

**WOOD**
Surface must be clean, dry, and sound. Knots and pitch streaks must be scraped, sanded and spot primed with Rust Tough Alkyd Primer prior to application of topcoats. Two full coats are recommended.
APPLICATION

APPLICATION CONDITIONS
Temperature: 50°F minimum, 95°F maximum (air, surface, and material). At least 5°F above dew point. Relative humidity: 85% maximum

APPLICATION EQUIPMENT
The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with existing environmental and application conditions.
Reduction/Clean-up: Water.
Airless Spray: Pressure: 1500 psi; Hose: 1/4" ID; Tip: .017" - .021"; Filter: 60 mesh; Reduction: As needed, up to 12.5% (1 pint) by volume of water.
HVLP: Gun: Binks 95; Fluid Nozzle: 66; Air Nozzle: 63PB; Atomization Pressure: 50 psi; Fluid Pressure: 7 - 10 psi; Air Cap: 704; Fluid Nozzle: E Tip Reduction: As needed, up to 12.5% (1 pint) by volume of water.
Conventional Spray: DeVilbiss JGA 502, or equivalent; Atomization Pressure: 50 psi; Fluid Pressure: 20-25 psi; Air Cap: 704; Fluid Nozzle: E Tip Reduction: As needed, up to 12.5% (1 pint) by volume of water.
Brush: Nylon/Polyester; Reduction: Not recommended.
Roller: 3/8" woven with phenolic core; Reduction: Not recommended.

Note: If specific application equipment is listed above, equivalent equipment may be substituted.

PERFORMANCE INFORMATION
• Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.
• When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.
• During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. If possible, plan painting schedules to avoid these influences during the first 16-24 hours of curing.
• Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, methods of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.
• Excessive reduction of material can affect film build, appearance, and adhesion.
• Application temperature above 95°F may cause dry spray, uneven sheen, and poor adhesion.
• Application temperature below 50°F may cause poor adhesion and lengthen the drying and curing time.
• Iron Guard® DTM Acrylic Enamel is extremely sensitive to hydrocarbon containing solvents. When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse. Do not use hydrocarbon containing solvents.

CHARACTERISTICS
FINISH: High Gloss, 80+ units @ 60°
SHELF LIFE: 36 months, unopened, at 77°F
TINTING: Tint with Blend-A-Color® Colorants at 100% tint strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color. Tinting can affect the flash/early rust resistance of the coating.
VOLUME SOLIDS: 34% ± 2%, may vary by color
WEIGHT SOLIDS: 43% ± 2%, may vary by color
VOC (EPA Method 24): <100 g/L
RECOMMENDED SPREADING RATE:
Wet mils: 6.5-10.0;
Dry mils: 2.5-4.0; Coverage: 218 - 136 sq ft/gal approximate.

Note: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

DRYING SCHEDULE @ 77°F & 50% RH @ 8 wet mils
To touch: 15 - 30 minutes
To handle: 1 - 2 hours
To recoat: 4 hours
To cure: 30 days

Note: Drying time is temperature, humidity, and film thickness dependent.
FLASH POINT: >200°F, PMCC
REDUCER/CLEAN-UP: Water

PERFORMANCE TESTS
System Tested: (unless stated otherwise)
Substrate: Steel
Surface Preparation: SSPC-SP10
Finish: 2 cts. Iron Guard® DTM Acrylic Enamel (K110 Series) @ 3 mils dft/ct

Note:
Adhesion:

Direct Impact Resistance:
Method: ASTM G14;
Result: >160 in. lbs.

Flexibility:
Method: ASTM D522, 180° bend, 1/8" mandrel;
Result: Passes.

Water Resistance @ 100% RH :
Method ASTM D2247-99
Result: One week not affected

Pencil Hardness:
Method: ASTM D3363; Result: 2B.

Salt Fog Resistance:
Method: ASTM B117, 500 hours;
Result: Excellent.

QUV: Method: ASTM D4587, 1000 hours;
Result: Excellent.

CAUTIONS
Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings® Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings® Distributor.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, Krylon Products Group cannot make any warranties as to the end result. Please direct any questions or comments to 1-800-777-2966.