

XPC Stage 2



Selection & Specification Data

Generic Type	Aliphatic Acrylic Polyurethane
Description	Thin film, high gloss finish with exceptional weathering performance characteristics. Used extensively in virtually all industrial markets, XPC provides a smooth, durable finish that has superior resistance to corrosion, abrasion and chemical exposure.
Features	<ul style="list-style-type: none">■ High solids, low VOC content■ Excellent weatherability■ Exceeds SSPC Paint 26 specification for a Level 3 urethane■ Available in all colors including metallic-pigmented colors■ Excellent flow characteristics allow for application by spray or roller■ Superior impact and abrasion resistance■ Indefinite recoatability■ VOC compliant to current AIM regulations
Color	Refer to Skyline XPC Color Guide. Certain colors, particularly in non-lead safety oranges, reds and yellows may require multiple coats for adequate hiding. Check color suitability before use.
Finish	Gloss
Primers	Refer to Substrates & Surface Preparation
Topcoats	XPC Clear Coat when required
Dry Film Thickness	2.0-2.5 mils (50-63 microns)
Solids Content	By volume 70% ±2%
Theoretical Coverage Rate	1123 mil ft ² (27.5 m ² /l at 25 microns) Allow for loss in mixing and application
VOC Values	As supplied: 2.2 lbs/gal (264 g/l) Thinned 25 oz/gal w/ #25: 3.06 lbs/gal (264 g/l) 25 oz/gal w/ #25: 2.9 lbs/gal (348 g/l) 25 oz/gal w/ #25: 3.0 lbs/gal (362 g/l) These are normal values and may vary slightly with color.
Dry Temperature Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C) Discoloration and loss of gloss is observed above 200°F (93°C)

*The alignment of aluminum flakes in aluminum-filled finishes is very dependent on application conditions and techniques. Care must be taken to keep conditions as constant as possible to reduce variations in final appearance. It is also advisable to work from a single batch of material since variations can occur from batch to batch. For more information consult the Sheeting Solutions Technical Service Department.

*To the best of our knowledge the technical data contained in this document herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Skyline Steel to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Skyline Steel quality control. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, is limited to replacement of products. **NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SKYLINE STEEL, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANT ABILITY AND FITNESS FOR A PARTICULAR PURPOSE.***

Substrates & Surface Preparation

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. For all surfaces prime with specific XPC primer as recommended by your Sheeting Solutions sales representative. Refer to the specific primer's Product Data Sheet for detailed requirements of the specified primer.
Galvanized Steel	Prime with specific XPC primers as recommended by your Sheeting Solutions Sales Representative. Refer to the specific primer's Product Data Sheet for substrate preparation requirements.
Previously Painted Surfaces	Lightly sand or abrade to roughen surface and degloss the surface. Existing paint must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" adhesion test.

Performance Data

Test Method	System	Results	Report #
ASTM D4541 Abrasion	Blasted Steel 1 ct. Epoxy 1 ct. 134 HG	2562 psi (Pneumatic)	09360
ASTM D3359 Adhesion	Blasted Steel 1 ct. Epoxy 1 ct. 134 HG	5A	09360
ASTM D4060 Abrasion	Blasted Steel 1 ct. XPC	70 mg loss after 1000 cycles, CS17 wheel, 1000 gm load	09360
ASTM G26 Weatherometer	Blasted Steel 1 ct. Epoxy 1 ct. 134 HG	No blistering, rusting or cracking; gloss retention of 85%; color change of 1 McAdam unit after 2000 hours	09360
ASTM G53 ASTM D4587 Accelerated Weathering	Blasted Steel 1 ct. Org. Zinc 1 ct. Epoxy 1 ct. 134 HG	No rusting, blistering or loss of adhesion; less than 5% gloss loss after 3000 hours	03390
ASTM B117 Salt Fog	Blasted Steel 1 ct. Org. Zinc 1 ct. Epoxy 1 ct. 134 HG	No rusting, blistering, loss of bond or any measurable creepage from the scribe after 3000 hours	03390
ASTM D3363 Hardness	Blasted Steel 1 ct. Epoxy 1 ct. 134 HG	H	09360
ASTM D2794 Impact Resistance	Blasted Steel 1 ct. 134 HG	155 inch-pounds; no visible cracking. Gardner Impact Tester	03259
ASTM D870 Immersion Resistance	Blasted Steel 1 ct. Org. Zinc 1 ct. Epoxy 1 ct. 134 HG	No rusting in the scribe; no blistering, softening or discoloration after either 30 days of freshwater immersion or 30 days of salt water immersion at 75°F	03390

Test reports and additional data available upon written request.

Application Equipment

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Spray Application (General)	This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers such as Binks, De Vilbiss, and Graco.	
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap.	
Airless Spray	Pump Ratio:	30:1 (min.)*
	GPM Output:	3.0 (min.)
	Material Hose:	3/8" I.D. (min.)
	Tip Size:	.015"-.017"
	Output PSI:	2100-2400
	Filter Size:	60 mesh
	*Teflon packings are recommended and available from the pump manufacturer.	
Brush & Roller (General)	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 75°F (24°C).	
Brush	Recommended for touch-up only. Use a medium, natural bristle brush.	
Roller	Use a short-nap synthetic roller cover with phenolic core.	

Mixing & Thinning

Mixing	Power mix Part A separately, then combine and power mix. DO NOT MIX PARTIAL KITS.	
Ratio	4:1 Ratio (A to B)	
Thinning	Spray:	Up to 25 oz/gal (20%) w/ #214
	Brush:	Up to 25 oz/gal (20%) w/ #215
	Roller:	Up to 25 oz/gal (20%) w/ #215
	Use of thinners other than those supplied or recommended by Skyline Steel may adversely affect product performance and void product warranty, whether expressed or implied.	
	XPC Thinner may also be used to thin this product to minimize HAP and VOC emissions. Consult Sheeting Solutions Technical Service for guidelines.	
Pot Life	4 Hours at 75°F (24°C) and less at higher temperatures. Pot life ends when coating becomes too viscous to use.	

Cleanup & Safety

Cleanup	User thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the MSDS for this product.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive material.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	60°-85°F (16°-29°C)	65°-85°F (18°-29°C)	65°-85°F (18°-29°C)	40-60%
Minimum	50°F (10°C)	35°F (2°C)	32°F (2°C)	10%
Maximum	100°F (38°C)	120°F (49°C)	95°F (35°C)	80%

Industry standards are for substrate temperatures to be above 5°F (3°C) the dew point.

Caution: This product is moisture sensitive in the liquid stage and until fully cured. Protect from high humidity, dew and direct moisture contact until fully cured. Application and/or curing in humidities above maximum, or exposure to moisture from rain or dew may result in a loss of gloss and/or microbubbling of the product.

Curing Schedule

Surface Temperature & 50% Relative Humidity	Dry to Recoat	Dry to Topcoat w/ Other Finishes	Final Cure
35°F (2°C)	36 Hours	36 Hours	14 Days
50°F (10°C)	16 Hours	16 Hours	10 Days
75°F (24°C)	8 Hours	8 Hours	7 Days
90°F (32°C)	4 Hours	4 Hours	5 Days

These times are based on 2.0 (50 micron) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

Packing, Handling & Storage

Shipping Weight (Approximate)	1 Gallon Kit 13 lbs (5kg)	5 Gallon Kit 57 lbs (26kg)
Flash Point (Setflash)	50°F (32°C) for Part A 106°F (23°C) for Part B	
Storage	Store indoors.	
Storage Temp. & Humidity	40°F - 110°F (4°C - 43°C) Store indoors. 0-80% Relative Humidity	
Shelf Life:	Part A: Min. 36 months at 75°F (24°C) Part B: Min. 24 months at 75°F (24°C)	* Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.