

380 Series Waterborne Acrylic Enamel

Substrates (Direct)

- Plastics¹
- Fiberglass¹
- Interior Wood

Substrates (Over primer)

- Cold rolled steel
- Hot rolled steel
- Blasted steel
- Aluminum
- Galvaneal
- Interior Wood

Suggested Primers

- Aquacron 390-9300 Series
- Aquacron 8135 Series

End Use Markets

- Doors, windows and frames
- Metal fabrication
- Transportation
- Electrical enclosures
- Industrial equipment

Product Codes

- MV380HC – High gloss clear
- MV380HW – High gloss white
- MV380LC – Low gloss clear
- MV380LW – Low gloss white

AQUACRON™ 380 Series Waterborne Acrylic is a low VOC interior/exterior enamel intended for industrial use on primed metal surfaces, ABS, fiberglass, Plexiglas and PVC plastic substrates. The very fast dry and excellent block resistance properties make this product ideal for product finishing applications requiring a quick turnaround.

Product Highlights

- Excellent block resistance
- Excellent chemical resistance
- Available in a wide range of colors and gloss
- Outstanding adhesion to a variety of substrates
- Very fast drying
- Good flexibility
- Reduction and clean-up with tap water
- VOC <1.0 lbs./gal. (120 g/L)

Physical Properties

Property	Value
Solids % by weight	34.4 – 51.7
Solids % by volume	32.1 – 38.0
Weight / Gallon	7.4 – 7.5 lbs./gal. (888 – 900 g/L)
Coverage @ 1 mil, 100% TE	502 – 610 ft. ² /gal. (47 – 57 m ² /3.785L)
60° Gloss	30-70+
Package viscosity	20 – 30" Zahn #3 Cup
VOC (less water)	2.05 lbs./gal. (246 g/L)
Shelf life	2 years

Performance Properties

Test	Result*
Pencil hardness	F - H
Conical mandrel (1/8")	Pass
Adhesion	5B, excellent
Salt Spray	250-1000 hours ²
Humidity	250 hours

*results obtained over iron phosphate CRS panels



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Substrate Protection

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating will improve the performance properties of the coating system. See your PPG Representative for recommendations.

Cure Schedule

Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.

Physical Properties

Air Dry Times³

To Touch	20 – 30 min.
To Handle	1 hour
To Topcoat	1 hour

Force Dry Times

Flash Time	15 – 20 min. (ambient)
Temperature	180 – 220°F (82 – 104°C)
Time at Temperature	10 – 30 min.

Footnotes

1. Due to the variability in plastic and fiberglass substrates, it's highly recommended to test adhesion on a small sample before application
2. Salt spray is 250 hours over iron phosphate cold rolled steel with a non-chrome sealer. This product can get up to 1,000 hours of salt spray if used in combination with the MV390-9300 Series primers and iron phosphate pretreatment and a chrome sealer.
3. Excess film thickness will retard dry times and affect the recoat window. Do not apply at temperatures below 50°F (10°C).

The technical data presented is information believed by PPG to be currently accurate; however, no guarantee of accuracy, comprehensiveness or performance is given or implied. Continuous improvements in coating technology may cause future technical data to vary from what is in this document. Product is intended for application by trained personnel in a factory or shop application. Do not attempt to use product without the current Safety Data Sheet. The performance of a product can fluctuate due to surface preparation technique, method of application, operating conditions, the material it is applied to or with, and use. It is strongly recommended that products be tested with respect to these factors prior to full scale use.

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Mix Directions

Reduction	Water, up to 10% if needed
Line/Flush Clean Up	Soap and water, TFA880-70 or MV389C

Application

Equipment	Conventional, HVLP, air-assisted airless, airless
Recommended Wet Film Build	3.0 – 4.5 mils 76 – 114 microns
Recommended Dry Film Build	1.0 – 1.5 mils 25 – 38 microns

Additional Information

In-Service Temperature: 180° (82°C)

Do not apply at temperatures below 50° (10°C)

Protect from freezing

Not recommended for use on galvanized, Galvaneal or zinc rich surfaces



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