

Product specifications of

ACRA-BOND® *ULTRA*

A versatile, environmentally-friendly conventional solids acrylic coating for the residential/light commercial market



AkzoNobel

Tomorrow's Answers Today

Architects and specifiers will find ACRA-BOND® *ULTRA* is an excellent finish for a variety of interior metal surfaces and residential window and door systems.

After many years of successful application with the original ACRA-BOND®, our research and development group has released a product that is superior to current AAMA 2603 technologies.

Test data show it to be the finest conventional solids polyester on the market today.

Why was there a need to completely re-engineer such a workhorse product like the original ACRA-BOND®? The answer was in the voice of our customers. Since the trend to return to conventional solids acrylic technology is growing with the increase in installations of VOC abatement equipment, we believe that this technology will be the coating of choice for residential and light commercial use for quite some time.

What are the features and benefits of this new system?

- Better coverage in difficult to reach areas.
- Painting the most difficult shapes beautifully the first time rather than having to depend on a second run for customer satisfaction.
- Better mileage per gallon for the applicator and therefore a lower applied cost.
- Savings in energy consumption with lower curing temperatures.
- Better flexibility with improved hardness.
- Vastly improved resistance to metal marking.
- Larger windows of forgiveness in application without sags, solvent blisters, or "pull-away" from edges.
- Excellent surface clarity.
- Greatly improved exterior durability.

To make our vision of the future complete, we offer ACRA-BOND® *ULTRA* in our EXPRESS Intermix system for exact quantity needs and exact color matching. This on-site and on-demand ability eliminates waste and reduces costs by recycling overages into new colors.

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Disclaimer

The information contained herein is correct to the best of our knowledge. It is offered in good faith, but not to be construed as warranties as to performance of results, since the conditions of use of our products are beyond our control. We suggest that you evaluate the information presented here and determine the suitability of our products prior to commercial scale application.

ACRA-BOND® *ULTRA*

product specifications

Product Type	Acrylic baked enamel.
Specification	Meets or exceeds all AAMA 2603 specifications.
Primer	None
Percent Solids (Package)	Weight solids 48-64%, Volume solids 37-45%.
Percent Solids (Reduced)	Weight solids 40-53%, Volume solids 30-34%.
Reduction	15-25% by volume of Xylene/ Butyl Carbitol blend then add Butyl Carbitol as needed for flow.
Viscosity	17-19 seconds #3 Zahn @ 77° F (package), 20-25 seconds on Zahn #2 (reduced).
Film Thickness	Standard: 2.4 to 4.0 wet mils, 0.8 - 1.2 mils dry. Coastal: 3.5 to 5.0 wet mils, 1.2-1.4 mils dry.
Gloss Range	25 to 35% @ 60° angle.
Cure Schedule	Lab bake cycle 6 minutes @ 350° F. Production cure varies with the speed, oven temperature and metal mass being painted. Temperature must achieve 350° F and be maintained for 4 minutes minimum.
Cure	H+ pencil hardness and 50 MEK double rubs.

AAMA 2603 specification

The following is part of the AAMA 2603 Specification. ACRA-BOND® *ULTRA* has physical properties which more than qualify it for extrusion application.

6.4.1.1	Dry Adhesion	No pick-off
6.4.1.2	Wet Adhesion	No pick-off
6.5.1	Direct Impact	No pick-off
6.6.1.1	Chemical Resistance	Excellent
6.6.2.1	Mortar Resistance	Pass - little or no staining
6.6.3.1	Detergent Resistance	Excellent
6.7.1.1	1500 Hour Humidity Resistance	Pass
6.7.2.1	1500 Hour Salt Spray Resistance	Pass
6.8.1.1	1000 Hour Accelerated Weathering	Pass
6.8.2.1	1 Year Outdoor Exposure	Pass
N/A	Pencil Hardness	H - 3H

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AkzoNobel is the largest global paints and coatings company and a major producer of specialty chemicals. We supply industries and consumers worldwide with innovative products and are passionate about developing sustainable answers for our customers. Headquartered in Amsterdam, the Netherlands, we are a Global Fortune 500 company and are consistently ranked as one of the leaders on the Dow Jones Sustainability Indexes. With operations in more than 80 countries, our 55,000 people around the world are committed to excellence and delivering Tomorrow's Answers Today™.

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