

## AIRLESS SPRAYER RECOMMENDATIONS

The preferred method of applying **ACRYLINK G™** is with a conventional airless sprayer. Not only does using an airless sprayer tend to produce a membrane of more consistent thickness and better appearance but tends to reduce labor costs substantially by greatly increasing efficiency.

### Minimum Requirements for spraying **ACRYLINK G™**:

- 2500 psi of pressure
- 30:1 pump
- 1.5 gpm minimum

An airless can be powered either by gas, compressed air, or electricity. Those powered by compressed air require an air compressor (consult airless manufacturer for recommendations), while the other types are generally self-contained.

The **suction tube** should be a minimum of 1½ inches in diameter. In order to prevent the drum liner from fouling the suction tube, **IPC** recommends drilling three or four holes in the suction tube, about ½ inch from the end. Some suction tubes come with a wire-mesh screen attachment. Since **ACRYLINK G™** is strained in the manufacturing process, this attachment generally will serve no purpose. As long as there are no more than 40 wires per inch, using the screen attachment should not restrict suction significantly.

**Hose size** depends largely on the distance from the airless to the nozzle. If this distance is over 150 feet, then the inside diameter of the hose should be at least ½ inch. If this distance is less than 150 feet, then the inside diameter of the hose should be at least ¾ inch. **IPC** recommends that a ¼ inch whip be used for the last 15 to 25 feet of hose before the nozzle. Please consult manufacturer for further recommendations.

**Tip size** depends largely on the spray rate capabilities of the airless. An airless that is intended to spray at a rate of 1 gallon per minute will generally require a .025" tip. On the other hand, an airless rated at 3½ gallons per minute will generally require a .046" tip.

If an **extension** is to be used with the sprayer, the tip should have at least a 60° fan angle. If no extension is used, a 40° fan angle will work better. Thus, for example, an airless rated at 3½ gallons per minute with a spray extension would require approximately a 646 tip, while a 1 gallon per minute sprayer without an extension would use approximately a 425 tip.

Under normal circumstances, **ACRYLINK G™** can be applied without significant overspray. Lowering the pressure or increasing the tip size has been found to minimize overspray.