

FACTORY PACK ACRYLIC ENAMEL



- Fast Drying
- Can be Applied as a Basecoat
- Outstanding Gloss
- Selection of 18 Popular Colors
- Can be Applied with or without Activator



AVAILABILITY

Colors	Size	Additive	Size
AAE-1000-1 AE WHITE	GAL	AAE-0140-4 AE BASECOAT MAKER	QT
AAE-1014-1 AE ARCTIC WHITE	GAL		
AAE-1002-1 AE FLEET WHITE	GAL	Activator (Optional)	
AAE-1414-1 AE PERFORMANCE WHITE	GAL	ACH-1021-6 AE WET LOOK (HRD 1/4 PT)	HP
AAE-3000-1 AE BRIGHT YELLOW	GAL	ACH-1021-8 AE WET LOOK HARDENER	PT
AAE-3001-1 AE NEW CAT YELLOW	GAL		
AAE-4000-1 AE ORANGE	GAL	Recommended Reducers	
AAE-5000-1 AE PORSCHE RED	GAL	AUR-0730 SUPER-FLOW AUR - MOD	GAL/QT
AAE-5501-1 AE CANDY APPLE RED	GAL	AUR-0750 SUPER-FLOW AUR - HOT	GAL/QT
AAE-5502-1 AE DARK RED METALLIC	GAL	AUR-0760 SUPER-FLOW AUR - EXT HOT	GAL/QT
AAE-6001-1 AE FOREST GREEN	GAL	AUR-0600 FAST URETHANE REDUCER	GAL/5GL
AAE-6500-1 AE BRIGHT TEAL METALLIC	GAL	AUR-0610 MED URETHANE REDUCER	GAL/QT/5GL
AAE-7000-1 AE DARK BLUE	GAL	AUR-0620 SLOW URETHANE REDUCER	GAL/5GL
AAE-7500-1 AE CANYON BLUE METALLIC	GAL	AUR-0630 X-SLOW URETHANE REDUCER	GAL/5GL
AAE-7501-1 AE DARK BLUE METALLIC	GAL	AAR-0500 FAST ACRYLIC ENAMEL REDUCER	GAL/5GL
AAE-9000-1 AE BLACK	GAL	AAR-0510 MED ACRYLIC ENAMEL REDUCER	GAL/QT/5GL
AAE-9020-1 AE LIGHT GRAY METALLIC	GAL	AAR-0520 SLOW ACRYLIC ENAMEL REDUCER	GAL/5GL
AAE-9021-1 AE DOVE GRAY	GAL	AAR-0530 X-SLOW ACRYLIC ENAMEL REDUCER	GAL/5GL

ACRYLIC ENAMEL

PHYSICAL PROPERTIES

Pot Life	4 hours with hardener	Inter Coat Adhesion	Excellent
Flash Point	65°F to 80°F	Reparability Catalyzed	Excellent
Dry Film Build	2 to 3 mils	Humidity Resistant	Excellent
Sprayable Viscosity (RTS)	20-22" #2 Zahn Cup		
VOC (RTS)	<5.0 (lb/gal)		
Weight Solids (RTS)	44.7% to 59.9%		

DRY TIMES @ 70°F

AS A SINGLE STAGE

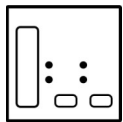
Flash	Until Hand Slick (approximately 15 to 20 min).
To Clearcoat	Overnight
Sand & Buff	Per manufacturer's recommendation

AS A BASECOAT

Flash	Until Hand Slick (approximately 15 to 20 min).
To Clearcoat	1 hour
Sand & Buff	Per manufacturer's recommendation

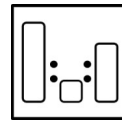
NOTE: All tests are performed at 70°F, higher temperatures will provide faster drying times. **DO NOT BUFF SINGLE STAGE COLOR.** ACH-1021 Wet Look Hardener must be added to the single stage color before clearcoating.

MIX RATIO AS A SINGLE STAGE



8	Parts Color	AE Color
1	Part Reducer	AUR Series Urethane Reducer or AAR Series Acrylic Enamel Reducer.
1	Part Hardener	ACH-1021 Wet Look Hardener (Optional)

MIX RATIO AS A BASECOAT



4	Parts Color	AE Color
1	Part Basecoat Maker	AAE-0140-4 Basecoat Maker
3	Parts Reducer	AUR Series Urethane Reducer or AAR Series Acrylic Enamel Reducer.

Note: Metallic Color Only

NOTE: For best results, use AUR-0730, 0750 or 0760 SUPER FLOW urethane reducer.

SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.3 to 1.5 mm	7 to 10 PSI at the cap
RP type	1.3 to 1.4 mm	45 to 55 PSI

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 65°F will severely retard dry times and through cure.

RECOMMENDED BARE METAL PRIMERS

- AXIS EPOX-PRIME & SEAL—APR-123 SERIES
- AXIS 1K ETCHING PRIMER—APR-1241
- AXIS ULTRAPRIME DTM—APR-1251

RECOMMENDED 2K PRIMER SURFACERS

- VERSAPRIME 2K HB—APR-126 SERIES
- AXIS ULTRAPRIME DTM—APR-1251

SURFACE PREPARATION



1. Clean vehicle with soap and water and allow it to dry, then wipe with AXIS PRE-CLEAN, using generous amounts and changing rags frequently.
2. Sand area as necessary to remove any rust or corrosion, repair all body damage.
3. Prime exposed metal with any of the recommended bare metal primers.
4. Prime repaired areas with VERSAPRIME 2K HB.
5. Block sand primed bodywork with 400P grit or finer wet or dry sandpaper. Clean area to be painted with AXIS PRE-CLEAN.
6. Seal vehicle with AXIS VERSASEAL.

REDUCER SELECTOR

Temperature Range	Recommended Reducer		
	Moderate	Hot Weather	Extremely Hot Weather
65-80°F	Yes		
80-95°F	Yes	Yes	
95°F or more		Yes	Yes

GENERAL INFORMATION

- Always consider the following when choosing a reducer: the size of the vehicle (is it a bus or a fender?), the temperature, humidity and air movement.
- Follow the recommendations in the reducer selector table for best results.

SPRAY GUN ADJUSTMENT

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise 1 and 1/4 turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

Note: Proper spray gun adjustment will determine the final finish, improper adjustment may cause paint defects such as orange peel, runs, sags and poor drying.



APPLICATION

- Apply two to three medium wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approximately 15-20 min.) before applying the next coat. A cross coat may be necessary to even out metallic colors.
- Application of a urethane clear will allow for better UV protection, long term durability, and buffability.
- It is recommended not to sand and buff metallic colors. If sanding and buffing, apply 2-3 coats of a urethane clear.
- Activator must be used in the single stage color when applying a urethane clear as the final coat. Dry times are dependant of shop conditions .
- Allow color to dry overnight before applying two to three coats of urethane clear.
- Allow the clear to dry per manufacturer's recommendation before sanding and buffing.

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

PRODUCT SAFETY INFORMATION

Before using any AXIS Product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.