

PRODUCT FEATURES

- ❖ Fast drying
- ❖ Can be applied directly over bare metal
- ❖ Outstanding gloss
- ❖ Selection of 13 colors
- ❖ Can be applied with or without activator
- ❖ No dieback when used as directed



AVAILABILITY

Color Part (A)	Unit	PC	Hardener Part (B)	Unit	PC
AME-2005-1 Flat Black	Gallon	2	AME-2071-1 Synthetic Enamel Harder	Pint	6
AME-2007-1 Gloss Black	Gallon	2			
AME-2007-5 Gloss Black	Five	1			
AME-2010-1 Pure White	Gallon	2			
AME-2010-5 Pure White	Five	1			
AME-2011-1 Off White	Gallon	2			
AME-2021-1 Olympic White	Gallon	2			
AME-2062-1 Ford Blue	Gallon	2			
AME-2071-1 John Deere Yellow	Gallon	2			
AME-2077-1 John Deere Green	Gallon	2			
AME-2146-1 New Caterpillar	Gallon	2			
AME-2235-1 Ford Gray	Gallon	2			
AME-2263-1 Machinery Gray	Gallon	2			
AME-2289-1 Silver	Gallon	2			
AME-2325-1 Inter. Harvester Red	Gallon	2			

Note: 5 gallon containers are available by special request only.

PHYSICAL PROPERTIES

Colors	See Color Chart
Pot Life	4 hours with hardener
Flash Point	55°F to 70°F
Sprayable Viscosity (RTS)	
Mixed 8:1 with activator	25-30" #2 Zahn Cup
Mixed 8:1 with ASR series reducer	22-26" #2 Zahn Cup
Recommended Dry Film Thickness	0.8-1.2 mils/coat

Weight Solids (RTS)	43% to 51%
Reparability Catalyzed	Excellent
Inter Coat Adhesion	Excellent
Humidity Resistant	Excellent
Gloss (all colors except silver)	90+ GU on a 60° Gloss Meter
Gloss (silver)	70+ GU on a 60° Gloss Meter
VOC (RTS)	
Mixed 8:1 with activator	<4.72 (lb./gal)
Mixed 8:1 with ASR series reducer	<4.92 (lb./gal)

RECOMMENDED BARE METAL PRIMERS

- ❖ EPOX-PRIME & SEAL - APR-123 series epoxy primer
- ❖ SELF ETCHING PRIMER 1K - APR-124 series self etching primer
- ❖ 1:1 WC Pre-Treatment - APR-1281 series etching primer

RECOMMENDED 2K PRIMERS SURFACERS

- ❖ VERSAPRIME 2K HB – 2K Primer Surfacer
- ❖ SUPERBUILD 2.1 HB – 2K Primer Surfacer

MIX RATIO WITH ACTIVATOR



8 Color
1 ACH-1010 series activator

MIX RATIO WITHOUT ACTIVATOR



8 Color
1 ASR series reducer

DRY TIMES @ 70°F



Dust free	20 minutes
Flash time	Until hand slick (approx. 15-20 minutes)

Print free	5 hours
Force dry	Flash for 15 minutes then bake @ 140°F

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure. One-half (½) fluid ounces of AXIS 2K PERFORMANCE ACCELERATOR per mixed quart may be added to improve cure response in adverse facility conditions.

SPRAY GUN ADJUSTMENTS



- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise 2¼ full turns. If additional adjustment is needed, open or close knob ¼ 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 orange peel, runs, poor drying, and poor adhesion just to name a few.

SPRAY GUN SETUP



Gravity HVLP	1.3-1.4 mm	7-10 PSI
Siphon HVLP	1.3-1.4 mm	7-10 PSI
Conventional	1.3-1.4 mm	45-55 PSI
Airless Assist	1.3 mm	Refer to equipment manual for proper adjustment

SURFACE PREPARATION



1. Clean surface with plenty of 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. For corrosion protection, prime large areas of exposed metal with any of the recommended bare metal primers.
4. Prime repaired areas with any of the recommended 2K primer surfacers.
5. Block sand primed bodywork with 400P grit or finer wet or dry sandpaper. Clean area to be painted with AXIS PRE-CLEAN.
6. Final sand the repair area with machine / DA (#400P grit or finer) sandpaper and re-wipe vehicle with AXIS PRE-CLEAN.
7. Seal vehicle with AXIS VERSASEAL.

APPLICATION



- ❖ Clean vehicle with AXIS PRE-CLEAN before painting.

SOLID COLORS

- ❖ Apply 2 to 3 medium wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approx. 10-15 min.) before applying the next coat.

METALLIC COLORS

- ❖ Apply 1 tack coat from a distance of 6 to 8 inches; allow tack coat to become hand slick (aprox. 10-15 min.) before applying the next coat. Follow with 2 medium wet coats; allow proper flash time between coats.

EQUIPMENT CLEANUP



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 4 hours @ 55-70°F or more than 2 hour @ >70°F.

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.

For more detailed recommendations, please contact your local Axis Performance Coatings distributor. These products may require several components and must be mixed properly to comply with VOC regulations. These products are not recommended as part of a multi-coat system if the VOC exceeds local, state or Federal regulations.

LIMITED WARRANTY

The recommendation for applications of this product are based on data obtained by our research facilities and is believed to be accurate. The manufacturer warrants all materials sold by it against defect in the material, but does not warrant its fitness for any specific application or use. Product warranty can be restricted to replacement of materials only. No other warranty, written or oral, is expressed or implied.