

5.0 VOC - 2K Acrylic Basecoat (Full Fill)

TECHNICAL DATA SHEET

PRODUCT FEATURES

Easy to apply ◇ Superior flow-out and leveling ◇ Outstanding durability ◇ Extremely flexible ◇ High gloss & "mirror like" D.O.I. ◇ Economical to use ◇ Excellent abrasion & chip resistance ◇ Outstanding chemical resistance

RECOMMENDED BARE METAL PRIMERS

EPOX-PRIME & SEAL (Gray, Black & White)
 SELF ETCHING PRIMER – 1K (Gray, Black)

RECOMMENDED PRIMER SURFACER

VERSAPRIME 2K HB
 SUPERBUILD 2K 2.1

PHYSICAL PROPERTIES



Mix Ratio	8:1:4
Pot Life	6 hours
Flash Point	>22°F
Color & Gloss Retention	Excellent
Theoretical Dry Film	480-512 sq.ft./1 mil-
Sprayable Viscosity (RTS)	18-20 sec
Recommended Dry Film Build	1.0-1.5 mil
Weight Solids	36-42%
Volume Solids	30-32%
Flexibility	Excellent
Chip Resistance	Excellent
Gloss (Metallic Colors)	Matte
Gloss (Solid Colors)	Matte
Gasoline Resistance	Excellent
Repair ability	Excellent
Florida Exposure	Excellent
Density	9.0 + 6
Humidity Resistance	Excellent
Pencil Hardness	2H

VOC. INFORMATION

Material	V.O.C.: <510g/l (4.25 #/gal)
Coating	V.O.C.: <510g/l (4.25 #/gal)
RTS coating	V.O.C.: <600g/l (5.0 #/gal)

MIXING RATIO



8 parts	Color
1 part	K-17, K-18 or K-19
4 parts	ALR series 2.1 VOC Urethane Reducer

SURFACE PREPARATION

General Procedure

- Clean vehicle with soap and water to remove any dirt or grime.
- Wipe vehicle with AXIS PRE-CLEAN, using generous amounts and changing rags frequently.
- Sand area as necessary by hand or machine to remove any rust or corrosion, repair all body damage.
- Prime bare metal with any of the recommended bare metal primers. Use a 2K primer surfacer when needed to fill sand scratches
- Final sand all areas with Machine / D.A. (#320 grit or finer) sandpaper.
- Re-wipe vehicle with AXIS PRE-CLEAN.

PENTAD 54 SERIES

PART (A) 5.0 2K ACRYLIC BASECOAT (Full Fill)

PART (B) K-17, K-18 or K-19 Activator



GUN SETUP



Gravity HVLP	1.3–1.4 mm	7-10 PSI
Siphon HVLP	1.3–1.4 mm	10 PSI
Conventional	1.3–1.4 mm	50-55 PSI

Note: The pressure on a HVLP gun is measured at the cap, on a conventional gun, pressure is measure at the gun.

APPLICATION INSTRUCTIONS

- Adjust air pressure to 50-55 psi at the gun if using a conventional gun or 10 PSI at the cap for HVLP's
- Apply 2-3 medium wet coats of PENTAD urethane color, as needed, allowing 20 minutes flash time between coats.
- On metallic colors a cross coat might be necessary to even out the metallic's and to avoid mottling.

DRY TIMES

By Air @ 77°F



Flash	15 - 20 minutes
To Tape	1.5 hours
To Clearcoat	1 hour

Force Dry



Purge	15 minutes
Dry @ 140°F	20 minutes
Cool Down	30 minutes

CLEANNING

Clean equipment with a quality lacquer thinner such as AXIS ALT series or a quality urethane reducer such as AXIS AUR series. Do not leave catalyzed product in the gun more than 8 hours @ 55-70°F or more than 4 hours @ >70°F.

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 75°F. Temperatures below 60°F will severely retard dry times and thorough cure. One (1) to one-half (½) fluid ounces of AXIS 2K PERFORMANCE ACCELERATOR per mixed quart may be added to improve cure response in adverse facility conditions.

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. Do not permit anyone without protection in the painting area. Only professional, trained painters intend this product for industrial use. 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 V.O.C. regulations. These products are not recommended as part of a multi-coat system if the V.O.C. exceeds local, state or Federal regulations.

Limited Warranty

The technical data and suggestions for use contained in this document are true and correct to the best of our knowledge at the date of issuance. The statements of this document do not constitute a warranty, expressed or implied, as to the performance of these products. Since Vogel Automotive Coatings does not control the application of its products, or the condition of the surfaces to which they are applied, Vogel Automotive Coatings liability will under no circumstances exceed replacement of the product.