

PRODUCT FEATURES

- Compatible with a Wide Range of Topcoats
- Fast Drying
- No Sanding Necessary

SUBSTRATES

Properly sanded and treated:

- Steel
- Aluminum
- Body Filler
- Galvanized
- Fiberglass
- OEM Finishes
- Some Plastics

PHYSICAL PROPERTIES

Colors	Green
Mix Ratio	1:1
Pot Life	6 hours
Flash Point	25°F
Sprayable Viscosity (rts)	17-20 sec. #2 Zahn Cup
Recommended Dry Film Build	0.5 mils
Weight Solids (rts)	15.27%
Color Holdout	Excellent
Salt Spray Resistance	Excellent
VOC (rts)	5.71 lbs/gal 684.29 g/L

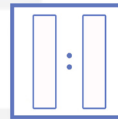
DRY TIMES @ 70 °F



To Sand (if necessary to remove dust particles)	2 hours
To Topcoat	30 minutes
Air Dry	30 minutes
Force Dry	Flash for 10 mins then force dry @140°F for 20 minutes.

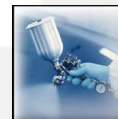


MIX RATIO



1 Part Pre-Treatment	APR-1281-1 or 1281-4
1 Part Acid Converter	BPR-1280-1 or 1280-4

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	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.

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.

1:1 WC PRE-TREATMENT

Part (A): APR-12811 & 12814 - Pre-Treatment

Part (B): BPR-12801 & 12804 - Acid Converter



SURFACE PREPARATION



- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean dry cloth, then clean with AXIS PRE-CLEAN, using generous amounts and changing rags frequently prior to painting.
- Sand area as necessary to remove any rust or corrosion, then repair all body damage.
- Sand old finishes with 320-400 grit dry by hand or machine or 400 grit wet.
- Prime exposed metal with AXIS 1:1 WC PRE-TREATMENT.
- If filling is required, prime area with SUPERBUILD 2K high build primer surfacer.
- Sand vehicle with 320 grit or finer D.A. or hand sand with 400 grit or finer wet or dry sandpaper.
- Re-wipe vehicle with AXIS PRE-CLEAN.
- Seal vehicle AXIS VERSASEAL 2K sealer.

APPLICATION



- Apply 1 medium wet coat allowing a minimum of 60 minutes before topcoating with a 2K primer, polyester primer or paint. Film build is approximately 0.5 mils per coat (dry film).

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 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 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.