

Advanced Industrial Coatings

3.5 VOC Acrylic Enamel

Product Data Sheet

K2 Series

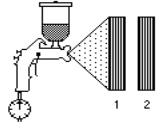
APPLICATION

Overall

1. Adjust air pressure at the gun to 55-65 psi Conventional Pressure Feed (adjust pot pressure to 8-15 fluid ounces per minute delivery).
2. For Conventional Pressure Feed, apply 2 medium coats at a gun distance of 8-10 inches. Spray to hiding. For HVLP, apply 1 full wet coat with 50% overlap, applying the second coat in a cross-coat method. Recommended dry film thickness is 2.0-2.5 mils.
3. Clean spray gun immediately after use with Gun and Equipment Cleaner.

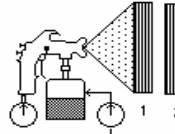
HVLP

Apply 1 full wet coat
With 50% overlap.



Conventional Pressure Feed

Apply 2 medium coats.
Allow each to become hand slick



Equipment

HVLP
Fluid Tip 1.4 -1.5 mm
Fluid Delivery 8-15 oz./min.
Atomizing Air 8-10 psi @ Tip
Apply 1 full wet coat with 50% overlap
Using a cross-coat technique

Conventional Pressure Feed
0.70/1.8 mm
8-15 oz./min.
55 - 65 psi @ Gun
Apply 2 medium coats

DRYING SCHEDULE

Dry times are based on dry film thickness of 2.0 - 2.5 mils; thicker films will extend drying times.

Air dry times @ 75°F and 50% Relative Humidity:

	<u>Unaccelerated</u>	<u>Accelerated</u> Up to 8 oz. AIC440/AIA200 per sprayable gal
- Dust free	2 hours	1 hour
- Tack free	3 hours	2 hours
- Tape free	4 hours	3 hours
- Nib Sand	8 hours	4 hours

Force dry times:

<u>Temperature</u>	<u>Tape Free</u> <u>Unaccelerated</u>	<u>Tape Free with 8 oz.</u> <u>AIC440/AIA200 per sprayable gal</u>
140°F	80-120 minutes	60 minutes
160°F	60-80 minutes	45 minutes
180°F	45-60 minutes	30 minutes

NOTES

- Decals may be applied after air-drying 72 hours at 75°F. Lower temperatures, heavy film thickness, poor air movement, thick decals, foil-based decals, etc., will extend the 72 hour dry time before decals may be applied.
- Infrared Recommendation: 10 min. on low for flash and 20 min. on high until firm. Lamp should be no closer than 36 inches.
- Recoat before 8 hours or after 48 hours to prevent lifting. AIC K2 series can be recoated with itself before 8 hours or after 48 hours and up to 2 weeks after initial application. After 2 weeks sanding is required.

PERSONAL PROTECTION

- Read all label directions before use
- Refer to MSDS for specific information
- Wear a NIOSH approved organic vapor respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, respirator and latex gloves when using product.

To learn more about Advanced Industrial Coatings Products, call 1-888-813-2263.

AS2744
03/24/09