



# Advanced Industrial Coatings

## 3.5 VOC Acrylic Enamel

### K2 Series

## PRODUCT OVERVIEW

Advanced Industrial Coatings 3.5 VOC Acrylic Enamel is a two-component acrylic enamel topcoat system for properly prepared and/or primed metal surfaces. Advanced Industrial Coatings is an easy-to-use, high gloss, durable, chemical and solvent resistant coating that can be air dried or force dried. The AIC™ K2 series is an intermix color system that is extremely versatile and cost effective. It is recommended for use on industrial applications that require good hiding and good sag-resistance. The 3.5 VOC acrylic enamel also has a 1K option if such properties are desired.



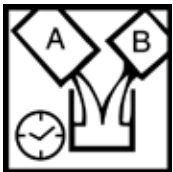
### SUITABLE SUBSTRATES

- Cold rolled steel
- Hot rolled steel
- Fiberglass
- ABS & PC/ABS
- Aluminum

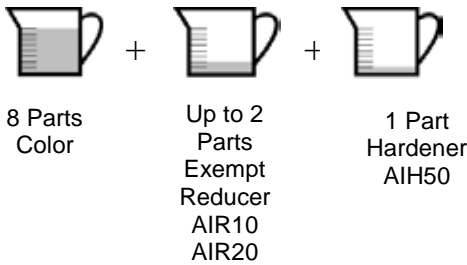
### SUITABLE PRIMERS

- AIP 100 Series Primers
- AIP 200 Series Primers

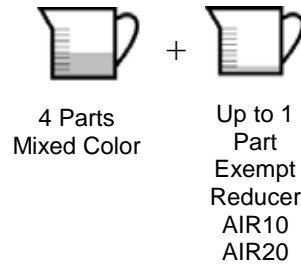
**Note:** AIC™ 3.5 Acrylic Enamel K2 Series can be applied directly to these substrates if surface preparation recommendations are followed.



### MIXING



### (Optional 1K Mix Ratio)



To speed dry time of the 2K product, add up to 8 ounces of the AIA200 accelerator per sprayable

To speed dry time of the 1K product, add up to 8 ounces of the AIC440 drier per sprayable gallon.



### APPLICATION

1. HVLP: Adjust air pressure at cap to 8-10 psi.
2. Conventional: Adjust air pressure at the gun to 45-60 psi for pressure feed applications with a fluid delivery of 8-15 ounces per minute.
3. 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.
4. Clean spray gun immediately after use with Gun and Equipment Cleaner.



### DRYING SCHEDULE

#### 2K Mix Drying Schedule

#### Air Dry Times

#### Unaccelerated

- Nib Sandable: 1 hour
- Dust Free: 1 hour
- Tack Free: 2 hours
- Tape Free: 3 hours
- Sandable: 4-6 hours

NOTE: See Dry Schedule in Product Data Sheet for Force Dry information

#### (Optional 1K Mix Ratio)

#### Air Dry Times

- Nib Sandable: 1 hour
- Dust Free: 2 hours
- Tack Free: 3 hours
- Tape Free: 4 hours
- Sandable: 8 hours



### PERSONAL PROTECTION

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



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# PRODUCT DATA SHEET



## SURFACE PREPARATION

- § Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth.
- § Solvent clean with the appropriate Low VOC Surface Cleaner and wipe dry with a clean cloth.
- § If doing repair, grind repair area to remove paint and all rust as needed
- § Sand all areas to be primed and featheredge all broken film areas. Then solvent clean with the appropriate cleaner.
- § Prime with AIP primer.



## SUITABLE SUBSTRATES

- Cold rolled steel
- Hot rolled steel
- Fiberglass
- ABS & PC/ABS
- Aluminum

**Note:** AIC™ 3.5 Acrylic Enamel K2 Series can be applied directly to these substrates if surface preparation recommendations are followed.

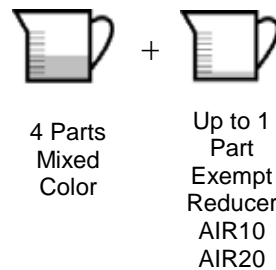
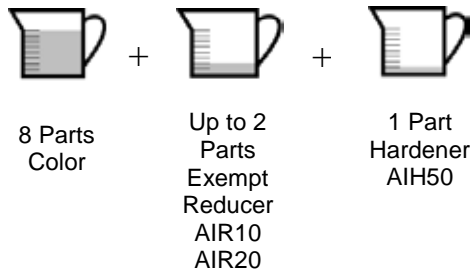
## SUITABLE PRIMERS

- AIP 100 Series Primers
- AIP 200 Series Primers



## MIXING

- Stir or shake AIC K2 series thoroughly before mixing.
- Mix by volume 8 parts AIC K2 series color, with up to 2 parts of AIR10 / AIR20 reducer and 1 part AIH50 hardener.
- Stir thoroughly and strain before use.
- Pot life: 4 hours at 70°F. With accelerator AIC440 / AIA200 pot life: 3 hours at 70°F.
- 1K option pot life: Extended pot life 7 days
- To speed dry time of the 1K product, add up to 8 ounces of the AIC440 drier per sprayable gallon.
- To speed dry time of the 2K product, add up to 8 ounces of the AIA200 accelerator per sprayable gallon.



speed dry time of the 2K product, add up to 8 ounces of the AIA200 accelerator per sprayable

To speed dry time of the 1K product, add up to 8 ounces of the AIC440 drier per sprayable gallon.

REDUCER	TEMPERATURE RANGE
AIR10	50-75°F
AIR20	75-90°F



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## PRODUCT DATA SHEET



### APPLICATION

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2. Conventional: Adjust air pressure at the gun to 45-60 psi for pressure feed applications with a fluid delivery of 8-15 ounces per minute.
3. 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.
4. Clean spray gun immediately after use with Gun and Equipment Cleaner.

### EQUIPMENT

#### Gun Type

Conventional Pressure Feed  
HVLP Pressure Feed

#### Nozzle

0.8-1.4 mm at 8-15 oz/min  
0.8-1.2 mm at 8-15 oz/min

#### Air Pressure

45-60 psi  
8-10 psi at cap

### RECOAT

- § 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 14 days after initial application without sanding or scuffing. After 14 days, sand or scuff before recoating.



### 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 at 75°F and 50% relative humidity.

#### **Air Dry Times**

##### Unaccelerated

Nib Sandable: 1 hour  
Dust Free: 1 hour  
Tack Free: 2 hours  
Tape Free: 3 hours  
Sandable: 4-6 hours

#### **(Optional 1K Mix Ratio)**

##### **Air Dry Times**

Nib Sandable: 1 hour  
Dust Free: 2 hours  
Tack Free: 3 hours  
Tape Free: 4 hours  
Sandable: 8 hours

#### **Force Dry Times**

<u>Temperature</u>	<u>Time to Tape Free</u>
140°F	80-120 minutes
160°F	60-80 minutes
180°F	45-60 minutes

#### **Force Dry Times**

<u>Temperature</u>	<u>Time to Tape Free</u>
140°F	80-120 minutes
160°F	60-80 minutes
180°F	45-60 minutes

- To speed dry time of the 1K product, add up to 8 ounces of the AIC440 drier per sprayable gallon.
- To speed dry time of the 2K product, add up to 8 ounces of the AIA200 accelerator per sprayable gallon.

### 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 minutes on low for flash and 20 minutes on high until firm. Lamp should be no closer than 36 inches.



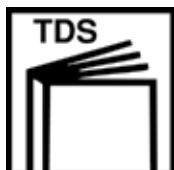
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# PRODUCT DATA SHEET

## TECHNICAL DATA



<b>Mixing Ratio by Volume</b>	8:2:1	<b>Recommended Film Thickness</b>	2.0-2.5 mils
<b>Max VOC @ 8:2:1</b>	3.5 lbs/gal	<b>Hours of Xenon 1000</b>	No Effect
<b>Ready to Spray Volume Solids (White)</b>	40 %	<b>Salt Spray Resistance 250 hrs</b>	1/8" creepage
<b>Coverage @ 1 mil dry (white)</b>	800 FT <sup>2</sup> /gal	<b>10% Sulfuric Acid</b>	Slight Effect
<b>Pot Life</b>	4 hours at 70°F 3 hours at 70°F with accelerator	<b>Humidity 100 hours</b>	Slight Effect
<b>Viscosity (sprayable) Gardener #2 Zahn Cup (ISO calibrated)</b>	18-25 sec	<b>Flexibility (1/8" conical mandrel)</b>	Excellent

K2 Series-with hardener	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
<b>Density</b>	8.18	979	7.91	947
	<b>% by Wt.</b>	<b>% by Vol.</b>	<b>% by Wt.</b>	<b>% by Vol.</b>
<b>Volatiles</b>	47.6	55.6	55.4	63.4
<b>Solids</b>	52.4	44.4	44.6	36.6
<b>Water</b>	0	0	0	0
<b>Exempt Compounds</b>	10.9	13.3	23.4	27.9
	Lb/Gal	G/L	Lb/Gal	G/L
<b>VOC Total</b>	2.99	359	2.53	303
<b>VOC Less Exempt</b>	3.46	414	3.50	420
	Lb/Gal	KG/L	Lb/Gal	KG/L
<b>HAPs</b>	3.51	0.421	3.10	0.372

K2 Series-without hardener	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
<b>Density</b>	8.18	979	7.86	941
	<b>% by Wt.</b>	<b>% by Vol.</b>	<b>% by Wt.</b>	<b>% by Vol.</b>
<b>Volatiles</b>	47.6	55.6	56.4	64.5
<b>Solids</b>	52.4	44.4	43.6	35.5
<b>Water</b>	0	0	0	0
<b>Exempt Compounds</b>	10.9	13.3	25.8	30.7
	Lb/Gal	G/L	Lb/Gal	G/L
<b>VOC Total</b>	2.99	359	2.39	287
<b>VOC Less Exempt</b>	3.46	414	3.46	414
	Lb/Gal	KG/L	Lb/Gal	KG/L
<b>HAPs</b>	3.51	0.421	3.51	0.149

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