

FACTORY PACK ACRYLIC ENAMEL

PRODUCT FEATURES

- Fast Drying
- Can be Applied as a Basecoat
- Outstanding Gloss
- Selection of 18 Popular Colors
- Can be Applied with or without Activator



AVAILABILITY

Colors		Size	Per Case	Additive		Size	Per Case
AAE-1000-1	AE WHITE	GAL	2	AAE-0140-4	AE BASECOAT MAKER	QT	6
AAE-1001-4	AE ARCTIC WHITE	GAL	2	Activator (Optional)			
AAE-1002-1	AE FLEET WHITE	GAL	2				
AAE-1414-1	AE PERFORMANCE WHITE	GAL	2				
AAE-3000-1	AE BRIGHT YELLOW	GAL	2	ACH-10216	AE WET LOOK (1/4 PT) HRD	HP	6
AAE-3001-1	AE NEW CAT YELLOW	GAL	2	ACH-1021-8	AE WET LOOK HARDENER PINT	PT	6
AAE-4000-1	AE ORANGE	GAL	2	Recommended Reducers			
AAE-5000-1	AE PORSCHE RED	GAL	2	AUR-0730-1	SUPER-FLOW AUR - MOD	GAL	2
AAE-5501-1	AE CANDY APPLE RED	GAL	2	AUR-0730-4	SUPER-FLOW AUR - MOD	QT	4
AAE-5502-1	AE DARK RED METALLIC	GAL	2	AUR-0750-1	SUPER-FLOW AUR - HOT	GAL	2
AAE-6001-1	AE FOREST GREEN	GAL	2	AUR-0750-4	SUPER-FLOW AUR - HOT	QT	4
AAE-6500-1	AE BRIGHT TEAL METALLIC	GAL	2	AUR-0760-1	SUPER-FLOW AUR - EXT HOT	GAL	2
AAE-7000-1	AE DARK BLUE	GAL	2	AUR-0760-4	SUPER-FLOW AUR - EXT HOT	QT	4
AAE-7500-1	AE CANYON BLUE METALLIC	GAL	2				
AAE-7501-1	AE DARK BLUE METALLIC	GAL	2				
AAE-9000-1	AE BLACK	GAL	2				
AAE-9020-1	AE LIGHT GRAY METALLIC	GAL	2				
AAE-9021-1	AE DOVE GRAY	GAL	2				

Activator (Optional)

ACH-10216	AE WET LOOK (1/4 PT) HRD	HP	6
ACH-1021-8	AE WET LOOK HARDENER PINT	PT	6

Recommended Reducers

AUR-0730-1	SUPER-FLOW AUR - MOD	GAL	2
AUR-0730-4	SUPER-FLOW AUR - MOD	QT	4
AUR-0750-1	SUPER-FLOW AUR - HOT	GAL	2
AUR-0750-4	SUPER-FLOW AUR - HOT	QT	4
AUR-0760-1	SUPER-FLOW AUR - EXT HOT	GAL	2
AUR-0760-4	SUPER-FLOW AUR - EXT HOT	QT	4

PHYSICAL PROPERTIES

Pot Life	4 hours with hardener	Inter Coat Adhesion	Excellent
Flash Point	65°F to 80°F	Reparability Catalyzed	Excellent
Dry Film Build	2 to 3 mils	Humidity Resistant	Excellent
Sprayable Viscosity (RTS)	20-22" #2 Zahn Cup		
VOC (RTS)	<5.0 (lb/gal)		
Weight Solids (RTS)	44.7% to 59.9%		

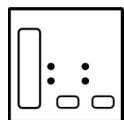
DRY TIMES @ 70°F



Air Dry		Force Dry
Flash	Until Hand Slick (approximately 15 to 20 min).	Flash for 15 minutes then bake @ 120°F for 30 minutes.
To Clearcoat	Overnight	Note: 1. Only use slow reducer when force drying. 2. Allow vehicle cool down to room temperature before sanding and buffing.
Sand & Buff	12 to 16 hours	

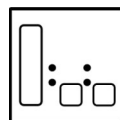
Note: All tests are performed at 70°F, higher temperatures will provide faster buffing times.

MIX RATIO AS A SINGLE STAGE



8	Part Color	AE Color
1	Part Reducer	SUPER-FLOW Reducer (see availability table for options)
1	Part Hardener	ACH-1021 Wet Look Hardener (Optional)

MIX RATIO AS A BASECOAT



4	Part Color	AE Color
1	Part Reducer	AAE-0140-4 Basecoat Maker
3	Part Hardener	AUR Series Urethane Reducer

Note: Metallic Color Only

SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.2 to 1.4 mm	7 to 10 PSI
Conventional	1.3 to 1.4 mm	45 to 55 PSI

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 65°F will severely retard dry times and through cure.

Note: For best results, a conventional gun is recommended.

RECOMMENDED BARE METAL PRIMERS

1. AXIS EPOX-PRIME & SEAL—APR-123 SERIES
2. AXIS 1K ETCHING PRIMER—APR-124 SERIES
3. AXIS ULTRAPRIME—APR-1251-1

RECOMMENDED 2K PRIMER SURFACERS

1. VERSAPRIME 2K HB—APR-126 SERIES
2. AXIS ULTRAPRIME—APR-1251-1

SURFACE PREPARATION



1. Clean vehicle with plenty 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. Prime exposed metal with any of the recommended bare metal primers.
4. Prime repaired areas with VERSAPRIME 2K HB.
5. Block sand primed bodywork with 400P grit or finer wet or dry sandpaper. Cleanse area to be painted with AXIS PRE-CLEAN.
6. Seal vehicle with AXIS VERSASEAL.

REDUCER SELECTOR

Temperature Range	Recommended Reducer		
	Moderate	Hot Weather	Extremely Hot Weather
65-80°F	Yes		
80-95°F	Yes	Yes	
95°F or more		Yes	Yes

GENERAL INFORMATION

- Always consider the following when choosing a reducer: the size of the vehicle (is it a bus or a fender?), the temperature, humidity and air movement.
- Follow the recommendations in the reducer selector table for best results.

SPRAY GUN ADJUSTMENT

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise 1 and 1/4 turns. Open or close knob 1/4 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 paint defects such as orange peel, runs, sags and poor drying.

APPLICATION



Apply two to three medium wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approximately 15-20 min.) before applying the next coat. A cross coat may be necessary to even out metallic colors. It is recommended not to sand and buff metallic colors. If sanding and buffing, apply at least 2 coats of urethane clear as your final coats. Activator must be used in single stage color when applying a urethane clear as a final coat. (Dry times are dependent of shop temperature and humidity)

EQUIPMENT 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 2 hours.

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.