

QUICK MIX

PRODUCT FEATURES

- Long Term Durability
- Superior Flow-Out and Levelling
- 2.8 VOC Compliant
- Choice of 3 Hardeners
- High Gloss and D.O.I.
- Convenient Packaging



Part No	Description	Size	Case
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FACTORY PACKS

AQM-8100-1	Pure White	GAL	2
AQM-8101-1	Fine Metallic	GAL	2
AQM-8102-1	Coarse Metallic	GAL	2
AQM-8103-1	Caterpillar Yellow	GAL	2
AQM-8104-1	Safety Yellow	GAL	2
AQM-8106-1	Bright Red	GAL	2
AQM-8110-1	Red Metallic	GAL	2
AQM-8111-1	Teal Metallic	GAL	2
AQM-8112-1	Medium Blue	GAL	2
AQM-8113-1	Blue Metallic	GAL	2
AQM-8114-1	Black	GAL	2
AQM-8115-1	Kubota Orange	GAL	2
AQM-8116-1	John Deere Green	GAL	2
AQM-8184-1	Flat Black	GAL	2

Part No	Description	Size	Case
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ADDITIVE AND BINDER

AQM-8200-4	Flattening Agent	QT	6
AQM-8207-1	Mixing Binder	GAL	2

TONERS

AQM-8208-1	Transparent Yellow Oxide	GAL	2
AQM-8209-1	Transparent Red Oxide	GAL	2
AQM-8210-1	Magenta	GAL	2
AQM-8211-1	Maroon	GAL	2

HARDENERS

BQM-8370-4	Fast (70° - 80°F)	QT	4
BQM-8370-6	Fast (70° - 80°F)	HP	6
BQM-8380-4	Medium (80° - 90°F)	QT	4
BQM-8380-6	Medium (80° - 90°F)	HP	6
BQM-8390-4	Slow (90°F and over)	QT	4
BQM-8390-6	Slow (90°F and over)	HP	6

PHYSICAL PROPERTIES

Color	See color chart	Weight Solids (RTS)	44.73 % to 57.31%
Pot Life	3 hours	Theoretical Coverage @ 1 mil (A+B)	625.8 to 693.2 sq ft
Flash Point	1°F	Gloss 20°/60°	75+ GU "Gloss Units" / 85+ GU "Gloss Units"
Dry Film Build	2.5 to 3.0 mils	Inter Coat Adhesion	Excellent
Sprayable Viscosity	22" to 30" #2 Zahn Cup	Reparability Catalyzed	Excellent
EPA VOC (RTS)	≤2.61 (lb/gal)	Humidity Resistant	Excellent
ACTUAL VOC (RTS)	≤1.81(lb/gal)		

DRY TIMES @ 70°F



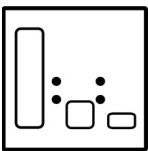
Air Dry

Dust Free	15 minutes
Flash	Until Hand Slick (approximately 15 to 20 min).
Print Free	14 hours
Deliver	16 to 18 hours
Force Dry	Bake at 140°F for 30 to 40 minutes. Use only a slow hardener when force drying. Allow vehicle to cool down to room temperature before delivery

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

MIX RATIO

COLD SHOP CONDITIONS



4 Parts Color	QUICK MIX
1 Part Activator	Activator (see availability table for options)
1/2 Part Reducer	Compliant Urethane Reducer

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure.

SPRAY GUN SETUP



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

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.

ACTIVATOR SELECTOR

Temperature Range	Recommended Activator		
	BQM-8370-4/8370-6	BQM-8380-4/8380-6	BQM-8390-4/8390-6
70-80°F	Yes		
80-90°F		Yes	
90°F or higher			Yes

SURFACE PREPARATION



1. Clean vehicle with soap and water and allow it to dry, then wipe with ASC-0165-1 WATER BASED PRE-CLEAN, using generous amounts and changing rags frequently.
2. Sand areas as necessary to remove any rust or corrosion, repair all body damage.
3. Prime exposed metal with a compliant bare metal primer or epoxy such as APR-1281 or APR-2259.
4. Prime repaired areas with AXIS SUPERBUILD 2K or VERSAPRIME 2K HB. (California users must use SUPERBUILD 2K)
5. Block sand primed bodywork with #400 grit or finer wet or dry sandpaper. Clean area to be painted with AXIS PRE-CLEAN.
6. Final sand the repair area with machine / DA (#400 grit or finer) sandpaper and re-wipe vehicle with ASC-0165-1 WATER BASED PRE-CLEAN.
7. For improved color holdout and coverage seal vehicle with VERSASEAL 2K tintable sealer.

GENERAL INFORMATION

- Always consider the following when choosing an activator: the size of the vehicle (is it a bus or a fender?), the temperature, humidity and air movement.
- Do not combine slow reducers with fast activators; this combination may cause solvent pop.
- Follow the recommendations in the activator selector table for best results.

APPLICATION



Apply 2 to 3 wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approx. 15 to 20 min) before applying the next coat. A cross coat may be necessary when applying metallic colors for a more uniform appearance. Apply all coats within 1½ hour.

OPTIONAL—2 coats of **ACL-1810 EURO 2.1 URETHANE CLEAR** may be applied for better UV protection and buffability.

- Allow single stage color to dry for 1 ½ hours @ 70°F before applying the urethane clear. Do not allow the single stage color dry more than 3 hours before applying the clear.

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.