



Advanced Industrial Coatings

1K Industrial Epoxy Primers

AIP100-White, AIP101- Black, AIP102-Gray, AIP103- Red

PRODUCT OVERVIEW

Advanced Industrial Primer is a high-solids, low VOC, direct to metal epoxy primer offering excellent performance properties and topcoatability. AIP 1K Epoxy Primers can be used with a wide range of topcoats, and is considered an ideal primer for fleet, construction machinery, farm equipment and other industrial applications.

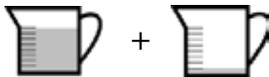


SUITABLE SUBSTRATES

- Cold rolled steel
- Hot rolled steel
- Galvanized steel
- Aluminum
- Fiberglass
- SMC



MIXING



Primer	Up to 10%
AIP100	Reducer
AIP101	AIR10
AIP102	AIR20
AIP103	



APPLICATION

1. HVLP: Adjust air pressure at cap to 8-10 psi.
2. Conventional: Adjust air pressure at the gun to 55-65 psi for pressure feed applications with a fluid delivery of 8-15 ounces per minute.
3. For Pressure/Siphon 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 1.5-2.0 mils.
4. Clean spray gun immediately after use with Gun and Equipment Cleaner.



DRYING SCHEDULE

Air Dry Times

At 75°F and 50% relative humidity

Dust Free:	30 minutes
Tack Free:	45 minutes
Nib Sandable:	1 hours
Tape Free:	2 hours
Sandable:	4 hour

Force Dry Times

<u>Temperature</u>	<u>Time to Tape Free</u>
140°F	1 hour
180°F	45 minutes



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

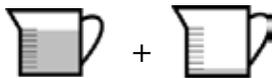
- Cold rolled steel
- Hot rolled steel
- Galvanized steel
- Aluminum
- Fiberglass
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Note: AIP 100 series epoxy primers do not require an etch primer and can be applied directly to the properly cleaned and sanded substrates with 220 grit sandpaper.



MIXING

- Stir or shake AIP 1K Epoxy Primers AIP100, AIP101, AIP102, AIP103 thoroughly before mixing.
- Can be sprayed with no reduction.
- If reduction is needed, use up to 10% AIR10 or AIR20.
- Stir thoroughly and strain before use.
- Pot life: 7 days



Primer	Up to
AIP100	10%
AIP101	Reducer
AIP102	AIR10
AIP103	AIR20

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

APPLICATION



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EQUIPMENT

<u>Gun Type</u>	<u>Nozzle</u>	<u>Air Pressure</u>
Conventional Pressure Feed	0.8-1.4 mm at 8-15 oz/min	55-65 psi
HVLP Pressure Feed	0.8-1.2 mm at 8-15 oz/min	8-10 psi at cap



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RECOAT

§ May be topcoated or recoated after 15 minutes and up to 14 days without sanding or scuffing.

DRYING SCHEDULE

- Dry times are based on the unreduced mix with recommended dry film thickness of 1.5-2.0 mils
- Thicker films will extend drying times
- Air dry times at 75° F and 50% relative humidity

- **Air Dry Times**

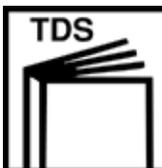
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- **Force Dry Times**

Temperature	Time to Tape Free
140°F	1 hour
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TECHNICAL DATA



Reduction	Up to 10% with AIR10 or AIR20	Viscosity (sprayable) Gardner #2 Zahn Cup (ISO calibrated)	18-20 sec
Max VOC *AIR10 OR AIR20 do not increase VOC	3.32 lbs/gal	Recommended Dry Film Thickness	1.5-2.0 mils
Ready to Spray Volume Solids (White)	53 %	Physical Properties*	
Coverage @ 1 mil dry (white)	850 FT ² /gal	Salt Spray 250 hours	1/8" creep
Pot Life	7 Days	Humidity 96 hours	No Effect
		Flexibility (1/8" conical mandrel)	Pass

AIP100,101,102,103	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	11.80	1414	11.33	1357
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	28.2	47.2	32.0	52.0
Solids	71.8	52.8	68	48
Water	0	0	0	0
Exempt Compounds	0	0	5.3	9.1
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	3.32	398	3.02	362
VOC Less Exempt	3.32	393	3.32	398
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	2.25	0.269	2.25	0.269