



# Advanced Industrial Coatings

## 3.5 VOC Urethane Primer

AIP200-White, AIP201-Dark Gray, AIP202-Gray

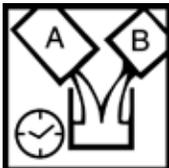
### PRODUCT OVERVIEW

Advanced Industrial Coatings 2K Urethane Primers AIP200, AIP201, AIP202 are low VOC, two-component urethane primers for use with Advanced Industrial Coatings topcoat system. AIP200, AIP201, AIP202 should be used over properly prepared bare and/or painted substrates. AIP200, AIP201, AIP202 2K primers deliver good gloss holdout and corrosion resistance over properly prepared substrates with the added ability to fill minor surface scratches. These Urethane Primers also offer a 1K mixing ratio if such alkyd properties are desired.



#### SUITABLE SUBSTRATES

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

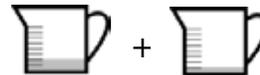


#### MIXING



8 Parts Primer AIP200 AIP201 AIP202	+	4 Parts Reducer AIR10 AIR20	+	1 Part Hardener AIH50
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#### (Optional 1K Alkyd Mix)



2 Parts Primer AIP200 AIP201 AIP202	+	1 Part Reducer AIR10 AIR20
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#### 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. For HVLP, apply 1 full wet coat with 50% overlap, applying the second coat in a cross-coat method. Recommended dry film thickness is 1.5-2.5 mils.
4. Clean spray gun immediately after use with Gun and Equipment Cleaner.



#### DRYING SCHEDULE

##### 2K

##### Air Dry Times

Dust Free:	20 minutes
Tack Free:	30 minutes
Nib Sandable:	45 minutes
Tape Free:	1-2 hours
Sandable:	2 hours

##### 1K

##### Air Dry Times

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

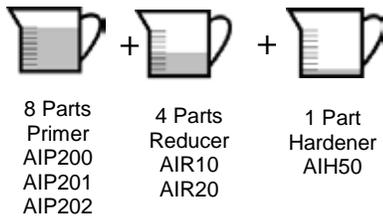
- Cold rolled steel
- Hot rolled steel
- Galvanized steel
- Fiberglass
- Aluminum
- SMC

*Note: AIP200, AIP201, AIP202 primers do not require an etch primer and can be applied directly to the properly cleaned and sanded substrates with 220 grit sandpaper.*

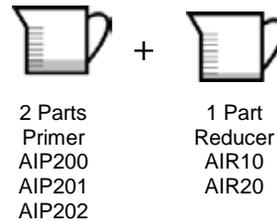


#### MIXING

- Stir or shake AIP200, AIP201, AIP202 primer thoroughly before mixing.
- Mix by volume 8 parts AIP primer with 4 parts AIR10 or AIR20 reducer and 1 part AIH50 hardener. Stir thoroughly and strain before use.
- Pot life: 1 hour at 70° F. Pot life: 7 days without hardener.



#### (Optional 1K Alkyd Mix)



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



#### APPLICATION

5. HVLP: Adjust air pressure at cap to 8-10 psi.
6. 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.
7. For Pressure/Siphon feed, apply 2 medium coats at a gun distance of 8-10 inches. For HVLP, apply 1 full wet coat with 50% overlap, applying the second coat in a cross-coat method. Recommended dry film thickness is 1.5-2.5 mils.
8. Clean spray gun immediately after use with Gun and Equipment Cleaner.

#### EQUIPMENT

Gun Type	Nozzle	Air Pressure
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

#### RECOAT

- May be topcoated or recoated after 15 minutes and up to 48 hours without sanding or scuffing. After 48 hours scuff or sand before recoating.



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### DRYING SCHEDULE

- Dry times are based on the recommended dry film thickness of 1.5-2.5 mils.
- Thicker films will extend drying times.
- Air dry times at 75° F and 50% relative humidity.

#### 2K

##### Air Dry Times

Dust Free:	20 minutes
Tack Free:	30 minutes
Nib Sandable:	45 minutes
Tape Free:	1-2 hours
Sandable:	2 hours

##### Force Dry Times

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

#### 1K

##### Air Dry Times

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

##### Force Dry Times

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



### TECHNICAL DATA

Mixing Ratio by Volume	8:4:1	Viscosity (sprayable) Gardner #2 Zahn Cup (ISO calibrated)	15-17 sec
Max VOC @ 8:4:1	3.47 lbs/gal	Recommended Film Thickness	1.5-2.5 mils
Ready to Spray Volume Solids (White)	29 %	Physical Properties	
Coverage @ 1 mil dry (white)	470 FT <sup>2</sup> /gal	Salt Spray 250 hours	1/8" creep
2K Pot Life	1 hours at 75°F	Humidity 96 hours	No Effect
		Flexibility (1/8" conical mandrel)	Excellent

AIP200,201,202-with hardener	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	10.80	1294	9.32	1116
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	38.2	56.0	52.2	69.3
Solids	61.8	44	47.8	30.7
Water	0	0	0	0
Exempt Compounds	10.4	12.1	29.2	38.2
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	3.00	359	2.14	257
VOC Less Exempt	3.41	408	3.47	415
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.04	0.005	0.03	0.004

AIP200,201,202-without hardener	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	10.80	1294	9.40	1125
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	38.2	56.0	52.6	70.7
Solids	61.8	44	47.4	29.3
Water	0	0	0	0
Exempt Compounds	10.4	12.1	31.4	41.4
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	3.00	359	2.00	239
VOC Less Exempt	3.41	408	3.41	408
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.04	0.005	0.04	0.005

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Cleveland, OH 44115

Printed in USA

AS2762  
1/19/11