



# Advanced Industrial Coatings

## Metal Direct™

### 2000 Series Factory Packaged Colors

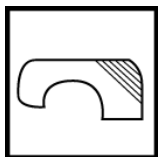
## PRODUCT OVERVIEW

Advanced Industrial Coatings AIC™ Metal Direct™ 2000 Series Factory Packaged Colors is a low VOC Acrylic Polyurethane that offers direct-to-metal adhesion. The AIC™ Metal Direct™ line offers factory packaged colors that are durable, high gloss, chemical resistant, and offer direct-to-metal adhesion. This product line is ideal for industrial applications, machinery, and equipment. AIC™ Metal Direct™ offers excellent hiding and is free of lead and chromate hazards.



### SURFACE PREPARATION

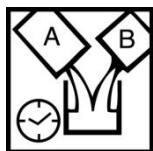
- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth
- Solvent clean with an appropriate Surface Cleaner and wipe dry with a clean cloth
- Blast all metal areas (Preferred) or sand with 80 grit sand paper (sanding recommended for SMC and FRP)
- Solvent clean with an appropriate Surface Cleaner and wipe dry with a clean cloth



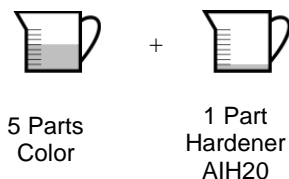
### SUITABLE SUBSTRATES

- Blasted Cold Rolled Steel
- Blasted Hot Rolled Steel
- Sheet Molded Compound (SMC)
- Fiberglass Reinforced Plastic (FRP)

**NOTE:** Not for use on immersion services. Not for use on surfaces with extended surface temperatures of 250°F or more.



### MIXING



**Note:** When using HVLP equipment only, up to 1 part AIR10 Reducer can be added to mix.



### APPLICATION

1. HVLP: Adjust air pressure at cap to 8-10 psi for pressure feed applications with a fluid delivery of 16-22 ounces per minute. Apply 1 full wet coat with 50% overlap, then apply a second coat in a cross-coat method. Recommended dry film build is 4-8 mils.
2. Airless: Airless Delivery pressure between 2,500 – 3,500 psi. Pump up to 3,000 lbs fluid pressure. 1 full wet coat with 50% overlap, applying the second coat in a cross-coat method at an application distance of 12-18 inches. Recommended film build is 4-8 mils.

**NOTE:** Estimated coverage is 871 sq. ft per gallon per mil.

### PERSONAL PROTECTION

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



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## Metal Direct™

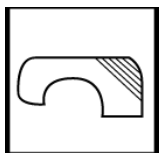
### 2000 Series Factory Package Colors

## PRODUCT DATA SHEET



### SURFACE PREPARATION

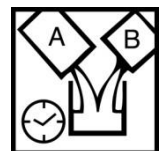
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### MIXING

- Stir or shake AIC Metal Direct™ Acrylic Polyurethane thoroughly before mixing
- Mix by volume, 5 parts AIC Metal Direct™ Acrylic Polyurethane Color with 1 part AIH20 hardener. Stir thoroughly
- Pot Life: 2 Hours



5 Parts  
Color

+



1 Part  
Hardener  
AIH20

**Note:** When using HVLP equipment only,  
add up to 1 part AIR10 Reducer



### APPLICATION

#### Overall

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### EQUIPMENT

#### Airless

Recommended Fluid Pressure	2500 – 3500 psi
Reversible Tip	3-13, 5-21
60 – 1 Pump	Up to 3,000 lbs fluid pressure
Filter	None

**Note:** Hose needs to maintain or exceed 6,000 psi. Please contact your ACME representative for proper recommendation.

#### Gun Type

HVLP Pressure Feed

#### Nozzle

1.3 or 1.4 mm at 16-22 oz/min

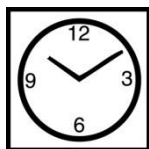
#### Air Pressure

8-10 psi at cap (use manufacturers recommendation)



# Advanced Industrial Coatings Metal Direct™ 2000 Series Factory Package Colors

## PRODUCT DATA SHEET



### DRYING SCHEDULE

Air dry times @ 8.0 mil wet @ 70° F, 50% Relative Humidity:

Hand Slick: 45 Minutes  
Dust Free: 1 Hour  
Tack Free: 1.5 Hours  
Nib Sandable: 2 Hours  
Sandable: 3 Hours

**Minimum Recoat Time:** 20 minutes

**Maximum Recoat Time:** 72 hours

**NOTE:** In order to recoat after 72 hours, surface must be sanded with 220-320 grit sandpaper.

### TECHNICAL DATA

Mixing Ratio by Volume	5:1	Physical Properties*	
Max VOC	0.7	Impact	80/60
Ready to Spray Volume Solids (White)	55%	Humidity	Pass
Coverage @ 1 mil dry (white)	882 sq ft per gal per mill	Salt Spray (500 hrs)	Pass
Pot Life	2 Hours	Dry Adhesion	Pass
Viscosity (sprayable) #3 Zahn Cup (ISO calibrated)	20 – 25 seconds	MEK R	50
Recommended Dry Film Thickness*	4-8 mils	Gloss	80 to 90

**Note:** Please contact your ACME® representative for higher film build recommendations.

0.7 VOC AIC Metal Direct™ DTM	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	11.18	1339	11.01	1319
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	54.5	33.9	33.8	50.5
Water	0	0	0	0
Exempt Compounds	26.4	44.9	22.3	37.4
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	0.46	55	0.38	46
VOC Less Exempt	0.89	107	0.70	84
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0	0	0	0

To learn more about ACME® Automotive Refinish Products, visit our Web site at [www.sherwin-automotive.com](http://www.sherwin-automotive.com)