



# 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



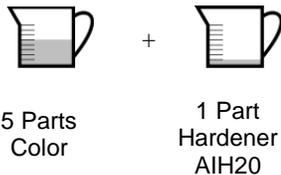
### SUITABLE SUBSTRATES

- 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



5 Parts  
Color

1 Part  
Hardener  
AIH20

**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.



**PRODUCT DATA SHEET**



**SURFACE PREPARATION**

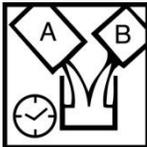
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**SUITABLE SUBSTRATES**

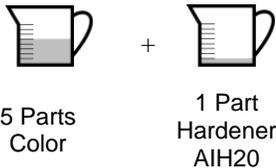
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**MIXING**

- 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



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



**APPLICATION**

**Overall**

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 film build is 4-8 mils.
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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)



## 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

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

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

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