

AIC

Advanced Industrial Coatings

FPC135 Series - 3.5 VOC Acrylic Enamel
Factory Packaged Colors Product Data Sheet

PRODUCT DESCRIPTION

AIC Factory Packaged Colors (FPC135 Series) are two-component acrylic enamel topcoats with a 3.5 VOC level. The topcoat system is for use on properly prepared and/or primed metal surfaces. FPC135 Series colors are easy-to-use, high gloss, durable, chemical and solvent resistant coatings that can be air-dried or force-dried. The FPC135 Series is free of lead and chromate hazards. AIC FPC135 Series are extremely versatile, cost effective products and are recommended for use on industrial applications. The FPC135 Series acrylic enamel also has a 1K option if such properties are desired.

TECHNICAL DATA

Max VOC			
With AIR10 / AIR20 @ 8:2: 1 ratio	3.5 lbs/gal		
HAP's	<1.5 lbs/gal RTS		
Viscosity (sprayable)			
Gardner #2 Zahn Cup (ISO calibrated)	18-25 sec		
Flash point PMCC (white)	35°F		
Coverage @ 1 mil dry (white)	800 sq. ft./gallon		
Recommended dry film thickness (white)	2.0-2.5 mils		
Volume Solids (white)	40%		
Gloss 60°	88		
20°	78		
DOI	Very Good		
Pencil Hardness at 48 hours	HB		
at 2 weeks	H		
Performance after one-week air dry			
- Impact resistance (80 inch-pounds)			
Direct		120	
Reverse		120	
- Flexibility (1/8" conical mandrel)		Pass	
- Solvent resistance (10 double rubs) (MEK/Xylene/Gasoline/Diesel/Oil)		No effect	
- Chemical resistance (24 hr. covered contact)			
10% Hydrochloric acid		Effect	
10% Sulfuric acid		Slight effect	
10% Sodium hydroxide		Slight effect	
Gasoline		No effect	
Motor Oil		No Effect	
Antifreeze		Effect	
- Salt spray resistance -250 hrs*		1/8" creepage	
- Humidity resistance - 100 hours*		Slight Haze	
		* Over properly treated and primed metal	

SUITABLE PRIMERS

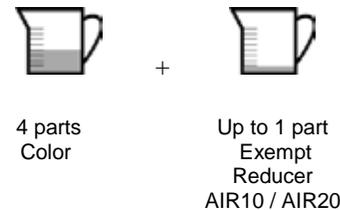
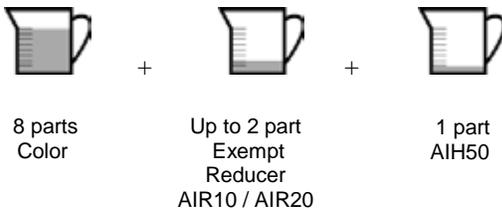
- All Advanced Industrial Coatings Primers / Sealers / Epoxy Primers
 - AIP100 White Epoxy Primer
 - AIP101 Black Epoxy Primer
 - AIP102 Gray Epoxy Primer
 - AIP103 Red Oxide Epoxy Primer
 - AIP200 White Urethane Primer
 - AIP201 Black Urethane Primer
 - AIP202 Gray Urethane Primer
- The following properly prepared or pretreated metals
- Cold Rolled Steel
 - Hot Rolled Steel
 - 5052 Aluminum

MIXING

- Stir or shake AIC FPC135 Series thoroughly before mixing.
- Mix by volume, **8 parts color, with up to 2 parts of AIR10 / AIR20 reducers and 1 part AIH50 hardener.**
- Stir thoroughly and strain before use.

- Pot life: 4 hours @ 70°F.**
- Pot life: 3 hours @ 70°F. Accelerated with AIC440/AIA200.**
- Pot life: Unlimited without hardener**

(Optional 1K Mix Ratio)



- To speed cure time of the **1K product** add up to **8 ounces of the AIC440 Drier** per sprayable gallon. To speed cure time of the **2K product**, add up to **8 ounces of the AIA200 Accelerator** per sprayable gallon. Refer to **Drying Schedule** section for details about cure times with AIC440/AIA200.

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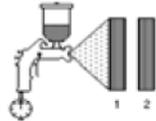
APPLICATION

Overall

1. Adjust air pressure at the gun to 55-65 psi Conventional Pressure Feed (adjust pot pressure to 8-15 fluid ounces per minute delivery).
2. For Conventional Pressure 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 2.0-2.5 mils.
3. Clean spray gun immediately after use with Gun and Equipment Cleaner.

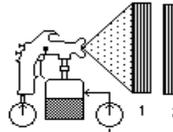
HVLP

Apply 1 full wet coat
With 50% overlap.



Conventional Pressure Feed

Apply 2 medium coats.
Allow each to become hand slick



Equipment

Fluid Tip
Fluid Delivery
Atomizing Air

HVLP
1.4 -1.5 mm
8-15 oz./min.
8-10 psi @ Tip
Apply 1 full wet coat with 50% overlap
Using a cross-coat technique

Conventional Pressure Feed
0.70/1.8 mm
8-15 oz./min.
55 - 65 psi @ Gun
Apply 2 medium coats

DRYING SCHEDULE

Dry times are based on dry film thickness of 2.0 - 2.5 mils; thicker films will extend drying times.

Air dry times @ 75°F and 50% Relative Humidity:

	<u>Unaccelerated</u>	<u>Accelerated</u> Up to 8 oz. AIC440/AIA200 per sprayable gal
- Dust free	2 hours	1 hour
- Tack free	3 hours	2 hours
- Tape free	4 hours	3 hours
- Nib Sand	8 hours	4 hours

Force dry times:

<u>Temperature</u>	<u>Tape Free</u> <u>Unaccelerated</u>	<u>Tape Free with 8 oz.</u> <u>AIC440/AIA200 per sprayable gal</u>
140°F	80-120 minutes	60 minutes
160°F	60-80 minutes	45 minutes
180°F	45-60 minutes	30 minutes

NOTES

- Decals may be applied after air-drying 72 hours at 75°F. Lower temperatures, heavy film thickness, poor air movement, thick decals, foil-based decals, etc., will extend the 72 hour dry time before decals may be applied.
- Infrared Recommendation: 10 min. on low for flash and 20 min. on high until firm. Lamp should be no closer than 36 inches.
- Recoat before 8 hours or after 48 hours to prevent lifting. Any AIC Factory Packaged color can be recoated with itself before 8 hours or after 48 hours and up to 2 weeks after initial application. After 2 weeks sanding is required.

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.

To learn more about Advanced Industrial Coatings Products, call 1-888-813-2263.

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