



Advanced Industrial Coatings

1K Industrial Epoxy Primers

AIP100 White

AIP101 Black

AIP102 Gray

AIP103 Red

PRODUCT DESCRIPTION

Advanced Industrial Primer is a high-solids, low VOC, epoxy primer offering excellent performance properties and topcoatability with a wide range of topcoats including two component urethanes, alkyds and acrylic enamels. It is an ideal primer for fleet, construction machinery, farm equipment and other industrial applications.

TECHNICAL DATA

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| <ul style="list-style-type: none"> • Reduction May be reduced up to 10% with AIR10 or AIR20 or unreduced. • Max VOC AIR10 or AIR20 do not increase VOC's 3.37 lbs/gal • Viscosity (sprayable) Gardner #2 Zahn Cup (ISO calibrated) 18-20 sec • Coverage @ 1 mil dry (white) 850 sq. ft./gallon • Recommended dry film thickness (white) 1.5-2.0 mils • Volume Solids (white) 53% | <ul style="list-style-type: none"> • Unlimited Pot life • Direct to Metal Properties • Fast drying • Excellent holdout of topcoat • Excellent corrosion resistance • High solids for quick film build with minimum spray passes • Free of lead and chromate hazards • Extended recoat times |
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SUITABLE SUBSTRATES

AIP 100 series Epoxy primers do not require an etch primer and can be applied directly to the following properly cleaned and sanded substrates with 220 grit sandpaper:

- Cold rolled steel
- Hot rolled steel
- Galvanized steel

MIXING

1. Stir or shake AIP 1K Epoxy Primers AIP100 / AIP101 / AIP102 / AIP103 thoroughly before mixing.
2. **Can be sprayed as is with no reduction or up to 10% AIR10 / AIR20.** Stir thoroughly and strain before use.



1K
Primer
AIP100
AIP101
AIP102
AIP103

+



Up to
10%
Reducer
AIR10/AIR20

- **Pot life:** Unlimited

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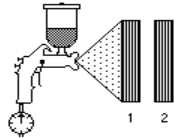
APPLICATION

Overall

1. Adjust air pressure at the gun to 55-65 psi for siphon, gravity or pressure feed (adjust pot pressure to 5-10 psi for 8-12 fluid ounces per minute delivery).
2. 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.
3. Clean spray gun immediately after use with Gun and Equipment Cleaner.

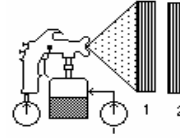
HVLP

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

1.2 –1.4 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 the unreduced mix with recommended dry film thickness of 1.5 – 2.0 mils;
- thicker films will extend drying times.

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

Force Dry times:

	<u>Air Dry</u>	140°F	180°F
- Dust free	30 min	15 min	15 min
- Tack free	45 min	30 min	20 min
- Tape free	2 hours	1 hour	45 min
- Nib Sand	4 hours	2 hours	1 hour

RECOATING

Can be topcoated or recoated after 15 minutes. Must be scuffed or sanded after 2 weeks.

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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