



2K High Solids Interior Polyurethane Enamel

AUE-360/AUE-360LG (AUE-3606A) Interior Use

AUE-360/AUE-360LG with AUE-3606A is a two-component high solids polyurethane intended for interior use applications. It offers excellent mar and good chemical resistance as well as high film build capabilities with one pass coverage. AUE-360 can be combined with the low gloss version, AUE-360LG, to achieve intermediate gloss levels.

When catalyzed with AUE-3606A, AUE-360/AUE-360LG is recommended for interior use only industrial applications on properly pre-treated or primed metal surfaces. Example applications include metal fabrication, castings, machinery, medical equipment, and metal-racking/shelving (interior application).

Under some specifications, this product is also known as SPECTRACRON 360.

Features and Benefits:

- High film build capability
- Excellent mar and good chemical resistance
- Intermediate gloss levels possible
- Plural component capable with no accelerator required

Associated Products:

- AUE-360 - 2K High Solids Polyurethane
- AUE-360LG - 2K High Solids Low Gloss Polyurethane
- AUE-3606A - Polyurethane Hardener for Interior Use Only

Physical Constants: *All values are theoretical, depend on color and are Ready-to-Spray. Actual values could vary slightly due to manufacturing variability.*

	AUE-360 with tints only	AUE-360 AUE-3606A	AUE-360LG with tints only	AUE-360LG AUE-3606A
Percent solids (by weight)	55.9 – 72.0%	60.1 – 72.0%	55.0 – 71.0%	58.6 – 71.2%
Percent solids (by volume)	49.1 – 57.5%	51.9 – 58.2%	46.2 – 54.3%	49.2 – 55.6%
HAPs	≤ 0.1 lbs/gal	≤ 0.1 lbs/gal	≤ 0.1 lbs/gal	≤ 0.1 lbs/gal
Photo-chemically reactive	No	No	No	No

Flashpoint

AUE-360 only = 63°F, AUE-360LG only = 93°F
AUE-3606A = 124°F

RTS Combinations:	AUE-360 w/ tints only	AUE-360 AUE-3606A	AUE-360LG w/ tints only	AUE-360LG AUE-3606A
Volume Ratio	As is	3 : 1	As is	4 : 1
Applicable Use Category	Single-Stage Coating	Single-Stage Coating	Single-Stage Coating	Single-Stage Coating
VOC Actual	362 – 454 (g/L) 3.03 – 3.79 (lbs/gal)	350 – 418 (g/L) 2.92 – 3.49 (lbs/gal)	375 – 442 (g/L) 3.13 – 3.69 (lbs/gal)	391 – 476 (g/L) 3.26 – 3.97 (lbs/gal)
VOC Regulatory (less water less exempt)	362 – 454 (g/L) 3.03 – 3.79 (lbs/gal)	350 – 418 (g/L) 2.92 – 3.49 (lbs/gal)	345 – 443 (g/L) 3.13 – 3.70 (lbs/gal)	391 – 476 (g/L) 3.26 – 3.97 (lbs/gal)
Density	1021 – 1353 (g/L) 8.51 – 11.28 (lbs/gal)	1045 – 1293 (g/L) 8.71 – 10.78 (lbs/gal)	1064 – 1328 (g/L) 8.87 – 11.07 (lbs/gal)	1052 – 1382 (g/L) 8.77 – 11.52 (lbs/gal)
Volatiles wt. %	28.0 – 44.1	28.0 – 39.8	28.8 – 41.4	29.0 – 44.9
Water wt. %	0.0 – 0.2	0.0 – 0.2	0.0 – 0.2	0.0 – 0.2
Exempt wt. %	0.0	0.0	0.0	0.0
Water vol. %	0.0 – 0.3	0.0 – 0.2	0.0 – 0.2	0.0 – 0.3
Exempt vol. %	0.0	0.0	0.0	0.0

AUE-360 / AUE-360LG

(AUE-3606A) Interior Use

Directions for Use

Substrate Preparation:

The surface to be coated must be sanded and free of all contamination (including dust, dirt, oil, grease, and oxidation). Chemical treatment and the use of a conversion coating will improve the performance properties of the coating system. We recommend that adhesion and system compatibility be checked prior to full application.

Metal	Direct to properly treated substrate
Cold Rolled Steel	Refer to CPCTB01 for approved primers.
Hot Rolled Steel	Refer to CPCTB01 for approved primers.
Galvaneal	Refer to CPCTB01 for approved primers.
Galvanized	Refer to CPCTB01 for approved primers.
Aluminum	Refer to CPCTB01 for approved primers.
Plastic / Fiberglass	Surface should be free of all contamination. Because of the variability of plastic/ fiberglass substrates, coating performance should be confirmed on the actual plastic/fiberglass substrate being used.

Note: For improved performance between this topcoat and CPC primers please see the CPC Primer/Topcoat compatibility chart (CPCTB01).

Mix Directions:



Mix Directions: Thoroughly agitate component A on mechanical shaker prior to mixing. Stir thoroughly before and occasionally during use. This material must be stored in a lined container.



Thinning: Not recommended in VOC compliant areas. In non-regulated areas, up to 10% of Q70 (MAK), or Q60 (MEK) can be added. In VOC regulated areas, Q30 (Acetone) may be utilized.



Blend Ratio:

AUE-360 : AUE-3606A	AUE-360LG : AUE-3606A
3 : 1	4 : 1

Pot Life @ 77°F (25°C): 2 – 3 hours

Spray Viscosity Range: #3 Zahn 20 – 35 seconds *depending on color*

Unopened Shelf Life: (each component) 2 years

Application Equipment:



Conventional: (with or without pressure pot): 1.3 – 1.7 mm needle/nozzle with 40 – 50 psi at the gun



HVLP: (with or without pressure pot): 1.3 – 1.5 mm needle/nozzle with 10 psi at the gun or per manufacturer



Airless: No recommendation

Air-Assisted Airless: No recommendation

Brush or Roll: This product can be brushed or rolled

Electrostatic: 1.2 – 1.6 mm @ maximum pressure recommended by manufacturer

Application:



Apply: 1 – 2 medium coats with a 10 – 15 minute flash. Apply only when air, product and surface temperature are above 60°F (10°C) and when surface temperature is at least 5°F (3°C) above the dew point.

	AUE-360 w/AUE-3606A	AUE-360LG w/AUE-3606A
Recommended Wet Film Build:	2.5 – 4.5 mils	
Recommended Dry Film Build:	1.5 – 2.5 mils	
Square Foot Coverage @ 1 mil no loss:	832 – 933	788 – 892

Dry Times:



	AUE-360 w/AUE-3606A	AUE-360LG w/AUE-3606A
Dry to Touch:	½ – 1 hour	½ – 1 hour
Dry to Handle:	1 – 2 hours*	1 – 2 hours*
Dry to Recoat:	1 hour – 4 days	1 hour – 4 days
Force Dry:	20 minutes @ 180°F (after 10 minute air dry)	

* Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.

AUE-360 / AUE-360LG

(AUE-3606A) Interior Use

Technical Data*

Performance Properties:

Test	ASTM Method	Results	
		AUE-360 / AUE3606A	AUE-360LG / AUE3606A
Gloss @ 60° Angle*	D523	87 – 90	19 – 30
Pencil Hardness	D3363	F	F
Conical Mandrel	D522	Pass	Pass
Adhesion	D3359	5B	5B
Chip Resistance	D3170	7	7
In Service Temperature Limit**		300°F	

** As you approach 300°F depending on the pigmentation, the color may change, but the film integrity will be maintained up to 300°F.

Chemical Resistance:

Chemical	ASTM Method	Results	
		AUE-360 / AUE3606A	AUE-360LG / AUE3606A
Toluene	D1308	Slight ring, gloss loss	Slight ring
10% NaOH (Sodium Hydroxide)	D1308	Pass	Pass
10% HCl (Hydrochloric acid)	D1308	Pass	Pass
10% H ₂ SO ₄ (Sulphuric acid)	D1308	Pass	Pass
Gasoline	D1308	Mild ring, lift, yellowing	Slight ring
Isopropyl Alcohol	D1308	Slight ring	Slight ring
Water**	D1308	Pass	Pass

** Although resistant to intermittent exposure, not recommended for immersion.

Weather Resistance***

System:
BONDERITE® 1000
AUE-360 (LG) / AUE-3606A

	ASTM Method	Results	
		AUE-360 / AUE3606A	AUE-360LG / AUE3606A
Salt Spray – 300 hours	B117		
Corrosion Creep	D1654	3A	3A
Scribe Blisters	D714	6M	6M
Face Blisters	D714	8D	8D
Humidity – 100 hours	D1654	No rusting, 8F blistering	

All tests results assume proper cure and preparation of test substrates. Unless otherwise stated, all results were obtained spraying product direct to metal on *Bonderite* 1000.

* The application and performance property data above are believed to be reliable based on laboratory findings. It is for the buyer to satisfy itself on the suitability of the product for its particular use. Variation in environment, procedures of use, or extrapolation of data may cause unsatisfactory results.

Miscellaneous:

*** AUE-360 and AUE-360LG utilizing AUE-3606A are for interior use only. If exterior durability (exposure to UV and other harsh conditions) is needed, AUE-3501, GXH1086, or GXH1080 should be used at their appropriate mix ratios. See CPCPB221 for information using these hardeners.

AUE-360 / AUE-360LG

(AUE-3606A) Interior Use

Safety:



These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment, materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness.

Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers.

Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645-1320 and in MEXICO 01-800-00-21-400. Have label information available.



Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.



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