

2K HS INTERIOR POLYURETHANE ENAMEL

AUE-120

AUE-120, 2K HS **Interior** Polyurethane Enamel is a high solid, low VOC, 2-component interior polyurethane coating. It is designed to be sprayed as a low-gloss (satin) smooth coat or can be textured to provide a unique custom finish or to hide surface imperfections like grinding marks and weld seams.

AUE-120 can be used for applications such as business machines, dental equipment, computer cabinetry, electronic enclosures, etc. This product is formulated lead and chrome free.

Features and Benefits

- Smooth or custom texture finish
- Excellent chemical resistance, hardness and flexibility
- Outstanding mar and abrasion resistance
- Low VOC at ≤ 2.8 lbs. / gal. with no reportable HAPs
- Available in wide range of custom colors
- Contains no heavy metals

Associated Products:

- AUE-120 2K High Solids Interior Urethane
- AUE-3606A 2K High Solids Aromatic Urethane Hardener
- AUE1-FP901, Factory-packaged Black
- Exempt Solvent Blend (like F3385)

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

| | AUE-120 | AUE-120 w/ AUE-3606A | AUE-120 w/ AUE-3606A + Exempt Solvent Blend |
|--|-------------------|-------------------------|---|
| Percent solids (by weight) | 56.2 – 66.7% | 59.2 – 67.6% | 54.3 – 62.7% |
| Percent solids (by volume) | 45.7 – 51.2% | 48.9 – 53.3% | 44.4 – 48.5% |
| HAPs | < 0.1 lbs/gal | < 0.1 lbs/gal | < 0.1 lbs/gal |
| Photo-chemically reactive | No | No | No |
| Volume Ratio | As is | 4 : 1 | 4 : 1 : ½ |
| Applicable Use Category | Single-Stage Ctg. | Single Stage Ctg. | Single Stage Ctg. |
| VOC Actual (g/L) | 200 - 256 | 222 – 267 | 202 – 243 |
| VOC Actual (lbs/gal) | 1.67 – 2.13 | 1.86 – 2.23 | 1.69 – 2.02 |
| VOC regulatory (less water less exempt) (g/L) | 271 – 345 | 282 – 337 | 282 – 337 |
| VOC regulatory (less water less exempt) (lbs/gal) | 2.26 – 2.88 | 2.35 – 2.81 | 2.35 – 2.81 |
| Density (g/L) | 1183 – 1409 | 1170 – 1350 | 1160 – 1324 |
| Density (lbs/gal) | 9.87 – 11.76 | 9.76 – 11.27 | 9.68 – 11.05 |
| Volatiles wt. % | 33.3 – 43.8 | 32.4 – 40.8 | 37.3 – 45.7 |
| Water wt. % | 0.0 – 0.1 | 0.0 – 0.1 | 0.0 – 0.1 |
| Exempt wt. % | 18.8 – 22.4 | 15.7 – 18.1 | 21.9 – 24.9 |
| Water vol. % | 0.0 – 0.2 | 0.0 – 0.1 | 0.0 – 0.1 |
| Exempt vol. % | 25.9 | 20.7 | 27.9 |


Flashpoint AUE-120 = 17°F (-8°C) , AUE-3606A = 124°F (51°C)

AUE-120

Directions For Use

Surface Preparation:

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating and/or primer will improve the performance properties of the coating system. See your PPG Representative for recommendations. We recommend that the customer trial the product for adhesion and compatibility using all substrates.

|  | Metal | Direct To Substrate |
|---|----------------------|---|
| | Cold Rolled Steel | Excellent |
| | Hot Rolled Steel | Good |
| | Galvaneal | Good |
| | Galvanized | Good |
| | Aluminum | Good |
| | Plastic / Fiberglass | Surface should be free of all contaminants. Coating performance should be tested to confirm properties over plastic/ fiberglass being used. |

Note: For acceptable compatibility between primers and CPC topcoats 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. Do not use an accelerator.

Thinning: Exempt Solvent Blend (like F3385)



| Blend Ratio | AUE-120 w/ AUE-3606A | AUE-120 w/ AUE-3606A : Exempt Solvent Blend |
|--------------------------------|--|---|
| | 4 : 1 | 4 : 1 : ½ |
| Pot Life @ 77°F (25°C): | 3 – 4 hours | 3 – 4 hours |
| Spray Viscosity Range: | # 3 Zahn = 10 – 17 seconds | 9 – 15 seconds |
| Shelf Life (each component) | AUE-120: 2 years unopened AUE-3606A: 2 years unopened | |



Application Equipment:

| | | |
|--|-------------------|-------------|
| Conventional (with or without Pressure Pot): | 1.3 – 1.7 mm tip | 50 – 60 psi |
| HVLP (with or without Pressure Pot): | 1.3 – 1.7 mm tip | 8 – 10 psi |
| Airless | Not recommended | |
| Air-Assisted Airless | Not recommended | |
| Brush/Roll | Not recommended | |
| Electrostatic | No recommendation | |

Application:

Apply: 1 – 2 medium coats with 10 – 15 minute flash. Apply only when air, product or surface temperature is above 50°F (10°C) and when surface temperature is at least 5°F (3°C) above the dew point.



| Recommended Wet Film Build: Recommended Dry Film Build: Square foot Coverage @ 1 mil no loss: | AUE-120 w/ AUE-3606A | AUE-120 w/ AUE-3606A : Exempt Solvent Blend |
|--|-------------------------|---|
| | 3.0 – 5.0 mils | 3.6 – 6.0 mils |
| | 1.5 – 2.5 mils | 1.5 – 2.5 mils |
| | 800 sq/ft | 666 sq/ft |

AUE-120

Dry Times:

Air Dry @ 77°F 50% RH



Touch:

Handle*:

Recoat**:



Force Dry:

AUE-120 w/ AUE-3606A

1 Hour

2 ½ - 3 Hours

15 minutes to 24 hours

30 Minutes @ 140F

*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.

** After this time, the topcoat must be abraded prior to recoating.

Technical Properties*:

| Test | ASTM Method | Result |
|-------------------|-------------|---------------------------------|
| | | AUE-120 w/ AUE-3606A |
| Gloss @ 60° Angle | D523 | 15 - 40 |
| Pencil Hardness | D3363 | F - H |
| Conical Mandrel | D522 | Pass |
| Adhesion | D3359 | 5B |
| Chip Resistance | D3170 | 7 |

Chemical Resistance:

| Chemical | ASTM Method | Result |
|------------------------------------|-------------|---------------------------------|
| | | AUE-120 w/ AUE-3606A |
| Toluene | D1308 | Gloss Loss |
| 10% NaOH | D1308 | Very Slight Gloss Loss |
| 10% HCl | D1308 | No Effect |
| 10% H ₂ SO ₄ | D1308 | No Effect |
| Gasoline | D1308 | Very Slight Gloss Loss |
| Isopropyl Alcohol | D1308 | Very Slight Gloss Loss |
| Water** | D1308 | |

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

Weather Resistance

| | ASTM Method | Result |
|-------------------------------|-------------|---------------------------------|
| | | AUE-120 w/ AUE-3606A |
| Salt Spray – 200 hours | B117 | |
| Corrosion Creep | D1654 | 6A |
| Scribe Blisters | D714 | 4M |
| Face Blisters | D714 | Few Microblisters |
| Humidity – 100 hours | D2247 | |
| 5 Minute Recovery Adhesion | D3359 | 5B |
| 1 Hour Recovery Adhesion | D3359 | 5B |
| 24 Hour Recovery Adhesion | D3359 | 5B |
| | | |
| | | |
| | | |
| | | |

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:

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 Have label information available.

Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor.

For Additional information regarding this product, see the MSDS AND LABEL information.



PPG Industries
19699 Progress Drive
Strongsville, OH 44149
1-800-647-6050

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
1-888-310-4762

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