



AUE-360 /AUE-3606

2K High Solids Urethane (For interior use only)

CPC 155

PRODUCT DESCRIPTION	
Component A AUE-360 2K High Solids Urethane (Spectracron 360)	Component B AUE-3606 Hardener for AUE-360 (Interior use only) (also labeled as Q3606)
TYPE Acrylic Urethane	
RECOMMENDED USE AUE-360 (Spectracron 360) mixed with a AUE-3606 catalyst is a 2-component fast-dry urethane that offers a high film build capability with one pass coverage. It does not require an accelerator, can be sprayed through airless or air-assisted equipment and can also be brushed or rolled. It is recommended for industrial use on pre-treated or primed metal surfaces. Suitable applications include metal fabrication, castings, manufacturing machinery, medical equipment, metal-racking/shelving (interior application). Once formulated, batches as small as one gallon can be reproduced time after time without the color drift problems associated with manual small batch methods. Under some specifications, this product is also known as SPECTACRON 360.	

PHYSICAL CONSTANTS	
Voc (Mixed) 3.5 lbs/gal (varies by color) Some colors can also be formulated to 2.8 lbs/gallon (max)	Flash Points AUE-360 (Spectracron 360) 85°F (29°C) AUE-3606 Catalyst for AUE-360 124°F (51°C)
Percent Solids By Weight (Mixed) 56 ± 3%	Ready To Spray Viscosity (Varies By Color) #3 Zahn = 20 - 35 Seconds #2 Zahn = N/A
Percent Solids By Volume (Varies By Color) 57 ± 4%	Shelf Life 12 months
Weight Per U.S. Gallon (Varies By Color) 9.0 ± 5 lbs./gallon	

PERFORMANCE FEATURES	
Pencil Hardness (Varies By Color) H-2H	Fade Resistance Excellent
Flexibility (Conical Mandrel) Excellent	In Service Temperature Limitations 200° F
Adhesion Excellent	Sheen Gloss @ 60° angle – 20% – 90%
96 Hour Humidity Resistance Excellent	Water Resistance Although resistant to intermittent exposure, <i>not recommended For immersion.</i>

CHEMICAL/SOLVENT RESISTANCE			
Fertilizer	Pass	MEK	Pass
Hydraulic Fluid	Pass	Oil	Pass
Gasoline	Pass		

SURFACE PREPARATION		
The surface to be coated must be sanded, free of all contamination, including dust, dirt, oil, grease and oxidation. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the finished coat.		
Metal	Recommended Topcoat	Direct To Properly Treated Substrate
Cold Rolled Steel	HBA-CT, HBA-4035, MPP-807, HSP-2128, EEP-435, EPX-900, EFP-428/928, HBE-400	Excellent
Hot Rolled Steel	HBA-CT, HBA-4035, MPP-807, HSP-2128, EEP-435, EPX-900, EFP-428/928, HBE-400	Excellent
Galvanized	HSP-2128, EEP-435, EPX-900, EFP-428/928, HBE-400	Fair-Good
Galvaneal	HSP-2128, EEP-435, EPX-900, EFP-428/928, HBE-400	Fair-Good
Aluminum	HBA-CT, HBA-4035, MPP-807, HSP-2128, EEP-435, EPX-900, EFP-428/928, HBE-400	Good
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.	

APPLICATION DATA

MIXING DIRECTIONS

Stir thoroughly before and occasionally during use. 3 parts AUE-360LG (Spectracron 360) component A to 1 part AUE-3606 (Q3606) component B by volume. For interior use only.

Mixing ratio is 3 : 1. Stir thoroughly before using.

AUE-360	:	AUE-3606
3	:	1

Note: Moisture contamination in components can result in poor properties of applied films or gelling of the material. Do not open until ready to use.

Pot Life

77°F (25°C) 2 – 3 hours after mixing

HVLP

25-50 PSI
1.3-1.5 Fluid Tip

Thinning

Acetone or Aromatic 100

Pressure Pot

10-16 ounces per minute fluid delivery
1.0-1.4 fluid tip

Application Equipment

Conventional Spray:
40 - 50 PSI at the gun
1.3 – 1.7 fluid tip

Drying Time

(77°F / 25°C and 50% relative humidity)

To Touch:	½ - 1 hour	Recommended Wet Film Build:	3.5 – 5.0 mils
To Handle:	1 – 2 hours*	Recommended Dry Film Build:	1.5 – 2.5 mils
Recoat:	1 hour to 4 days	Application of film thickness in excess of that recommended for this product will substantially extend dry time and lengthen the recoat window.	
Force Dry:	20 minutes @ 180°F (Allow 10 minutes air dry)		

* This condition does not mean that the paint film has reached full cure. It is a stage where handling can be achieved without loosening, wrinkling or otherwise marring the film under minimal pressure from fingers or hands. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.

Paint film is not fully cured for 7 days.

Film in excess or below these recommended film builds may cause problems such as, adhesion failure, pigment floatation, solvent popping, slow cure, and accelerated gloss and color failure.

RECOMMENDED SPREADING RATE

850 - 950 sq. ft. at 1.0 mil dry film per U.S. gallon (varies by color). Spreading rate figures do not include losses due to mixing, transfer or application of coating, or losses due to surface irregularities or porosity.

CLEAN UP

MEK

APPLICATION PRECAUTIONS AND LIMITATIONS

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. After 24 hours, mechanically abrade the surface before recoating.

Avoid moisture contamination of the AUE-3606 (Q3606) component B. Moisture can gel the material and affect performance properties.

Note: Do not use accelerators

To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.

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 SHEET 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.**

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