



Commercial Performance Coatings

AUE-400LG/AUE-421

CPC 48

Low VOC Polyurethane Enamel - LG

PRODUCT DESCRIPTION			
AUE-400LG Low Voc POLYURETHANE ENAMEL-LG Component A (Pigmented)		AUE-421 URETHANE CATALYST Component B	UA-11 URETHANE ACCELERATOR Component C
<p>TYPE: Polyurethane</p> <p>RECOMMENDED USE AUE-400LG Low VOC Polyurethane Enamel is recommended for interior and exterior use on properly prepared and or primed metal surfaces. Suitable applications include metal fabrication, castings, cabinets, machinery, and heavy equipment. AUE-400LG Low VOC Polyurethane Enamel provides a wide balance of performance properties, including excellent flow and leveling, film hardness and good exterior durability.</p> <p>COLORS Virtually any new or existing color standard can be quickly and precisely matched using PPG's COLOR ACCURATE™ instrument matching and dispensing system. 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. All colors supplied from the COLOR ACCURATE™ system will be formulated to meet Federal standards concerning the amount of lead in the dried film.</p>			
PHYSICAL CONSTANTS			
<p>WEIGHT PER U.S. GALLON (MIXED) (varies by color) 8.48 - 10.59 lbs/gal</p> <p>PERCENT SOLIDS BY WEIGHT (MIXED) (varies by color) 58.6% - 69.2%</p> <p>PERCENT SOLIDS BY VOLUME (MIXED) (varies by color) 52.4% - 59.0%</p>		<p>FLASH POINTS</p> <p>AUE-400LG Pensky-Martens 99°F (37°C) AUE-421 Pensky-Martens 80°F (27°C) UA-11 Pensky-Martens 96°F (36°C) VOC (MIXED) <3.5 lbs/gal (varies by color)</p>	
<p>READY TO SPRAY VISCOSITY (varies by color) #3 Zahn 13-16 seconds #2 Zahn 45- 55 seconds</p>			
PERFORMANCE FEATURES			
<p>PENCIL HARDNESS: HB-F (varies by color)</p> <p>FLEXIBILITY (CONICAL MANDREL) Pass</p> <p>FADE RESISTANCE Exposure studies confirm that the fade resistance of the Low VOC AUE-400LG finish is significantly better than that of most interior/exterior polyurethane enamels.</p> <p>96 HOUR HUMIDITY RESISTANCE Excellent</p>		<p>SHEEN AUE-400LG Low VOC Polyurethane Enamel is supplied as a low gloss finish (15 -30 on a 60° gloss meter).</p> <p>ADHESION Excellent</p> <p>IN SERVICE TEMPERATURE LIMITATIONS 300°F Note: As you approach 300°F, depending on the pigmentation, the color may change, but film integrity will be maintained until 300°F.</p>	
CHEMICAL/SOLVENT RESISTANCE			
10% SULFURIC ACID	Excellent	10%HYDROCHLORIC ACID	Excellent
10%AMMONIA	Excellent	10%SODIUM HYDROXIDE	Excellent
XYLENE	Good	ISOPROPYL ALCOHOL	Excellent
OIL	Excellent	GASOLINE	Excellent
500 HOURS SALT SPRAY	Very Good		
<p>WATER RESISTANCE: Resistant to intermittent exposure. Not recommended for immersion</p>			



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 Primers	Direct To Properly Treated Substrate
Cold Rolled Steel	CRE- 9XX, HBA-4035, HBA 9XX, EPX-900, HSP-2128, HSP-900/902, PLC-900	Excellent
Hot Rolled Steel	CRE-9XX, HBA-4035, HBA 9XX, EPX-900, HSP2128 HSP-900/902, PLC-900	Excellent
Galvanized	CRE-9XX, EPX-900, HBA4035, 9XX, HBA-9XX, HSP-2128, HSP-900/902, PLC-900	Fair
Galvaneal	CRE-9XX, EPX-900, HBA-4035, 9XX, HSP-2128, HSP-900/902, PLC-900	Fair
Aluminum	CRE-9XX, HBA-4035, HBA-9XX, EPX-900, HSP-2128, HSP-900/902, PLC-900	Good – Very 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. To each pigmented gallon of AUE-400LG component A (103.5 oz.), add the entire contents of 1 quart container (18.5 oz) of AUE-421, component B (clear curing agent), and 6 oz of UA-11 Urethane accelerator, component C. Agitate thoroughly and allow it to digest 5 minutes before using. 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.

THINNING

Recommend thinning to 3.5 VOC with MEK, or other PPG urethane grade reducers.

POT LIFE

77°F (25°C) 2 to 2 1/2 Hours

Note: Higher temperatures and high humidity will shorten pot life.

RECOMMENDED WET FILM BUILD (Mixed)

Spray Application: 2.7 - 4.0 mils

RECOMMENDED DRY FILM BUILD

1.5 - 2.0 mils

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.

APPLICATION EQUIPMENT

Conventional Spray: 50-60 psi at the gun.

DRYING TIME

3 mils wet at 77 °F (25 °C) and 50% relative humidity.

To Touch:	30 minutes- 1 hour
To Handle:	2-3 hours*
Dry:	24 hours**
Recoat:	2 hours to 4 days
Force Dry:	(allow 10 minutes air dry)
Bake:	10 minutes @ 180 °F
Bake:	20 minutes @ 140 °F
Bake:	30 minutes @ 120 °F

* 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.

Application of film thickness in excess of that recommended for this product will substantially extend dry time and lengthen the recoat window.

RECOMMENDED SPREADING RATE

840-946 sq. ft. at 1.0 mil dry film per U.S. gallon (varies by color). Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularities or porosity.

CLEAN UP

PPG Urethane Reducer or 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.

Brush and roller application is not recommended.

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 (304) 843-1300. 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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