



AUE-280LG / AUE-281

CPC 54

2.8 VOC Polyurethane Enamel - LG

PRODUCT DESCRIPTION																			
AUE-280LG 2.8 VOC POLYURETHANE ENAMEL – LG Component A		AUE-281 CATALYST FOR AUE-280 Component B																	
<p>TYPE: Polyurethane</p> <p>RECOMMENDED USE</p> <p>AUE-280LG is a high performance, low gloss polyurethane topcoat which conforms to 2.8 lbs/gal VOC limits in regulated areas. This product has excellent durability in interior or exterior applications.</p> <p>AUE-280LG is particularly suited for use on electronics components, cabinets, machinery, metal furniture, exterior signs and metalwork.</p> <p>AUE-280LG base may be mixed with AUE-280 base to obtain intermediate gloss levels (see suggestions below).</p> <p>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.</p>																			
PHYSICAL CONSTANTS																			
<p>WEIGHT PER U.S. GALLON (MIXED) (varies by color) 8.7 – 10.3 lbs./gal</p> <p>PERCENT SOLIDS BY WEIGHT (MIXED) (varies by color) 45.0 – 58.0</p> <p>PERCENT SOLIDS BY VOLUME (MIXED) (varies by color) 32.0 – 42.0</p>		<p>FLASH POINTS</p> <table border="0"> <tr> <td>AUE-280LG</td> <td>Pensky-Martens</td> <td>14°F (-10°C)</td> </tr> <tr> <td>AUE-281</td> <td>Pensky-Martens</td> <td>334°F (168°C)</td> </tr> </table> <p>VOC (RTS) <2.8 lbs./gal</p>		AUE-280LG	Pensky-Martens	14°F (-10°C)	AUE-281	Pensky-Martens	334°F (168°C)										
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READY TO SPRAY VISCOSITY (varies by color) #3 Zahn 10-20 seconds																			
PERFORMANCE FEATURES																			
<p>PENCIL HARDNESS HB – H (varies by color)</p> <p>FLEXIBILITY (Conical mandrel) Excellent</p> <p>SHEEN 60° Gloss = 10 – 20 (as supplied) AUE-280LG may be blended with AUE-280 to achieve:</p> <table border="1"> <thead> <tr> <th>Description</th> <th>60° Gloss</th> <th>AUE-280LG Parts (by vol)</th> <th>AUE-280 parts (by vol)</th> </tr> </thead> <tbody> <tr> <td>Matte / Eggshell</td> <td>10-20</td> <td>1</td> <td>0</td> </tr> <tr> <td>Satin</td> <td>20-40</td> <td>4</td> <td>1</td> </tr> <tr> <td>Semi-Gloss</td> <td>40-60</td> <td>2</td> <td>1</td> </tr> </tbody> </table>		Description	60° Gloss	AUE-280LG Parts (by vol)	AUE-280 parts (by vol)	Matte / Eggshell	10-20	1	0	Satin	20-40	4	1	Semi-Gloss	40-60	2	1	<p>96 HOUR HUMIDITY RESISTANCE Excellent</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.</p>	
Description	60° Gloss	AUE-280LG Parts (by vol)	AUE-280 parts (by vol)																
Matte / Eggshell	10-20	1	0																
Satin	20-40	4	1																
Semi-Gloss	40-60	2	1																
CHEMICAL/SOLVENT RESISTANCE																			
10% SULFURIC ACID	Excellent	10%HYDROCHLORIC ACID	Excellent																
10%AMMONIA	Excellent	10%SODIUM HYDROXIDE	Excellent																
XYLENE	Good	ISOPROPYL ALCOHOL	Very Good																
OIL	Excellent	GASOLINE	Very Good																
500 HOURS SALT SPRAY	Very Good																		
WATER RESISTANCE: Resistant to intermittent exposure. Not recommended for immersion																			

SURFACE PREPARATION

For optimum performance, surface to be coated should 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	HBA-4035, HSP-900/902; HSP-2128, CRE-904/907, EPX-900	Very Good
Hot Rolled Steel	HBA-4035, HSP-900/902; HSP-2128, CRE-904/907, EPX-900	Very Good
Galvanized	HSP-900/902, HSP-2128; CRE-904/907, EPX-900	Very Good
Galvaneal	HSP-900/902, HSP-2128; CRE-904/907, EPX-900	Very Good
Aluminum	HSP-900/902, HSP-2128; CRE-904/907, EPX-900	Fair
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.

Mix 24 oz of CPC tints into the AUE-280LG base to create a mix color "A" side.

Mix 6 Parts of pigmented AUE-280LG to 1 Part of AUE-281 Hardener (6:1). No accelerator is required.

AUE-280LG is blended at a 6:1 ratio for all low and intermediate glosses.

NOTE: Moisture contamination in components can result in poor properties of applied films or gelation of the material. Do not open until ready to use. **DO NOT USE LACQUER THINNERS FOR CLEANING LINES.**

THINNING

Additional thinning is not recommended for this product.

POT LIFE

3 – 4 hours at 75°F.

Note: Higher temperatures will shorten pot life.

RECOMMENDED WET FILM BUILD (Mixed)

Spray Application: 3.0 – 7.0 mils

RECOMMENDED DRY FILM BUILD

1.5 – 2.5 mils

Film in excess or below these recommended film builds may cause problems such as poor adhesion, solvent popping, runs, sags, or extended dry times.

APPLICATION EQUIPMENT

Conventional Spray: 55-65 psi at the gun.

DRYING TIME**

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

Touch: 20 – 30 minutes

Handle: * 60 – 90 minutes

May Topcoat: After 1 hour, before 3 days

* 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.

**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

520 – 700 sq. ft. at 1.0 mil dry film per U.S. gallon (varies by color). Spreading rate figures do not include losses due to thinning, transfer, application of coating, or losses due to surface irregularities or porosity.

CLEAN UP

Please use MEK (Q60). **Do not use Lacquer Thinner. Moisture and/or alcohol content of Lacquer Thinner may cause gelling or thickening of material remaining in lines and spray guns.**

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 (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.**

For further information, please contact the PPG Customer Focus Center toll-free at (800) 647-6050 or (888) 310-4762 in Canada.

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