



# AMERICAN COATINGS

## AX SERIES AUTO PRIMER SURFACER

A multifunctional Epoxy primer designed for Automotive type topcoats

### GENERAL FEATURES

- HIGH SOLIDS and LOW VOC
- FUNCTIONS AS A PRIMER - SEALER OR A PRIMER - SURFACER
- CAN BE SANDED IN 8 HRS (AT 70° F) FOR OPTIMUM SMOOTHNESS
- AN EXTENDED RECOATABILITY WINDOW OF UP TO 7 DAYS WITHOUT SANDING
- EXCELLENT CORROSION PROTECTION

### USES

American AX Series Epoxy has been designed to be a premium automotive quality primer that can be used as a traditional primer or as a primer surfacer. AX Series can be topcoated with American Coatings epoxies, polyurethanes, and acrylics.

**NOTE:** AX Series Primers may be topcoated up to 12 months, however, follow good painting practices by removing dirt, chalk, and other foreign matter. Degrease with TH150 and sand if aged over seven days.

### PRODUCTS

AX 8733	GRAY
AX 8730	RED OXIDE

### PHYSICAL DATA

Finish ----- Semi Gloss  
 Color ----- Gray and Red Oxide  
 Applied Over properly prepared----- Steel, Aluminum, galvanized surfaces, and polyester bodyfillers.  
 Components ----- Two  
 Cure ----- Catalytic 4:1 w/AX Cat  
**Volume Solids ± 2 %** ----- 44 %  
**V.O.C.** ----- 3.2 #/gal.

### **Recommended Dry Film**

**Thickness** ----- 0.8 – 2.2 mils  
 Number of Coats ----- one or two  
 Application Method ----- Airless or Conventional Spray

### **Thinning Required**

For Conventional Spray ----- Not Required

Dry Time @ 77° F and 50 % RH:

Touch -----30 min.  
 Recoat ----- 30 min.  
 Sand ----- 8 – 10 hours

Theoretical Coverage at:

Recommended Thickness-----882 – 321 sq. ft/gal

### Temperature Sanding Chart

	77° F	90° F	100° F	125° F
SAND	8 HRS	6 HRS	4 HRS	2 HRS

### Miscellaneous Properties

Shelf Life ----- 1 year  
 Pot Life – Mixed @ 77° F----- 10 hours  
 Pot Life – Mixed @ 90° F-----8 hours  
 Pot Life shortens as ambient temperatures rise.

### SURFACE PREPARATION

Prior Painted Surfaces – degrease with TH150 and sand.  
 Galvanized Steel – degrease with TH150 and sand.  
 Aluminum – degrease and sand. Wash primers or other chemical preparations are not necessary.  
 Steel – remove milscale and other foreign matter either by sandblast or other mechanical means. Degrease with TH150 to insure cleanliness.  
 Fiberglass and Polyester bodyfiller – sand.



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## APPLICATION INFORMATION

Supplied at a viscosity of 30 – 35 seconds Zahn 2 at 77° F.

## APPLICATION METHOD

Almost any method of spray equipment to include conventional air, air assisted, and airless.

## MIXING

Thoroughly mix Part B in Part A taking care to get good color consistency. Induction time is 30 minutes. Pot-life is 10 hrs at 77° F but shortens as ambient temperature rises

## CLEAN-UP AND THINNING

Thinning is not usually required. Cleanup can be done using TH600 or TH315 solvent.

## SPRAY EQUIPMENT FOR AIRLESS SPRAY

Pump Ratio ----- 30:1  
Air Supply (in) ----- 100 psi  
Hose Diameter (ID) ----- 1/4"  
Hose Length ----- 75'  
Tip Size ----- .011 - .015  
Atomization Pressure ----- 2,400

## FOR CONVENTIONAL SPRAY

Spray Pot Having Dual Regulated Air Gauges for Pot Pressure and Atomization Air

Air Supply (in) ----- 100 psi  
Material Hose (ID) ----- 1/2"  
Material Hose Length ----- 25 – 50'  
Air Hose (ID) ----- 5/16"  
Fluid Pressure (psi) ----- 50 - 60 psi  
Fluid Tip Orifice Size (in) ----- .050 - .060"

## SAFETY INFORMATION

**WARNING! FLAMMABLE, HARMFUL IF INHALED, CAUSES IRRITATION**

Keep away from heat, sparks or flames. Vapors may cause flash fire. Use with adequate ventilation. Do not breathe vapors or spray mist. Wear an appropriate, properly fitted respirator during and after applications unless air monitoring demonstrates vapor/mist levels are below applicable limits. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

## SHIPPING DATA

Proper Shipping Name ----- Paint Liquid  
Hazard Class----- Flammable Liquid

Flash Pt. °F SETA ----- 80° F Part A  
80° F Part B

UN No.----- 1263

## PACKAGING

<u>Shipping Wt.</u>	<u>PART A</u>	<u>PART B (AX Cat)</u>
	Ones 11.94 lbs.	Qts. 1.54 lbs.
	Fives 47.77 lbs.	Ones 7.7 lbs.

### DISCLAIMER

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