

OEM 2.1 VOC Clearcoat

AUE-20

AUE-20 is a one-visit, high gloss clearcoat that is easy-to-spray. It is designed to be a part of premium industrial coating systems and delivers excellent sag resistance properties while also providing superior durability and UV resistance.

AUE-20 is designed for use over the AUE-080, AUE-280, AUE-300, AUE-360 and AUE-370 topcoats.

Features and Benefits:

- Excellent appearance and sag resistance
- High gloss and DOI
- Superior durability and UV protection

Associated Products:

- AUE-20 OEM 2.1 VOC Clearcoat
- Q99 High Temperature/High Pressure Reducer
- Q93 Medium Exempt Reducer
- GXH1086 Urethane Hardener
- UA-11 Urethane Accelerator

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

	AUE-20	AUE-20/Q99/GXH1086	AUE-20/Q93/ GXH1086 + optional 1 oz UA-11
Weight per gallon (US)	9.46 lbs/gal	9.66 lbs/gal	9.69 lbs/gal
Percent solids (by weight)	39.5%	39.60%	39.00%
Percent solids (by volume)	41.2%	41.10%	40.70%
VOC less water (less exempts)	278 g/L 2.32 lbs/gal	252 g/L 2.10 lbs/gal	250 g/L 2.09 lbs/gal
HAPs	.81 lbs/gal	.54 lbs/gal	.54lbs/gal
Photo-chemically reactive	NO	NO	NO
Flashpoint	AUE-20 = 100 °F (38°C), Q99 = 100 °F (38°C), GXH1086 = 102°F (39°C), Q93 = 109 °F (43°C), UA-11 = 96°F (36°C)		

Directions for Use:

Substrate Preparation:

The surface to be coated should be free of all contamination (including dust, dirt, oil, grease and oxidation). Please use an appropriate PPG cleaner/degreaser per local environmental regulations.

AUE-20

Directions for Use (continued)

Mix Directions:



Mix Directions:

Extra agitation is not necessary prior to adding hardener

Thinning:

Additional thinning is not recommended

Blend Ratio (Vol.):

AUE-20	GXH1086	Q93 or Q99	UA-11
4	1	1/2 -1	1 oz./RTS gal. optional



Pot Life @ 77°F (25°C):

1.5 Hours – 3 Hours Dependant on RTS Mix

Spray Viscosity Range:

#2 EZ Zahn – 21 - 26 Seconds



Unopened Shelf Life:
(each component)

AUE-20: 4 years unopened, 1 year opened
Q93, Q99: 4 years unopened, 1 year opened
GXH1086: 2 years unopened, 14 days opened

Application Equipment:



Conventional/Compliant
(with or without pressure pot):

1.2 – 1.4 mm needle/nozzle with 45 – 55 psi at the gun

HVLP

(with or without Pressure Pot):

1.2 – 1.5 mm needle/nozzle with 10 psi at the cap or per manufacturer

Airless:

.010 - .013 fluid nozzle, 2100 – 2400 psi fluid pressure

Air-Assisted Airless:

.010 - .011 fluid nozzle, 1200 -1600 psi fluid pressure. Use minimum air pressure as possible to prevent tails in the spray pattern.

Brush or Roll:

No Recommendation

Electrostatic:

No Recommendation

Application:



Apply:

Allow color to dry a minimum of 1 hour prior to clearcoating
Apply one medium cross-coat of AUE-20 clearcoat
Maximum dry time of color before clearcoating*

- AUE-080 = 4 days
- AUE-280 = 4 days
- AUE-300 = 4 days
- AUE-360 = 1 day
- AUE-370 = 7 days

*After maximum dry time, color must be sanded prior to clearcoat application

Recommended Wet Film Build:

3.5 mils minimum

Recommended Dry Film Build:

1.5 mils minimum

Coverage:

658 sq. ft. @ 1.0 mil dry film per U.S. gallon

Dry Times:



Air Dry @ 77°F (25°C) 50% RH:

AUE-20 RTS

Dust-Free:

1 - 2 Hours

Handle:

3 - 5 Hours

Tape:

8 Hours

Recoat:

60 minutes to 3 days

Force Dry @ 140°F (60°C)

30 minutes after 15 minute flash

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Technical Data*

Performance Properties:

DA 180 sanded CRS

CRE-321

AUE-370

AUE-20

Test	ASTM Method	AUE-20
Pencil Hardness	D3363	HB/B
Mandrel	D522	Minor Cracking
Chip Resistance	D3170	7
Gloss - 60°	D523	100
Adhesion	D3359	5B
In service temperature limit		300°F (149°C)

Chemical Resistance:

Blasted HRS

CRE-321

AUE-370

AUE-20

Chemical ASTM D1308	AUE-20
10% NaOH (Sodium Hydroxide)	Pass
Skydrol	Mild blistering and slight ring
Gasoline	Mild ring
10% H2SO4 (Supphuric acid)	Pass
Antifreeze	Pass
Jet Fuel A	Pass

Weather Resistance:

Blasted HRS

CRE-321

AUE-370

AUE-20

	ASTM Method	AUE-20
Humidity – 100 hours		
	D2247	
5 Minute Recovery Adhesion	D3359 Method B	5B
1 Hour Recovery Adhesion	D3359 Method B	5B
24 Hour Recovery Adhesion	D3359 Method B	5B
QUV-UVA: 60° angle		
	D4587	
250 hour retention	D523	100%
500 hour retention	D523	100%
QUV-UVB: 60° angle		
	D4587	
250 hour retention	D523	100%
500 hour retention	D523	100%

All tests results assume proper cure and preparation of test substrates.

* 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.

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 and in MEXICO 01-800-00-21-400. Have label information available.



Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.



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