

AQ100 (Spray) / AQ056 (Dip) WATERBASED High Gloss DTM

AQ100 CLEAR PAIL	634240494850	AQ056 BLACK PAIL	634240411294
AQ100 CLEAR DRUM	634240433849	AQ056 BLACK DRUM	634240432884
AQ100 CLEAR TOTE	634240439448	AQ056 BLACK TOTE	634240420035

PRODUCT INFORMATION

PRODUCT DESCRIPTION

AQ100 & AQ056 DTM are direct to metal spray and dip topcoats with industry leading early water resistance properties and extremely fast dry times. Formulated using Royal's proprietary Flash Dry Technology helps fabricators reduce paint drying bottle necks. In addition to its outstanding protection properties, it significantly reduces the hazards of working with volatile compounds found in other VOC coatings. Neither can ignite and because they do not create any toxic vapors, the odor, headaches, and nausea often associated with other coatings are completely eliminated. Both provide greater performance on metals and greater health protection for workers.

PRODUCT CHARACTERISTICS

Finish	Gloss
Color	Black, Clear
Volume Solids	44% ± 2%, may vary by color
Weight Solids	47% ± 2%, may vary by color
VOC	<5 g/L; 0.042 lb/gal

RECOMMENDED SPREADING RATE PER COAT

	Minimum	Maximum
Wet mils	3.0	4.5
Dry mils	1.32	2.00
~Coverage sq ft/gal	235	157
Theoretical coverage sq ft/gal @ 1 mil dft	706	

DRYING SCHEDULE @ 4.0 MILS WET @ 50% RH

	@ 40°F	@ 77°F	@ 120°F
To touch	30 minutes	10 minutes	10 minutes
Tack-Free	5 hours	45 minutes	45 minutes
Dry-Hard	6 hours	2 hours	1 hour
To handle	7 hours	2.5 hours	1.5 hours
To recoat	10 hours	2.5 hours	1.5 hours

If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent. In high humidity use airflow to improve dry time.

Shelf Life	12 months, unopened at 77°F Protect from freezing
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RECOMMENDED USES

Flash Point >230F Closed Cup

Reducer/Clean Up Water

If Dried, clean with a blend of ammonia and water 1:9.
Spray equipment may also be cleaned with MIBK. After Cleaning,
flush equipment with solvent to prevent rusting.

For industrial and commercial application to steel for
protection against atmospheric corrosion.

In some cases, this primer can be top-coated with solvent based
urethanes and epoxies depending on solvent blend. A test patch is highly
recommended to test compatibility.

PERFORMANCE CHARACTERISTICS

ASTM D522 Flexibility, 180deg, 3/8"

ASTM D4541 Full adhesion 1,000 lbs/in²

ASTM D1308 Chemical Resistance

Gasoline & Crude oil

ASTM D523 Specular Gloss: 60deg = 86

LIMITATIONS

High humidity will slow drying

Excessive film thickness may cause mudcracking

Due to the wide variety of substrates, surface preparation methods and applica-
tion methods and environments, the full system should be tested for adhesion and
compatibility prior to full scale application.

SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease,
dirt, loose rust, fingerprints and other foreign material to ensure good adhesion.

For maximum performance, the surface must be abrasive blasted
for proper adhesion. All blasted steel must be primed the same day.

IRON AND STEEL

Remove all grease and oil from the surface by solvent cleaning using a
non-hydrocarbon solvent per SSPCSP1. Minimum surface preparation is Hand
Tool Clean per SSPC-SP2. For optimum performance, the surface should be blast
cleaned to Commercial Blast Clean per SSPC-SP6.

APPLICATION CONDITIONS

Temperature 40°F minimum, 100°F maximum
(air, surface, and material).
At least 5°F above dew point



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APPLICATION METHODS

AIRLESS SPRAY

CONVENTIONAL

BRUSH

CAUTIONS

Relative humidity 85% maximum

Airless Spray, Conventional, Roller and Brush, Dip

Unit: 1500 - 2100 psi **Tip:** .011 - .013 **Filter:** 60 Mesh **Cap/Tip:** 704FF

Air Pressure: 45-55 psi **Fluid Pressure:** 10-15 psi **Hose:** 1/4"

Reducer: Water **Reduction Rate:** Up to 10%

Confine to small areas and touch-up.

Refer to MSDS Sheet before use.

NOTE: SOLVENT BASED COMPATIBILITY SHOULD BE CHECKED PRIOR TO USE.

AQ100 & AQ056 is extremely sensitive to hydrocarbon containing solvents. When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse. Do not use hydrocarbon solvents.

During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. Avoid these conditions for the first 24 hours.

Stripe coat all crevices, welds, and sharp edges to protect against early failure in these areas. For best results on rusty surfaces, always apply first coat by brush. No painting should be done immediately after a rain or during foggy weather.

DO NO USE HYDROCARBON SOLVENTS FOR CLEANING.

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Royal Coatings representative for additional technical data and instructions.

SAFETY PRECAUTIONS

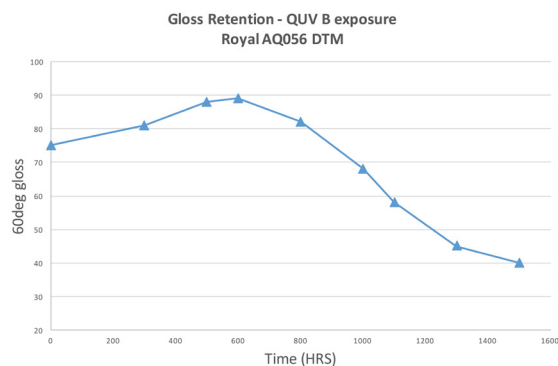
WARRANTY

Royal Coatings warrants our products to be free of manufacturing defects in accordance with applicable Royal's quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Royal Coatings.

NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY ROYAL COATINGS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

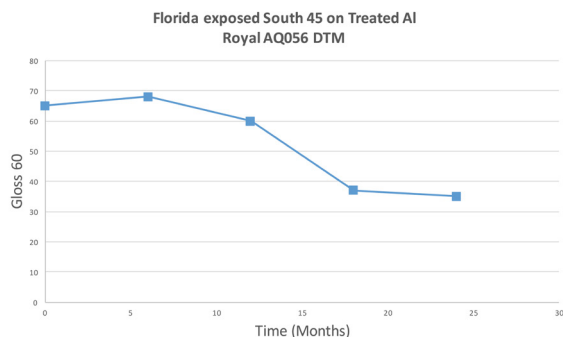


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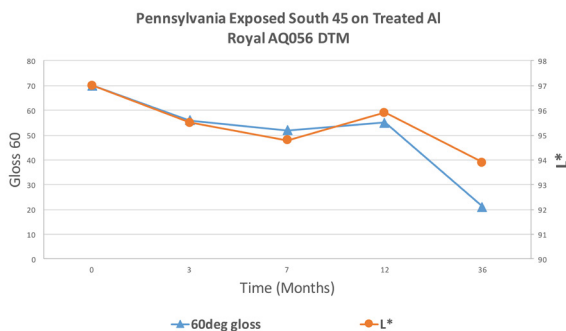
June 2016

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