


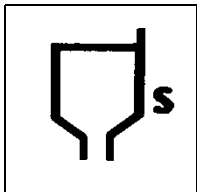
 **Base:**
10P20-44MNF
 **2 parts**

Curing Solution:
EC-291B
 **1 part**

Thinner/Reducer:
TR-114* or TR-102**
 **1 part**



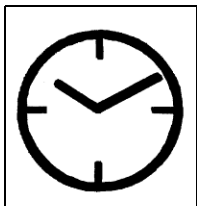
At 77°F (25°C):

| | | |
|------------------------|------------------------------------|---|
| Mix Viscosity: | 13 – 16 seconds Zahn-Cup #2 | *TR-114 is a VOC exempt and HAPS free thinner **TR-102 is a non-exempt thinner that raises the total VOC |
| | 15 – 25 seconds ISO-Cup #4 | |
| Pot life: | 4 Hours | |
| Induction Time: | 15 Minutes | |



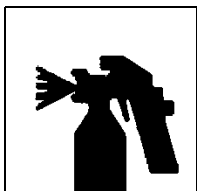
One coat needed: **Spray a single uniform wet coat to a dry film thickness of 15 – 25 micron (□m) (0.6 – 0.9 mils).**

Dry film thickness: **0.6 to 0.9 mils (15 – 25 microns)**



At 75 to 80°F & 50% RH

| | |
|------------------------|--|
| Dry to Topcoat: | 3 hours |
| Dry to Tape: | 3 – 4 hours |
| Clean Up: | Use TR-36, Solvent Cleaning C28/15, MEK |



| Type equipment | Tip Size | Gun Air Pres. | Pot Air Pres. | Other |
|---------------------------------------|----------------|---------------|---------------|-----------------|
| Air Assisted Airless Electrostatic | .011 - .013 in | 65-75 psi | 850-1000 psi | Graco PRO4000AA |
| HP Air Assisted Airless Electrostatic | .009 - .013 in | 60-75 psi | 1800-2500 psi | Graco PRO4500AA |

We have taken reasonable care in preparing the Mixing Guide and in collecting and preparing material for inclusion in it but do not represent or warrant that it is free from error or that the information content is complete or accurate. The information is advisory only and the use of the Material is solely at your own risk.