



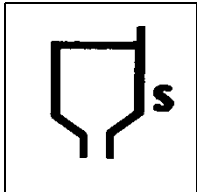
	<b>Base:</b> 10P20-44		<b>Curing Solution:</b> EC-265 or EC-273 1 part		<b>Thinner/Reducer:</b> TR-114* or TR-102** 1 part (optional but recommended)
		3 parts			



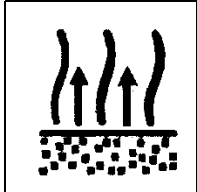
**At 77°F (24°C):**

<b>Mix Viscosity:</b>	13 – 19 seconds Zahn-ISO #2	*TR-114 is a VOC exempt and HAPS free thinner **TR-102 is a non-exempt thinner that raises the total VOC
<b>Pot life:</b>	15 – 21 seconds ISO-Cup #4 4 hours w/ Thinner 1 Hour w/ No Thinner	
<b>Induction Time:</b>	None required	

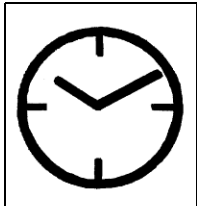


**One coat needed:** Apply one full wet closed coat. Avoid runs and sags. The high solids content causes a rapid film build-up.

**Dry film thickness:** 0.6 to 0.9 mils (15 – 23 microns)



**Primer can be topcoated in 2 to 2½ hours at 77°F (25°C).**  
(see Technical data sheet for details)



<b>At 75 to 80°F &amp; 50% RH</b>	<b>Dry to Topcoat:</b>	2¼ hours
	<b>Dry to handle:</b>	8 – 12 hours
	<b>Dry to tape:</b>	2¼ hours
	<b>Full Cure:</b>	7 days
	<b>Clean Up:</b>	Use MEK



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
HVLP	1.4 mm			Iwata, Sata, Binks Mach 1
Low Pres. Electrostatic	1.2 mm			PRO3500, 4500SC
Air Assisted Electrostatic	.28 - .33 mm			PRO4000AA

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.