



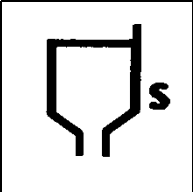
	Base: 20P1-21		Curing Solution: PC-235
 	3 parts		1 part

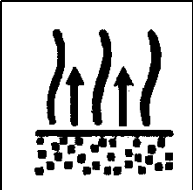


At 77°F (25°C):

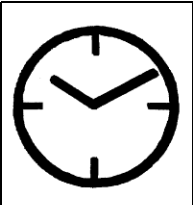
Mix Viscosity:	32 – 44 seconds 4 mm ISO Cup.
	19 – 24 seconds #2 Signature Zahn Cup.
	18 – 22 seconds # 4 Ford Cup.
Pot life:	4 Hours
Induction Time:	15 minutes



Coats needed:	Spray apply one or two uniform wet coats to recommended dry film thickness
Dry film thickness:	0.8 – 1.2 mils (20 – 30 microns)



- The ambient cure schedule is affected by relative humidity. 14-day room temperature cure requires a minimum 50% RH.
- The following accelerated cure schedule generally results in maximum chemical resistance properties for this coating: flash-off 2 hrs @ ambient conditions, followed by 4 hours at 70°C/158°F.



At 75 to 80°F & 50% RH

Tack free:	3 Hours Max
Dry hard:	12 Hours Max
Full cure:	14 Days
Clean Up:	MEK or a VOC Compliant Solvent Blend



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
HVLP	1.4 mm (.055 inch)	8-25 psi	Varies w/pot size	Iwata, Sata, BinksMach 1

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.