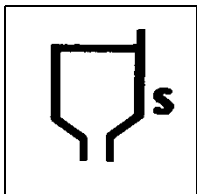


Base:
20P20-3
3 parts

Curing Solution:
PC-232
1 part

Thinner(optional):
TR-102 or TR-114
Up to 1 Part



At 77°F (25°C):

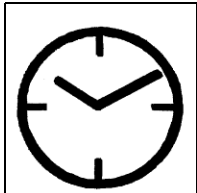
Mix Viscosity: 19 – 27 seconds Ford #4 (without thinner)
Pot life: 4 Hours
Induction Time: See Below Note



Coats needed: See Note Below
Dry film thickness: 1.5 to 3.0 mils (38 – 76 microns)

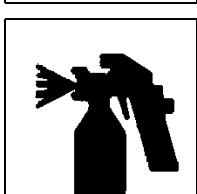


Note: If ambient temperature is above 90°F (32°C), add 1 pint of TR-114 to every mixed gallon, to increase pot life and flow-ability. Apply one full wet coat (3 mils WFT) and flash 15 minutes. Apply second full wet coat (3 mils WFT). Wait 2 hours to sand or apply topcoat. Continuous coats can be applied until desired film thickness has been achieved. Do not bake this coating as solvent pop will appear.



At 75 to 80°F & 50% RH

Dry to handle: 1 Hour
Dry to sand: 2 Hours (Depending on film thickness)
Dry to overcoat: 2 Hours Minimum, 24 Hours Maximum
Clean Up: Use TR-19, or MEK



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
HVLP	1.2 – 1.4 mm	8-25 psi	Varies w/pot size	Iwata, Sata, BinksMach 1