

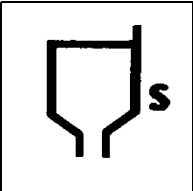

**Base:**  
**454-4-1**  
**3 parts**

**Curing Solution:**  
**CA-109**  
**1 part**

**Thinner (optional):**  
**TL-52**  
**0 - .25 part**



**At 75-80°F:**  
**(24-27°C)**
**Mix Viscosity:**  
**10 – 40 seconds ISO Cup # 4**  
**10 – 20 seconds Signature Zahn Cup # 2**  
**10 – 20 seconds Ford Cup # 4**  
**Pot life:**  
**8 Hours**  
**Induction Time:**  
**30 minutes**



**Coats needed:** **Spray a single wet coat.**  
**Dry film thickness:** **0.3 – 0.8 mils (8 – 20 µm microns)**



**At 75 to 80°F & 50% RH**  
**Dust-free at RT:** **30 minutes Maximum**  
**Tack-free at RT:** **3 Hours Maximum**  
**Dry Hard at RT:** **12 Hours Maximum**  
**Force cure (recommended):** **30 Minute Ambient flash, Followed by 1 Hour at 71°C/160°F**  
**Clean Up:** **Use TR-36 or MEK**



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
Conventional spray gun	1.2-1.4 mm	55-65 psi	6-12 psi	Low transfer efficiency
HVLP	1.2-1.4 mm	8-25 psi	Varies w/pot size	Iwata, Sata, BinksMach 1
Low Pres. Electrostatic	1.2-1.5mm	35-45 psi	12-100 psi	PRO3500, 4500SC
Air Assisted Electrostatic	.023-.028 mm	55-65 psi	2000-3000 psi	PRO 4500AA 360 -400 cc/min.

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.