


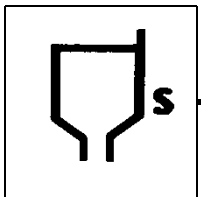




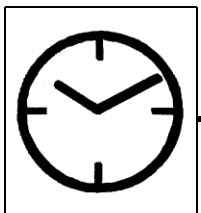
| | | |
|--|--|---|
|  Base: 463-12-8 1 parts |  Curing Solution: CA-116 1 part |  Curing Solution: TR-19 or TR49, C25/90S 0 - 0.25 part (as needed) |
|--|--|---|



| | | |
|--|------------------------|---|
| At 75-80°F: (24-27°C) | Mix Viscosity: | 26 – 34 seconds ISO Cup #3 |
| | | 26 – 36 seconds Signature Zahn Cup # 1 |
| | | 14 – 22 seconds Signature Zahn Cup # 2 |
| | Pot life: | 8 Hours |
| | Induction Time: | 30 minutes Recommended |



| | |
|----------------------------|---|
| Coats needed: | Spray a single uniform wet coat to recommended dry film thickness. |
| Dry film thickness: | 1.0 – 1.3 mils (25 - 33 microns) |



| | |
|-----------------------------------|---|
| At 75 to 80°F & 50% RH | |
| Dust free: | 15 Minutes |
| Dry to stack: | 1 Hour |
| Dry through: | 4 Hours |
| Dry to topcoat: | 1 Hour Minimum to 48 Hours Maximum |
| Clean Up: | Use TR-19 or MEK |



| Type equipment | Tip Size | Gun Air Pres. | Pot Air Pres. | Other |
|----------------------------|-----------------|----------------------|----------------------|-----------------------------|
| HVLP | 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 | .28-.33 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.