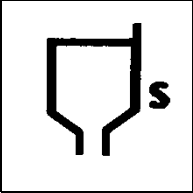





**Base:**  
 656-58 Series  
 3 parts


**Curing Solution:**  
 X-503  
 1 part



**At 77°F (25°C):**

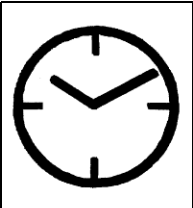
**Mix Viscosity:** 15 – 30 Seconds #4 Ford Cup  
 17 – 32 Seconds Signature Zahn-Cup #2  
 25 – 75 Seconds ISO cup #4

**Pot life:** 4 hours  
**Induction Time:** 30 minutes



**Coats needed:** Spray a single wet coat. Allow 15 – 30 minutes flash-off .  
 Apply a second wet coat.

**Dry film thickness:** 1.7 to 2.3 mils (43 – 58 microns)



**At 75 to 80°F & 50% RH**

**Dry to Touch:** 4 Hours  
**Dry to Tape:** 8 Hours  
**Clean Up:** Use TR-19, TR-36, C28/15, MEK or a VOC-compliant solvent blend.



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
HVLP	1.2 - 1.4 mm	<45 psi	5 – 15 psi	Iwata, Sata, BinksMach 1
Air Assisted Electrostatic	.023 - .028 mm	55 – 65 psi	1800 – 2500 psi	PRO 4500AA