

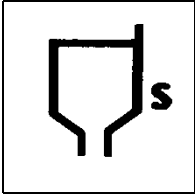
**Base:**  
4001PS002  
**4 parts**



**Curing Solution:**  
CS4902  
**1 part**



**Thinner/Reducer:**  
TR-114 (optional)  
**0 – 1 part**



**At 75-77°F:**  
**(24-25°C)**

**Mix Viscosity:**  
  
**Pot life:**  
**Induction Time:**

**18-25 seconds Signature Zahn #2**  
**20-28 seconds Ford Cup #4**  
**40-70 seconds ISO Cup #4**  
**2 hours W/O thinner 4 hours With Thinner**  
**15 Minutes**

**\*TR-114 is a VOC exempt and HAPS free thinner**

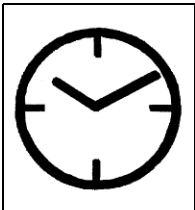


**Coats needed:**

**Apply Alumigrip 4001 using a cross coat method to achieve the desired film thickness.**

**Dry film thickness:**

**As Primer: 0.6 – 1.0 mils. (15 – 25 microns)**  
**As Surfacer: 3 – 6 mils. (75 – 150 microns)**



**At 75 to 80°F & 50% RH**

**Dry to Sand:**  
**Dry to Topcoat:**

**Approx. 3 Hours depending on the film thickness.**  
**As Primer: 2 Hours Minimum, 48 hours Maximum**  
**As Surfacer: 72 Maximum after sanding**

**Recoatable Minimum:**  
**Recoatable Maximum:**  
**Clean Up:**

**None, wet on wet application**  
**1 hour**  
**MEK, MPK, or applicable cleaning solvent**



**Type equipment**

**Tip Size**

HVLP	1.4mm (.055inch)
Low Pres. Electrostatic	0.6mm (.024inch)
High Pressure	
Air Assisted Electrostatic	0.5mm(0.018inch)