



Base:
4200GXXX
1 parts



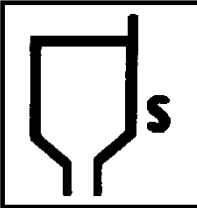
Curing Solution:
PC-242
1 part



Activator:
A4950 (AC-139), A4951,
A4952, A4953 or A4954
.125 part



Thinner: optional
TR-115
Up to .06 parts



At
77°F:
(25°C)

Mix Viscosity: 35 - 50 seconds ISO Cup #4, 17 - 22 seconds Zahn-Cup #2, Signature series

Pot life: Depends on activator chosen. See Technical Data Sheet

Induction Time: 15 Minutes Exception: 4200G90006 (black) needs 30-45 minute induction.

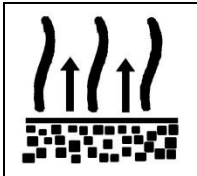
NOTE: TR-115 is an exempt solvent, but use outside of the Americas causes VOC to increase



Minimum 2 coats needed: Apply a wet and closed film, followed after 30 minutes flash off time by another closed and homogeneous layer. Do not "paint to hide" in the first layer application.

Dry film thickness: 2.0 - 3.0 mils (50.8 - 76.2 microns)

NOTE: The addition of TR-115 will reduce viscosity for smoother films and for better flow and leveling.



Drying Times(25 +/- 2°C / 77 +/- 2°F, 55 +/- 5% RH)

A4950 (standard activator) 12 – 16 hours, A4951 (medium activator) 9 – 13 hours,

A4952 (fast activator) 5 – 9 hours, A4953 (decoration activator) 2 – 4 hours,

A4954 (slow activator), 12 – 16 hours



At 75 to 80°F & 50% RH

Dry to Fly: White: 24hrs / Colors: 48hrs

Clean Up: TR-15, Solvent Cleaning C28/15 or Solvent Cleaning 98068 for electrostatic equipment .



Type equipment	Tip Size
HVLP	1.2 - 1.5 mm
Low Pres. Electrostatic	1.2 - 1.5 mm
Air Assisted Electrostatic	.009-.013 in