

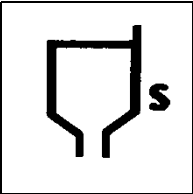
**Base:**  
4400GXXXXXX (solid) or  
4400EXXXXXX (metallic)  
**2 parts**



**Curing Solution:**  
CS4904  
**1 part**



**Activator: 1 part**  
A4956: Standard  
A4957: High Temp. High Humidity  
A4965: Fast Stripe – Spot Repair  
A4967: Cool Weather



At 75-80°F:  
(24-27°C)

**Mix Viscosity: 16 – 25 seconds #2 Zahn**  
**Pot life: 2.0 – 2.5 Hours (depending on activator selected see TDS)**  
**Induction Time: 10 minutes**  
**Dry Film Thickness: 1.0 – 1.5 mils (25.0 – 37.5 microns)**  
**Clean Up: Use TR-19 or MEK**



Number of coats: Two Stage Colors

**Alumigrip 4400 Solid Color Coat (4400GXXXXX)**  
**Alumigrip 4400 Effect Color Coat (4400E82XXX) and (4400E99XXX)**

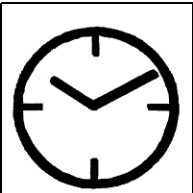
Apply 2 even wet coats with recommended flash time (depending on the activator chosen) in between coats or one cross coat until full hiding is achieved.

Number of coats Three Stage Colors

**Alumigrip 4400 Effect Color Coat (4400E83XXX)**

Apply a single uniform wet coat of Alumigrip 4400 Base Coat Effect, with recommended flash time in between coats depending on the activator chosen, followed by a cross coat. The total cross coats should achieve the desired uniform effect.

(Apply the underlayment or base color with the 2 even wet coats with recommended flash time in between coats or one cross coat until full hiding is achieved as mentioned above, before the effect coating is applied.)



**Activator**

Dry to tape  
Dry to touch  
Full cure

**A4956**

3.5 - 5.5 hrs  
2.0 - 3.0 hrs  
7 days

**A4957**

4.0 - 6.0 hrs  
3.0 - 4.0 hrs  
7 days

**A4965**

0.75 - 2.0 hrs  
0.50 - 2.0 hrs  
7 days

**A4967**

1.0 - 2.0 hrs  
1.0 - 2.0 hrs  
7 days



**Type equipment**

Air  
HVLP  
Low Pres. Electrostatic  
Air Assisted Electrostatic

**Tip Size/Nozzle Orifice**

1.2 – 1.4 mm  
1.2-1.4 mm  
1.2-1.5 mm  
.009-.013 in



Alumigrip may be sprayed outside of the perimeters listed above. Please see the Technical Data Sheet for Activator / Condition options. Dry times may vary depending on conditions.