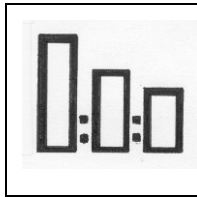




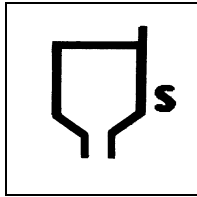


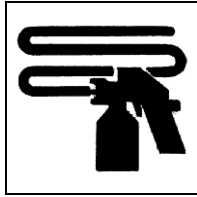
10P20-44M High Solids Epoxy Primer



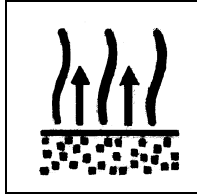
	Base: 10P20-44M		Curing Solution: EC-291		Thinner/Reducer: TR-114* or TR-102**
	2 parts		1 part		1 part



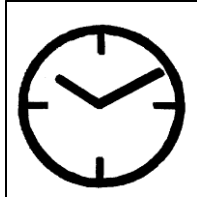
At 75-80°F: (24-27°C)	Mix Viscosity:	13-16 seconds #2 Zahn	*TR-114 is a VOC exempt and HAPS free thinner **TR-102 is a non-exempt thinner that raises the total VOC
	Pot life:	4 hours	
	Induction Time:	None required	



One coat needed:	Apply one full wet closed coat. Avoid runs and sags. The high solids content causes a rapid film build-up.
Dry film thickness:	0.6 to 0.9 mils (15.2 - 22.9 microns)



Primer can be topcoated in 2 to 2½ hours at 77°F (25°C).



At 75 to 80°F & 50% RH	Dry to Topcoat:	2¼ hours, if a drying time of 24 hours is exceeded, reactivate the surface with Scotch-Brite® Type A Very Fine
	Clean Up:	Use TR-36, MEK or applicable cleaning solvent

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Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
Conventional spray gun	.052-.070 in	60-70 psi	5-20 psi	Low transfer efficiency
HVLP	1.2-1.4 mm	8-25 psi	Varies w/pot size	Iwata, Sata, Binks Mach 1
Low Pres. Electrostatic	1.2-1.5 mm	35-45 psi	12-100 psi	PRO3500, 4500SC
Air Assisted Electrostatic	.009-.013 in	65-75 psi	850-1000 psi	PRO4000AA, Ransburg (tips 1.2-1.5 mm)
Air Assisted Electrostatic	.009-.013 in	60-75 psi	1800-2500 psi	PRO4500AA

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.