
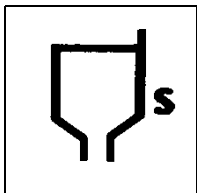

Base:
666-58 Series
3 parts


Curing Solution:
X-503
1 part

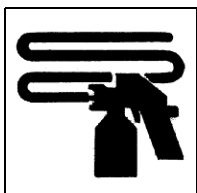


At 75-80°F:
(24-27°C)

Mix Viscosity: **16-30 sec. #4 Ford Cup**
 15-29 sec. S90 Zahn #2

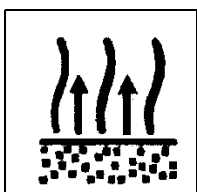
Pot life: **4 Hours**

Induction Time: **15 to 30 minutes required**



Coats needed: **2 coats needed: Apply a wet medium coat followed after a minimum of 15 to 30 minutes flash-off by a second medium wet coat. The application characteristics differ from conventional finishes. The high solid content causes a rapid film build-up. Use caution to avoid sags and runs.**

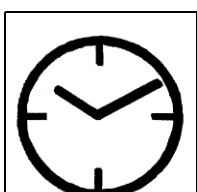
Dry film thickness: **1.8 to 2.2 mils (45 – 55 microns)**



Due to a rapid film build-up with high solid finishes allow a flash-off time between the coats.

55-75°F 30-50 minutes minimum
75-80°F 15-30 minutes minimum
80-90°F 15 minutes minimum

Please note: Volume of airflow can effect surface drying rates.



At 75 to 80°F & 50% RH

Dry to Touch: **4 hours**
Dry to tape (77 ± 4°F): **8 hours**
Recoat (R.H 35-75 %): **Within 48 hours. If a drying time of 48 hours is exceeded, condition the surface with Scotch-Brite® Type A very fine. Use TR-19, TR-36, or a VOC Compliant Solvent Blend**

Clean Up: **Use TR-19, TR-36, or a VOC Compliant Solvent Blend**

Scotch-Brite® is a registered trademark of 3M Corporation



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
Conventional spray gun	.052 - .070	55-65 psi	6-12 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	1.2-1.5mm	35-45 psi	12-100 psi	PRO3500, 4500SC
Air Assisted Electrostatic	.023-.028 mm	55-65 psi	2000-3000 psi	PRO 4500AA 360 - 400 cc/min.