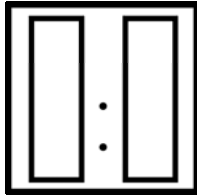
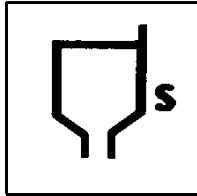


58 Series MIL-PRF-85285 High Gloss Topcoat



Base:
646-58-XXXX Series
 1 parts

Curing Solution:
X-501
 1 part



At 73-80°F:
(24-22.8°C)

Mix Viscosity: 15-30 sec. #4 Ford Cup
17-32 sec. S90 Zahn #2

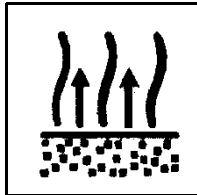
Pot life: 4 hours

Induction Time: 30 minutes



One coat needed: Apply a wet medium coat followed after a minimum of 30 to 45 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.

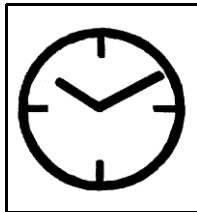
Dry film thickness: 1.8 to 2.2 mils (45-55 microns)



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: 10-12 hours
Recoat: Within 48 hours. If a drying time of 48 hours is exceeded, condition the surface with Scotch-Brite® Type A very fine.

Clean Up: Use TR-19, TR-36 or a VOC compliant solvent Brand

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Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
Conventional spray gun	1.2-1.4 mm	45-65 psi	10-20 psi	Low transfer efficiency
HVLP	1.2-1.4 mm	< 45 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	0.23-0.28 mm	55-65 psi	1800-2500 psi	PRO 4500AA 360 - 400 cc/min.

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.