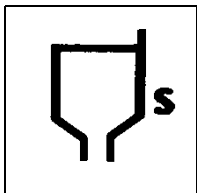


**Base:** 656-58 Series  
**Curing Solution:** X-503

**3 parts** (represented by three blue boxes) **1 part** (represented by one green box)



**At 75-80°F:** (24-27°C)

**Mix Viscosity:** 15-30 sec. #4 Ford Cup (Mil-PRF-85285)  
17-32 sec. S90 Zahn #2

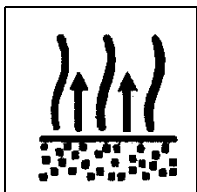
**Pot life:** 4 Hours

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



**Coats needed:** A 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. See flash-off times with temperature ranges listed below. The application characteristics differ from conventional finishes. The high solid content causes a rapid film build-up. Use caution to avoid sags and runs.

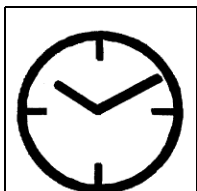
**Dry film thickness:** 1.8 to 2.2 mils (45 – 55 microns)



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:** 8 – 10 Hours  
**Recoat:** 1 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, C28/15, MEK or a VOC Compliant Solvent Blend

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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	5-25 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	0.23-.0.28 mm	55-65 psi	1800-2500 psi	PRO 4500AA 360 - 400 cc/min.