


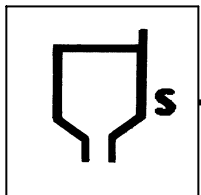
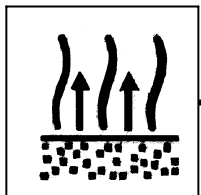
	Base: 683-3-2 or 683-3-20	Curing Solution: X-310A	Thinner/Reducer: TL-59
	2 parts	 1 part	 0 – 0.3 part



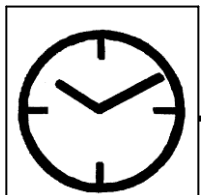
At 75-80°F: (24-27°C)	Mix Viscosity: Pot life: Induction Time:	20-27 seconds #2 Zahn 4 hours (683-3-2) 30 minute (683-3-20) not required
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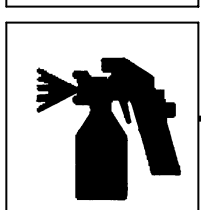
One coat needed:	Spray or brush apply one full wet coat.
Dry film thickness:	1 to 2 mils (25 – 51 microns)



Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.



At 75 to 80°F & 50% RH	Dry to Touch:	4 Hours (683-3-2) 30 Minutes (683-3-20)
	Full Cure:	7 Days
	Clean Up:	Use TR-36, MEK or applicable cleaning solvent



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