
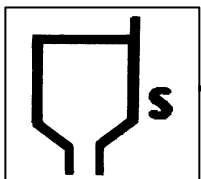
 <p>Base: ECM-F-XXXX</p> <p>3 parts</p>	 <p>Curing Solution: PC-404</p> <p>1 part</p>	<p>At low temperatures, the cure rate may be accelerated by adding one fluid ounce (30 ml) of AC-5000 per one mixed gallon of Aerodur® 5000. The use of AC-5000 is not recommended at temperatures of 70°F and above.</p>
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<p>At (21°C/70°F): 40 – 80 seconds ISO-Cup 4 24 – 38 seconds Gardener Signature Zahn-Cup #2 22 – 32 seconds Ford Cup #4</p>	<p>At (25°C/77°F): 40 – 70 seconds ISO-Cup 4 24 – 32 seconds Gardener Signature Zahn-Cup #2 22 – 27 seconds Ford Cup #4</p>
<p>Pot life: 4 hours Induction Time: 15 to 30 minutes</p>	



2 coats needed: Apply a single wet coat followed after a minimum of 30 minutes flash-off by a second wet coat.
Dry film thickness: 1.8 – 2.2 mils (45 – 55 microns)

The application characteristics differ from conventional finishes. In application, rapid film build will take place due to the high solid nature of the formulation.



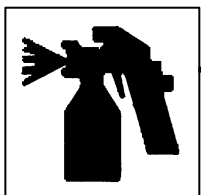
Due to a rapid film build-up with high solid finishes allow a flash-off time between the coats.

65-75°F / 18-24°C	30-50 minutes minimum
75-80°F / 24-32°C	15-30 minutes minimum
80-90°F / 27-32°C	15 minutes minimum

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



Dry to Touch: 4 hours
Dry to tape 25°C / 77°F ± 4°: 6 hours
Recoat (R.H 35 – 75 %): Maximum recoat time 48 hours. If a drying time of 48 hours is exceeded, reactivate the surface with Scotch-Brite® Type A very fine.
Clean Up Use TR-19, TR-36, or a VOC Compliant Solvent Blend



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	1.2-1.8 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	609 to 613	35-45 psi	2000-3000 psi	PRO4500AA 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.