



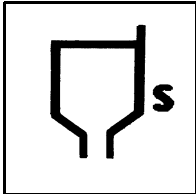
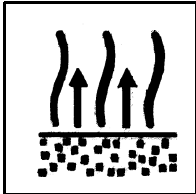
	<b>Base:</b> 4001PS	<b>Curing Solution:</b> CS4902		<b>Thinner/Reducer:</b> TR-114 (optional)
		4 parts		1 part	0 – 1 part



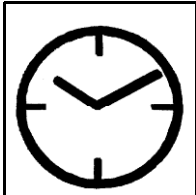
At 75-77°F: (24-25°C)	<b>Mix Viscosity:</b>	18-25 seconds Signature Zahn #2 20-28 seconds Ford Cup #4 40-70 seconds ISO Cup #4	<b>*TR-114 is a VOC exempt and HAPS free thinner</b>
	<b>Pot life:</b> <b>Induction Time:</b>	2 hours W/O thinner 4 hours With Thinner 15 Minutes	



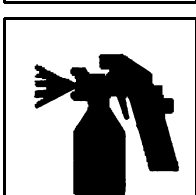
<b>Coats needed:</b>	<b>Apply Alumigrip® 4001 using a cross coat method to achieve the desired film thickness.</b>
<b>Dry film thickness:</b>	<b>As Primer: 0.6 – 1.0 mils. (15 – 25 microns) As Surfacer: 3 – 6 mils. (75 – 150 microns)</b>



**Dry times will depend on the film thickness desired.**



At 75 to 80°F & 50% RH	<b>Dry to Sand:</b>	<b>Approx. 3 Hours depending on the film thickness.</b>
	<b>Dry to Topcoat:</b>	<b>As Primer: 2 Hours Minimum, 48 hours Maximum As Surfacer: 72 Maximum after sanding</b>
	<b>Clean Up:</b>	<b>MEK, MPK, or applicable cleaning solvent</b>



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
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

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.

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