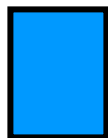
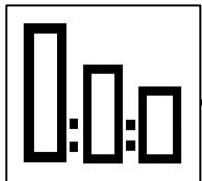
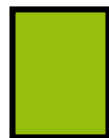


alumiGRIP 4200 Buffable Polyurethane Topcoat



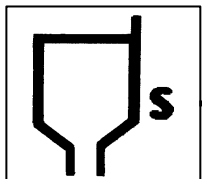
Base:
4200GXXX
1 parts



Curing Solution:
PC-242
1 part



Activator:
Alumigrip® 4950 (AC-139)
4951, 4952, or 4953
.125 part



At 77°F: (25°C)
Mix Viscosity: 35 - 50 seconds ISO Cup #4
17 - 22 seconds Zahn-Cup #2, Signature series
Pot life: 4 hours
Induction Time: 15 Minutes



Minimum 2 coats needed: Apply a full wet closed coat 30 to 60 minutes between coats
Dry film thickness: 2.0 - 3.0 mils (50.8 - 76.2 microns)
Wet edge time: 45 - 90 minutes at 77°F (25°C), 50% RH



Wet edge time is effected by temperature and air flow. Higher temperatures and airflow will decrease wet edge times. Due to a rapid film build-up with high solid finishes, allow a flash-off time between the layers with a minimum of 30 minutes.



At 75 to 80°F & 50% RH
Dry to Fly: White: 24hrs
Colors: 48hrs
Clean Up: TR-15, C28/15, or 98068 Solvent Cleaning for electrostatic equipment and TR-19, C28/15, 98068 or 98068 Solvent Cleaning for conventional spray equipment.



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
Conventional spray gun	1.2 - 1.5 mm	55-65 psi	8-12 psi	Low transfer efficiency
HVLP	1.2 - 1.5 mm	45-65 psi	8-12 PSI	Iwata, Sata, Binks Mach 1
Low Pres. Electrostatic	1.2 - 1.5 mm	35-45 psi	12-100 psi	PRO4500SC, XS3, Ransburg Solo gun
Air Assisted Electrostatic	.009-.013 in	55-65 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.