



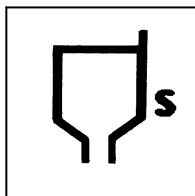
Base:
 4400GXXXXXX (solid) or
 4400EXXXXXX (metallic)
2 parts



Curing Solution:
 CS4904(solids)
 Or CS4905(metallic)
1 part



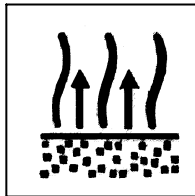
Thinner/Reducer:
 A4955 - A4957 (solids)
 A4958 (metallic)
1 part



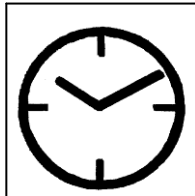
At 75-80°F: (24-27°C)
Mix Viscosity: 16 – 25 seconds #2 Zahn
Pot life: 1.5 – 2.5 Hours (depending on color)
Induction Time: 10 minutes



Coats needed: Apply a single uniform wet coat (1.0 mils wet) of Alumigrip® Base Coat, flash 15 minutes followed by a box coat. Repeat this process until desired film thickness is achieved. The total box coats should achieve the required dry layer thickness of 25.0 – 37.5 micron (µm) (1.0 – 1.5 mils)
Dry Film Thickness: 25.0 – 37.5 micron (µm) (1.0 – 1.5 mils)



Some colors may require a slightly higher film thickness to achieve full hide.



At 75 to 80°F & 50% RH **Dry to Dust Free:** 15 – 30 Minutes
Dry to Tape: 1 – 2 Hours
Full cure: 7 Days
Clean Up: Use TR-19 or MEK for conventional spray equipment

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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	1.0-1.4 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