

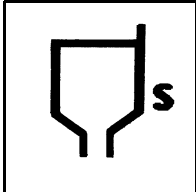
Base:
4400GXXXXXX (solid) or
4400EXXXXXX (metallic)
2 parts



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



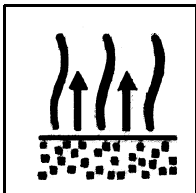
Thinner/Reducer:
A4955 - A4957 (solids)
A4958 (metallic)
1 part



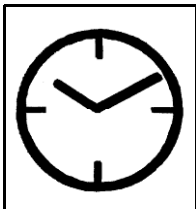
At 75-80°F: (24-27°C) **Mix Viscosity:** **16 – 25 seconds #2 Zahn**
Pot life: **1.5 – 2.5 Hours (depending on color)**
Induction Time: **10 minutes**



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

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.