


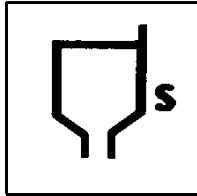




<b>Base:</b> <b>4450G00003</b>	<b>Curing Solution:</b> <b>CS4906</b>	<b>Activator Options:</b> <b>A4959, A4961, A4962 and A4963 (spot repair)</b> <b>.25 part</b>
 <b>1 parts</b>	 <b>1 part</b>	

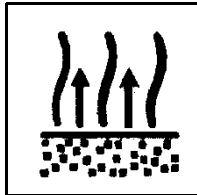


<b>At 75-80°F:</b> <b>(24-27°C)</b>	<b>Mix Viscosity:</b>	<b>16 – 20 seconds #2 Zahn</b>
	<b>Pot life:</b>	<b>2.5 Hours</b>
	<b>Induction Time:</b>	<b>10 minutes</b>

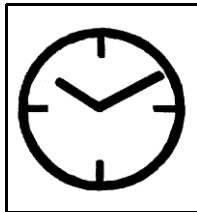


**Coats needed:** Apply a single uniform wet coat (1.0 mils wet) of Alumigrip® Clear Coat, flash 5 Minutes followed by a second coat then flash 15 minutes. Repeat this process with an increased wet film of two mils wet per pass. The total box coats should achieve the required dry layer thickness of 50 – 62.5µm (2.0 – 2.5 mils)

**Dry Film Thickness:** 2.0 to 2.5 mils (50.8 – 76.2 microns)



The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.



<b>At 75 to 80°F &amp; 50% RH</b>	<b>Dry to Dust Free:</b> 1 hour
	<b>Dry to Tape:</b> 8 – 10 Hours
	<b>Full cure:</b> 7 Days
	<b>Clean Up:</b> Use TR-19 or MEK for conventional spray equipment



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	1.2-1.4 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.