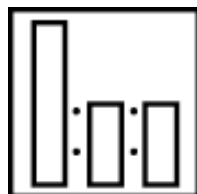




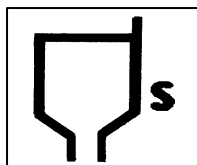


# Eclipse High Solids Polyurethane Topcoat



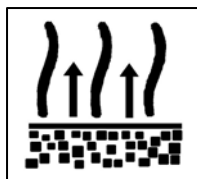
	<b>Base:</b> <b>ECL-G-XXX</b>	<b>Curing Solution:</b> <b>PC-233</b>	<b>Thinner:</b> <b>TR-109* (see chart below)</b>
	2 filled gallons 2 parts	 1 gallon 1 part	 1 gallon 1 part



<b>Mix Viscosity:</b>	<b>17-23 seconds #2 Zahn Cup</b>
<b>At 75-80°F (24-27°C):</b>	<b>Pot life with TR-109:</b> 4 hours-white, 3 hours-color; pot life will be reduced with the addition of an alternate thinner, see chart below
<b>Induction Time:</b>	<b>15 to 30 minutes</b>



**Minimum 2 coats needed: Apply a wet closed coat 30 to 45 minutes between coats.**  
**Dry film thickness: 2.0 - 3.0 mils (50.8 - 76.2 microns)**  
**Wet edge time: 35 - 45 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.



Drying Times	77°F (25°C)	77°F (25°C)	90°F (32°C)	120°F (48°C)	Note: TR-112 & TR-113 are recommended for touch-up areas and speed lines only and are pre-adjusted to meet specific dry times, no additional accelerator should be added. The pot life & wet edge of the topcoat are dramatically reduced when mixed with TR-112 & TR-113.
	<b>Pot Life</b>	<b>50% RH</b>	<b>40% RH</b>	<b>10% RH</b>	
TR-109	3 - 4 hrs	10 - 12 hrs	8 - 9 hrs	4 - 5 hrs	
TR-111	1½ - 2 hrs	7 - 8 hrs	4 - 5 hrs	3 - 4 hrs	
TR-112	1 - 1½ hrs	5 - 6 hrs	2 - 3 hrs	1½ - 2 hrs	
TR-113	½ - 1 hr	2 - 3 hrs	1 - 2 hrs	< 1 hr	
TR-141	3 hrs	10 - 12 hrs	7 - 9 hrs	4 - 6 hrs	



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
Conventional spray gun	.047-.055 in	45-65 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	55-65 psi	1800-2500 psi	PRO4000AA, Ransburg (tips 1.2-1.5 mm)

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.