



## Alumigrip® Firefox Clearcoat Application Procedure

### Characteristics



Product  
Information

- This fast drying, urethane clearcoat is designed for use in decorative finishing systems for general aviation aircraft.

- It may be used to enhance the appearance of base coat colors, as an over coat for the application of metallic finishes and for area repairs.

- This product may be wet sanded (1000 grit or finer) and buffed, if desired.

### Components



Base  
Curing Solution  
Thinner/Reducer

Alumigrip® Foxfire Clearcoat F3016  
G3010P  
T0001P, T0003P

### Instruction for Use



Mixing Ratio  
(volume)

3 parts	Alumigrip® Foxfire Clearcoat F3016
1 parts	G3010P
15-20% parts	T0001P, T0003P

1. Store material at room temperature for a minimum of 24 hours prior to mixing.
2. Prior to mixing put the base portion (F3016) on a shaker and agitate for ten minutes.
3. The base component should be uniform and free of lumps, skins or hard settling.
4. The curing solution should be clear. Do not use if the curing solution has gelled, is cloudy or milky.
5. **Do not use** if the unopened can shows signs of swelling since this indicates moisture contamination.  
Reducers: T0003P = Standard Reducer, T0001P = Fast Reducer
  - Use the T000XP to rinse residual material from the base and curing solution containers to ensure an accurate mix.
6. Viscosity should be 16-18 seconds (#2 Zahn) and dry film thickness 2.0-2.5 mils (50-62 microns  $\mu\text{m}$ ) dry.



### Note

It is extremely important to maintain an accurate mix ratio of as any deviation can adversely affect application and performance properties. Slowly add the base and curing solution components together while stirring.



Equipment

Conventional or airless spray.



Number of coats

Apply one single coat at 2.0 mils (50 microns) wet. Allow one hour flash and apply a cross coat at 2.0-3.0 mils (50-75 microns) wet.



Cleaning of  
Equipment

Use TR-15 or C28/15



Pot Life  
(25°C/77°F)

	77°F (25°)	77°F (25°C)	90°F (32°C)	120°F (48°C)
<b>Thinner</b>	<b>Pot Life</b>	<b>50% RH</b>	<b>40%RH</b>	<b>10%RH</b>
T0001P	8 – 10 hrs	14 – 16 hrs	8 – 10 hrs	6 – 8 hrs
T0003P	12 – 14 hrs	18 – 20 hrs	12 – 14 hrs	8 – 10 hrs

## Safety Precautions

Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDSs are available on request.

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