

Base:
10P20-13
3 part

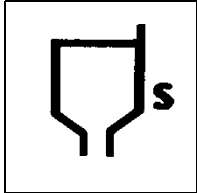
Curing Solution:
EC-213



1 part



Thinner/Reducer:
TR-114 or TR-49
0 to 1 part



At 77°F (25°C):

Mix Viscosity: 12 – 16 seconds #4 Ford Cup,
21 – 30 seconds 4mm ISO cup

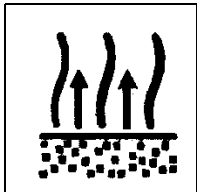
Pot life: 4 hours

Induction Time: 30 minutes

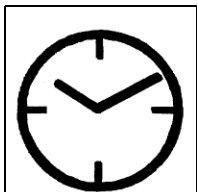


1 Coats needed: Apply one full wet closed coat. Avoid runs and sags. The High Solid content causes a rapid film build-up.

Dry film thickness: 0.6 – 0.9 mils (15 – 23 microns)



At 77°F (25°C), 55% RH
10P20-13 Primer can be force cured at elevated temperatures to accelerate speed of dry time.
(See Technical Data Sheet for detail)



At 77 +/- 2°F (25 +/- 2°C , 55 +/- 5% RH

Dry to Tape: 4 – 5 Hours

Dry to Topcoat: 5 Hours

Recoatable Minimum: 5 hours

Recoatable Maximum: 48 hours

Clean Up: Use C28/15, MEK, or TR-49



| Type equipment | Tip Size | Gun Air Pres. / Pot Air Pres. | Other |
|-------------------------------|------------|-------------------------------|--|
| HVLP (Pressure pot spray gun) | 1.4 mm | 25-30 psi | 8-12 psi Iwata, Sata, Binks Mach 1 |
| Low Pres. Electrostatic | 1.4 mm | 35-45 psi | 12-100 psi PRO3500, 4500SC |
| Air Assisted Electrostatic | 609 to 611 | 60-75 psi | 1800-2150 psi PRO 4500AA , XS Series, with a fluid flow rate of: 360 - 400 cc/min. fluid flow rate |