

Base:
3002G00002
(by volume)
2 parts



Curing Solution:
CS6003
(by volume)
2 part



Activator:
A905X
(by volume)
1 part

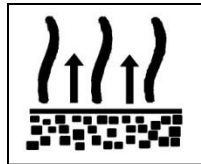


At 75-80°F:
(24-27°C)

Mix Viscosity: 15-20 seconds Zahn Cup #2
Pot life: 4 hours with Activator A9055 (see TDS for other activator pot life)
Induction Time: 15 minutes recommended



Minimum 2 coats needed: Apply one single cross-coat or two wet-on-wet applications.
Dry film thickness: 1.0 – 1.5 mils (25 – 37.5 microns)
Wet edge time: 15 – 20 minutes at 77°F (25°C), 50% RH



Wet edge time is effected by temperature, air flow and activator used. 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) (Dry times and recoat times will vary depending combinations of temperature, humidity, airflow and activator used.)
Dry to touch: 2 – 2.5 hours
Dry to tape: 8-11 hours
Recoat time, minimum: 30 minutes
Recoat time, maximum: 48 hours



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
HVLP	.047-.055 in 1.2-1.4 mm	up to 45 psi	5-20 psi	
Air Assisted Electrostatic	0.047 in(1.2 mm)	5 bar	350 – 400 cc flow rate	Graco XS3 & XS4
Air Assisted Electrostatic	.011 in (0.28mm)	65-70 psi	1800-2500 psi	Graco Pro 4500