

### ① Product & Substrate Temperature

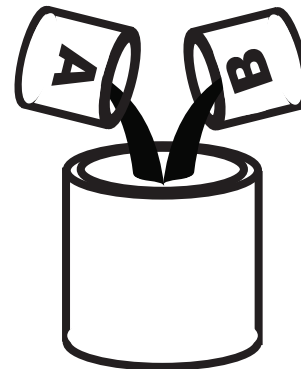


25°C (77°F)  
20°C (68°F)

20-25 °C (68-77 °F)\*



### ② Product Preparation



4 Part Component A  
1 Part Component B



### ③ Mixing



Paint must be thoroughly mixed.

### ④ Spraying Viscosity



18 seconds

40 seconds

conventional

airless

Viscosity: 20-60 seconds using a  
Lemmer DIN 4 cup (blue)



### ⑤ Spray Gun Setup

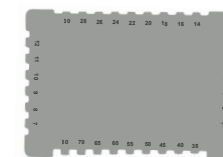


Feed Type	Fluid Tip	Application Pressure	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-1.8 mm	30-40 psi	
Pressure Feed	1.4-1.8 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1000-1800 psi	
Airless	13-17 Thou	1700-3000 psi	



### ⑥ Application

Recommended Film Thickness



4.0 - 7.5 mils wet



3.0 - 6.0 mils DFT