

FR2-55

Cabin Coating – Topcoat

Mixing

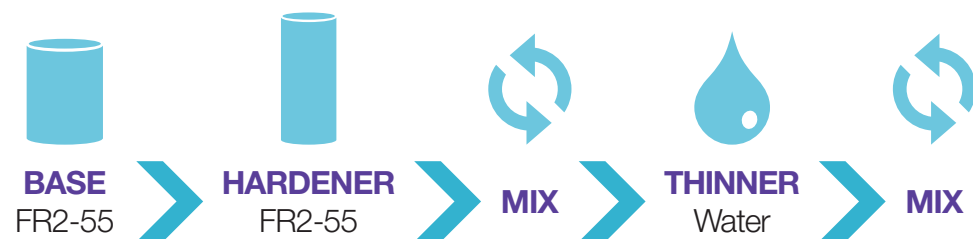
Mixing Ratio

	Mixing ratio by weight	Mixing ratio by volume
Base	100	4 parts
Hardener	20	1 part
Water	15 to 25	0.5 part to 1.2 parts

Note: Mixing by weight is highly recommended

Mixing Procedure

Mix the base and hardener until the mixture is homogeneous. Then add the water.



Texture Application

- 1 Apply 1 or 2 crossed coats to make a **smooth layer**
- 2 Let the paint **dry for 30 to 45 minutes**, until you reach a semi-gloss effect
- 3 **Apply texture by decreasing air pressure** on the gun (0.4 bar to 0.9 bar*)

* Pressure will be dependant on equipment and required texture

Physical Properties

Shelf Life / Storage

12 months for the base and hardener between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

Pot Life

23°C (73°F)	3 hours
35°C (95°F)	1.5 hours

Viscosity

Spraying Viscosity at 20°C / 68°F

ISO 6 Cup	15-25%	22 +/- 5 s
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Application & Drying Times

	23°C (73°F)	40°C (104°F)	60°C (140°F)
Dust free	60 minutes	N.A.*	N.A.*
Dry to handle	5 hours	2.5 hours	1 hour
Recoat able	4 hours to 24 hours	1 hour to 8 hours	30 minutes to 4 hours
Fully cured	7 days	3 days	12 hours

Conditions & Equipment

Temperature

15°C to 35°C (59°F to 95°F)

Humidity

It is possible to paint with high humidity but with sufficient air flow through the painted area. Recommended to use Venturi for example

Sieve

Recommended to sieve the diluted mixture with a 120-150 µm (4.7-6mils) filter

Equipment

Gravity compressed air gun Nozzle 1.4 to 1.8mm