

FR4-45

Cabin Coating – Primer/Surfacer

Mixing

Mixing Ratio

	Mixing ratio by weight	Mixing ratio by volume
Base	100	15 parts
Hardener	5	1 part
Water	5 to 15	1.1 parts to 3.5 parts

Note: Mixing by weight is highly recommended

Mixing Procedure

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



Viscosity

Spraying Viscosity at 23°C / 73°F

ISO 6 Cup	5-10%	22 +/- 5 s
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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

Application & Drying Times

	23°C (73°F)	40°C (104°F)	60°C (140°F)	80°C (176°F)
Dust free	30 mins	N.A.*	N.A.*	N.A.*
Dry to sand	3 hours	1 hour	30 mins	15 mins
Fully cured	7 days	3 days	12 hours	4 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 1.4mm to 2.2mm