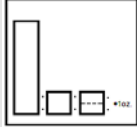




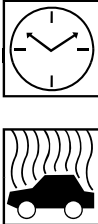



## 2K *A*Chromatic Surfacers

### Speed Air Dry Ratio

<p><b>Mix:</b></p> 	<p><b>Primer Surfacers Optimum Drying Speed</b>  <b>D8005 2K Surfacers: 4 Vols</b>  <b>D8291 2K Hardener: 1 Vol</b>  <b>D-Thinner: ½ - 1 Vol</b>  <b>DXR81: 1 oz per RTS Quart</b></p>																									
<p><b>Mix Ratio By Cumulative Weight in Parts (Grams) 4-1-1-1oz:</b></p>																										
<table border="1"> <thead> <tr> <th>Code:</th> <th>4oz:</th> <th>8oz:</th> <th>16oz:</th> <th>32oz:</th> </tr> </thead> <tbody> <tr> <td>D8005</td> <td>133 (118)</td> <td>267 (237)</td> <td>534 (474)</td> <td>1067 (948)</td> </tr> <tr> <td>D8291</td> <td>155 (138)</td> <td>310 (275)</td> <td>620 (551)</td> <td>1241 (1101)</td> </tr> <tr> <td>D872</td> <td>174 (154)</td> <td>348 (309)</td> <td>696 (617)</td> <td>1391 (1235)</td> </tr> <tr> <td>DXR81</td> <td>178 (158)</td> <td>355 (315)</td> <td>710 (630)</td> <td>1420 (1260)</td> </tr> </tbody> </table>		Code:	4oz:	8oz:	16oz:	32oz:	D8005	133 (118)	267 (237)	534 (474)	1067 (948)	D8291	155 (138)	310 (275)	620 (551)	1241 (1101)	D872	174 (154)	348 (309)	696 (617)	1391 (1235)	DXR81	178 (158)	355 (315)	710 (630)	1420 (1260)
Code:	4oz:	8oz:	16oz:	32oz:																						
D8005	133 (118)	267 (237)	534 (474)	1067 (948)																						
D8291	155 (138)	310 (275)	620 (551)	1241 (1101)																						
D872	174 (154)	348 (309)	696 (617)	1391 (1235)																						
DXR81	178 (158)	355 (315)	710 (630)	1420 (1260)																						
<p><b>Thinner Selection:</b>  <b>D870:</b> Up to 65° F / 18°C  <b>D871:</b> 65° - 77°F / 18° - 25°C  <b>D872:</b> 77° - 95°F / 25° - 35°C  <b>D873:</b> Over 95°F / 35°C</p>																										
<p><b>Pot Life:</b></p> 	<p><i>Accelerated Surfacers:</i> 30 minutes @ 70°F (21°C)</p>																									
<p><b>Additives:</b></p> 	<p><i>DXR81 Accelerator:</i> 1 oz of DXR81 to a ready-to-spray quart</p>																									
<p><b>Spray Gun Setup:</b></p> 	<p><i>HVLP at the cap:</i> 10 PSI / 0.7 bar  <i>Conventional at the gun:</i> 45 PSI / 3 bar  <i>Primer Surfacers:</i> 1.6 - 1.8 mm or equivalent</p>																									
<p><b>Application:</b></p> 	<p><b><u>Primer Surfacers w/DXR81</u></b>  <i>Apply:</i> 2 to 3 wet coats  <i>Film build per wet coat:</i> 3.0 mils  <i>Dried film build per coat:</i> 1.0 mils  <i>Between coats:</i> 0 minutes</p>																									
<p><b>Dry Times:</b></p> 	<p><i>Dust-free:</i> 20°C / 68°F 5 Minutes  <i>Dry to handle:</i> 20°C / 68°F 10 Minutes  <i>Dry to Sand:</i> 20°C / 68°F 20-30 Minutes  <i>Dry to Topcoat:</i> 20°C / 68°F 30 Minutes (after sanding)</p>																									
<p><b>VOC Information:</b></p> 	<p><i>VOC Regulatory (Less Water Less Exempts)</i>  <i>lbs/gal (g/L):</i> 4 : 1 : ½ + 1 oz. per RTS qt. 4.54 (544)      4 : 1 : 1 + 1 oz. per RTS qt. 4.75 (569)</p>																									