

## ILLUSTRIMUM™ M1172 DTM

### EQUIPMENT

#### Proportioner

- 1:1 mix ratio by volume
- Capable of producing 2000 psi
- Requires heated lines to the mix block
- Suggested minimum equipment (or equivalent)
  - Graco EXP-1 proportioner
  - Graco T-1 transfer pumps
  - Dual 8 inch blade air powered resin mixer

#### Mix Block

- Graco Mix Manifold Kit 3A2801F (24R992)

#### Spray Gun

- Graco G40 Air Assisted Airless or equivalent

#### Spray Tip

- To minimize film build while keeping an acceptable spray pattern we recommend using a Graco RAC FFLP 512 reversible tip
- Large parts or higher film thickness can use a larger tip in the Graco RAC FFLP line

#### Flush Pump

- Air powered diaphragm or piston pump compatible with chosen flush solvent

### SPRAY PARAMETERS

#### Proportioner

- Pressure: 1400 psi dynamic
- Line Heat : 82°C (178°F)
- Primary Heat: 82°C (178°F)

#### Spray Gun

- Assist air 40-60 psi at gun

### SURFACE PREPARATION

**Steel:** Clean and degrease. Sandblast to white metal blast at 2-3 mil profile or sand with 40-grit sand paper to remove mill scale and surface rust.

**Aluminum:** Clean and degrease. Brush blast or chemical cleaning and pre-treatment with Phosphoric acid or suitable cleaning/etching preparation.

**Galvanized Metal** Clean and degrease. Brush blast or chemical cleaning and pre-treatment appropriate to the age and degree of weathering

### APPLICATION AND CURE

#### Application

- Can be applied as thin as 3-5 mils in a single coat
- Can be applied as thick as 8-10 mils in a single coat
- 100% solids means wet film = dry film thickness

#### Curing

- Set to touch: 35 minutes\*
  - Tack Free 60 minutes\*
  - No bake or post cure process required
- \*At ambient conditions of ~23°C and ~30%RH. Actual cure times will vary with specific conditions

### CLEANUP

#### Liquid Components

- Immediately upon completion of spray, set mix block from spray to flush to purge the mixer and whip hose of mixed material.
- Use spill absorbent for large spills and dispose of according to local regulations
- Clean residues with solvented shop towels or treat with decontamination solution. Note that alcohol containing solvents will react with the Isocyanate.

#### Cured Material

- Cover with soaked shop towel or immerse small parts in a suitable paint removing solvent or gun wash

