



TD Coat RT/P General Guide

- Shop temperatures at 75f (24C) or better to 90f (32C)
- Typical spray tips would be 435-437 or 535-537
- "5" series tips have wider spray pattern
- "4" series tips have a narrower spray pattern
- #35 orifice will have lower flow rate, can be useful for small parts or intricate areas
- Apply at 0.04"(.1mm)-0.08"(0.2mm) per coat. You may apply less, more will have tendency to create runs/sags
- Allow to exotherm between coats and temperature to fall within 10 degrees F (5.5 degrees C) of ambient before adding next coat.
- Build coats to achieve desired thickness. Average usage is generally .25(6.25mm) to 1.0(25.4mm), requiring 2-3 coats.
- Frequent use of a mil gauge on each application is highly recommended along with an IR thermometer
- After first coat, wait 2 hours
- Subsequent coats, 30 minutes
- Wait 24 hours before machining can sand after 4 hours.
- Grind 36 grit or CNC machine