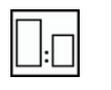


# Products Application Process

 Products	 Mixing Ratio	 Hardener Reducer	 Pot Life	 Nozzle	 Application	 Flash off between coats	 Flash off before baking	 Dry	 Sanding
TD42 Wash Primer	1:1	TX47	3 – 4 hours	Ø 1.1 - 1.3	1 - 2	/	5 -10 min	5 – 10 min	P180-P220 P320-P400
TD75 Plastic Primer	Ready for use		4 hours	Ø 1.3 - 1.5	1 - 2	3–5 minutes	10 – 15 min before next process		P400-P500 P600-P800
TD35/E 2K primer surfacer	3:1:1 100:25:15-20	Hardener TH01/02/03 MA21/22 Reducer TX33/32/31	1 hour	Ø 1.3 - 1.5	2 - 3	3 - 5 min	5 - 8 min	t=60°C 20 - 30 min t=23°C 1- 1.5 hour	P320-P400 P600-P800
TD39 High Build HS Primer/ TD40 High Build Primer Matte	5:1:0.25-0.5 100:12.5:3-7	Hardener TH01/02/03 Reducer TX33/32/31	4 hours	Ø 1.5 - 1.7	2 - 3	3–5 minutes	10 – 15 minutes	t=60 °C 60–80 min t=23°C 4-5 hours	P320-P400-P500 P600-P800
Tintable Primer Surfacers PW01 <input type="checkbox"/> PG02 <input type="checkbox"/> PB03 <input type="checkbox"/>	Wet-on-Wet 3:1:2 100:20:40	Hardener TH01/02/03 TH21/22/23 Reducer TX33/32/31	1 hours	Ø 1.3 - 1.5	1–2 layers	3 – 5 min	10 – 15 min before next process		P320-P400 P600-P800
	Sanding 3:1:1 100:20:20			Ø 1.5 - 1.7	2–3 layers		5 - 8 min	60 °C-30 min 23°C - 1 hours	P320-P400-P500 P600-P800
TDE31/E Universal 2K	Wet-on-Wet 3:1:2 100:25:50	Hardener TH01/02/03 Reducer TX33/32/31	1 hours	Ø 1.3 - 1.5	1–1.5 layers	/	10 – 15 min before next process		P320-P400 P600-P800
	Sanding 3:1:1 100:25:25			Ø 1.5 - 1.7	2–3 layers		3 – 5 min	5 - 8 min	
TDM41 Epoxy Primer	4:1:1-1.5 100:20:20-30	Hardener TD43 Reducer TX33/32/31	2 hours	Ø 1.3 - 1.6	1–2 layers	2 – 3 min	3 - 5 min	60°C -30 min 23°C - 4 hours	P180-P240-P320 P400-P600
TD70 1K Surfacers	1:0.4:0.55 100:60-80	Reducer TX33/32/31	4 hours	Ø 1.5 - 1.7	2 - 3 layers	3 – 5 min	5 - 8 min	60°C -30 min 23°C - 4 hours	P320-P400 P600-P800
TQ18 2:1 standard clear coat	2:1:0-0.4 100:50:0-20	Hardener TH19F/19/19S Reducer TX33/32/31	2 hours	Ø 1.3 - 1.5	2 - 3 layers	10 min	10 min	60 °C 45 min 23°C 4-5 hours	P1000-P1500 Trizact P1500-P3000
TQ27 2:1 HS Clear Coat	2:1:0-0.4 100:50:0-20	Hardener TH21/22/23 Reducer TX33/32/31	2 hours	Ø 1.3 - 1.5	2 - 3 layers	5 - 8 min	8 – 10 min	60 °C 35 min 23°C 4-5 hours	P1000-P1500 Trizact P1500-P3000
TQM66 4:1 Fast Curing Clear Coat	4:1:0-0.4 100:25:0-10	Hardener THM77 Reducer TXM33/32/31	30 min	Ø 1.3 - 1.5	1 - 2 layers	2 - 3 min	3 - 5 min	60 °C 5-7 min 23°C 50-65 min	P1000-P1500 Trizact P1500-P3000
MC166 Matte Clear Coat	3:1:0.6-0.8 100:33:20-25	Hardener THM01/02/03 Reducer TXM33/32/31	4 hours	Ø 1.3 - 1.5	2 - 3 layers	8- 10 min	15 - 20 min	60 °C 35 min 23°C 3-4 hours	/

## Application table of hardeners and reducers

Product	Fast		Standart		Slow	
	5°C~15°C, 40°F~60°F		15°C~25°C, 60°F~80°F		25°C~35°C, 80°F~95°F	
	Hardener	Reducer	Hardener	Reducer	Hardener	Reducer
TD75 Plastic Primer	/	/	/	/	/	/
TD42 Wash Primer	TX47	TX33	TX47	TX32	TX47	TX31
TD41 Epoxy Primer	TD43	TX44/TX33	TD43	TX44/TX32	TD43	TX44/TX31
TD70 1K Surfacer	/	TX33	/	TX32	/	TX31
TDE31/E Universal 2K Primer	TH03	TX33	TH02	TX32	TH01	TX31
TD35/E 2K primer surfacer	TH03	TX33	TH02	TX32	TH01	TX31
TD39 High Build HS Primer	TH03	TX33	TH02	TX32	TH01	TX31
TD40 High Build Primer Matte	TH03	TX33	TH02	TX32	TH01	TX31
PW01/PG02 /PB03 Tintable Primer Surfacer	TH21/TH03	TX33	TH22/TH02	TX32	TH21/TH01	TX31
TQ18 2:1 Standard clear	TH19F	TX33	TH19	TX32	TH19S	TX31
TQ27HS Clear Coat 2:1	TH21	TX33	TH22	TX32	TH23	TX31
TQ66 4:1 Fast repair clear	TH77	TX33	TH77	TX32	TH77	TX31
MC166 Matte Clear Coat	TH03	TX33	TH02	TX32	TH01	TX31