



Mariposa Products Application Process

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Products	Mixing Ratio	Hardener Reducer	Pot Life	Nozzle	Application (layers)	Flash off between coats	Flash off before baking	Dry	Sanding
MD42 Wash Primer	1:1	MX74	3 – 4 hours	Ø 1,1 - 1,3	1 - 2	/	5 -10 min	5 – 10 min	P180-P220 P320-P400
TDM75 Plastic Primer	Ready for use		4 hours	Ø 1.3 - 1.5	1 - 2	3 – 5 minutes	10 – 15 min before next process		P320-P400 P600-P800
MAM 600 Wet on Wet Primer	3:1:2 100:25:15-20	Hardener THM01/02/03 MAM21/22 Reducer TXM33/32/31	40 min	Ø 1.3 - 1.5	1 – 1.5	/	10 – 15 min before next process		P320-P400 P600-P800
TDM39 High Build HS Primer/ TDM40 High Build Primer Matte	5:1:0.25-0.5 100:12.5:3-7	Hardener THM01/02/03 Reducer TXM33/32/31	40 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
Greyscale Surface MPW01 <input type="checkbox"/> MPG02 <input type="checkbox"/> MPB03 <input checked="" type="checkbox"/>	Wet-on-Wet 3:1:2 100:20:40	Hardener THM01/02/03 Reducer TXM33/32/31	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 THM01/02/03 THM19F/19/19S Reducer TXM33/32/31	1 hours	Ø 1.3 - 1.5	1-2 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	60°C-40 min 23°C - 3-4 hours	
TDM41 Epoxy Primer	4:1:1-1.5 100:20:20-30	Hardener TDM43 Reducer TXM44/33/32/31	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
TQM18 2:1 Standard clear	2:1:0-0.4 100:50:0-20	Hardener THM19F/19/19S Reducer TXM33/32/31	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
TQM27 2:1 HS Clear Coat	2:1:0-0.4 100:50:0-20	Hardener THM21/22/23 Reducer TXM33/32/31	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
MCM166 Matt 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 (Until matt)	60 °C 35 min 23°C 3-4 hours	/



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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	/	/	/	/	/	/
MD42 Wash Primer	MX74	TXM33	MX74	TXM32	MX74	TXM31
TDM41 Epoxy Primer	TDM43	TXM44/TXM33	TDM43	TXM44/TXM32	TDM43	TXM44/TXM31
MAM 600 Wet on Wet Primer	THM03/MAM21	TXM33	THM02/MAM22	TXM32	THM01/MAM22	TXM31
TDE31/E Universal 2K Primer	THM03/THM19F	TXM33	THM02/THM19	TXM32	THM01/THM19S	TXM31
Greyscale Surfacer MPW01/MPG02/MPB03	THM03	TXM33	THM02	TXM32	THM01	TXM31
TDM39 High Build HS Primer	THM03	TXM33	THM02	TXM32	THM01	TXM31
TDM40 High Build Primer Matte	THM03	TXM33	THM02	TXM32	THM01	TXM31
TQM18 2:1 Standard clear	THM19F	TXM33	THM19	TXM32	THM19S	TXM31
TQM27HS Clear Coat 2:1	THM21	TXM33	THM22	TXM32	THM23	TXM31
TQM66 4:1 Fast Curing Clear Coat	THM77	TXM33	THM77	TXM32	THM77	TXM31
MCM166Matt Clear Coat	THM21	TXM33	THM22	TXM32	THM23	TXM31

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