

The following is a summary of spray equipment that has been successfully used to apply Flame Control Mastic No. 50-44 Low VOC.

GRACO EQUIPMENT:

Gun: Model No. 204-000, Series G9H

Tip: External mix, Horn type No. 160-660

Pump: President 10-1 texture, equipped with evenflow valve system

Hoses: Material: ¾ inch I.D. (minimum), solvent resistant, reinforced, with a 5 foot long, ¾ inch I.D. whip section at gun, fitting at gun should be quick connecting swivel type. Maximum hose length 100 feet.

Air to gun: ¾ inch I.D. (minimum)

Air compressor to pump: ¾ inch I.D. (minimum)

Compressor:

Must be capable of maintaining 85 PSI (minimum) when spraying.

START UP PROCEDURE:

Step 1: Place CAUTION signs in area, warning others that spray painting is in process, and that flammable vapors are present in the area. Check to ensure that all flames, fires, and other sources of ignition have been extinguished or turned off. Coated area must remain roped off, with "CAUTION, FLAMMABLE VAPOR" signs until the coating has thoroughly dried.

Step 2: Pump, hoses, and gun must be clean. Set up equipment and place pump in empty open head 55 gallon drum.

Step 3: Using a Jiffy double bladed mixer, thoroughly mix 4 to 8 five gallon pails of Flame Control Mastic No. 50-44 Low VOC. Each five gallon pail should be thinned (diluted) with approximately 1 quart of reducer Acetone/

Step 4: Dump the thinned (diluted), thoroughly mixed, Mastic No. 50-44 Low VOC into the 55 gallon drum.

Step 5: Remove fluid hose at gun and start pump. Pump until mastic has completely filled the material hose, then reattach the hose to the gun.

Step 6: Adjust evenflow valves to obtain the following pressure settings;

(*) Material 15 to 35 PSI

(*) Atomizing Air
20 to 40 PSI

(*) The above pressure settings are generally suitable for most conditions. Material pressure should be kept at the lowest possible setting to obtain a smooth uniform flow.

Step 7: Test spray a small area, adjust pressure settings to obtain a good spray pattern, then proceed with the application. Check wet film every few minutes, to insure that the proper film thickness is being applied. Be sure all surfaces, including edges, are properly coated.

NOTE: If spraying is to be discontinued for more than 3 or 4 minutes, the material pressure should be shut off at the pump. Release the material line pressure by triggering the gun, then remove the material hose at the gun and wash out gun in Acetone. This procedure is very important to prevent material from packing up at the gun and in the hose.

Information provided herein is believed to be reliable. The information is to be used as a guide, for the application of Flame Control Mastic No. 50-44 Low VOC. In as much as Flame Control Coatings, LLC has no control over the use or application to which others may put this information, we make no guarantee or warranty.