

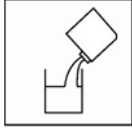


Pot Life and Induction Time

Pot life 40-45 minutes at 77° F (25° C) with 18145S™ Activator
30-50 minutes at 55° F (13° C) with 18146S™ CW Activator

Induction Time: **None** Required.

DuPont™ 18545S™ must not be applied beyond the recommended pot life.



Additives

NONE. Do not thicken or thin this product as altering formulation may adversely impact performance

Guidelines for Use



Substrates and Surface Preparation

Underlying DuPont™ Marine System primer coverage must be to product specification. It is critical that the underlying primer system be cured, sanded with 80 grit, and free of dirt and contamination prior to application of DuPont™ 18545S™ Fairing.

Environmental Conditions

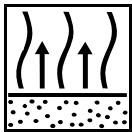
Substrate and ambient temperature must be between 55° F (10° C) and 95° F (35° C). The substrate must be at least 5° F (3° C) above the dew point. Relative humidity should be below 90%.



Application

To achieve desired results, it is critical that all tools, mixing boards, containers and other application accessories are free of contamination. Clean equipment with MEK, mineral spirits or acetone. Apply DuPont™ 18545S™ Fairing up to 1" thick total in areas which can be worked in 20 to 30 minutes. Several layers may be required to fill gouges and dents. DuPont™ 18545S™ Fairing must be cured and sanded (36-80 grit) prior to application of additional fairing or primers.

If DuPont™ 18550S™ Spray Fairing is not used, completed DuPont™ 18545S™ Fairing work must be sealed with at least two coats of Corlar® 18510S™ Epoxy Primer before applying final primer or topcoat.



Dry Times

To Sand: Time is dependent upon thickness applied and environmental conditions. Time will be approximately 12 to 24 hours.

To full cure: 3 to 12 days depending upon environmental conditions

Cure Time: @ 95° F (35° C)	3-5 days
@ 77° F (25° C)	5-7 days
@ 55° F (13° C)	10-12 days



Recoat

DuPont™ 18545S™ must be sanded with 36-80 grit prior to any further material being applied.



Cleanup

Scrape up excess material with a putty knife or cover material with an absorbent material and sweep into Container for disposal. Clean tools with DuPont™ 105™ Thinner or DuPont™ 106™ Thinner.

Disposal: React leftover resin and activator before disposing.

Physical Properties

Base Color: White

	<u>Normal Activator</u>	<u>Cold Weather Activator</u>
	DuPont™ 18145S™	DuPont™ 18146S™
VOC (mixed):	0.01 #/gal	0.02 #/gal
Color:	Blue	Blue
Weight Solids:	100%	100%
Mixed Density:	7.4 lbs/gal	7.1 lbs/gal
Theoretical Coverage:	6.4 sq ft per 1 mixed gallon @ ¼" thick 1.6 sq ft per 1 mixed gallon @ 1" thick	6.4 sq ft per mixed gallon @ ¼" thick 1.6 sq ft per mixed gallon @ 1" thick

Shelf Life: 2 years in original unopened containers. Store between 50°F and 100°F

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Do not allow material to enter drains or waterways.

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