Surface preparations

General
Surface should be clean, dry, free of oil, grease, and mildew prior to application . Noxudol 3101 is designed to adhere to most surfaces such as aluminum, wood, frp, steel, wood and fiberglass. It also adheres to primer.

Application Equipment

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.
General guidelines:

Mixer

Use a 1/2” drill with a slotted paddle

Pumps

56:1 to give an operating pressure of 5600 psi

Pump ratio	56:1
Psi	20psi / 0.3MPa
Material hose	1/2” I.D
Tip orifice	.039
Hose length	50’ maximum
Fan width	8’’

Spray guns

Mfg.	Model	Tip
Graco	XTR-HD	327-439

Mixing

Noxudol-3101 is supplied ready to use. This product will appear thick. A mixing blade must be use with a drill for a minimum of 10 minutes to achieve the necessary, smooth texture of the material required before spraying. Avoid adding water. Thinning may affect the properties of the Noxudol 3101.

Application procedures

Airless spray: A single coat built up with a number of quick passes allows greater control over quantities, thickness and finish. In certain conditions, it may be advantageous to apply two thin coats rather than one thick coat. It is necessary to ensure that the first coat has dried to touch.

Brush/Roller: Brush application, a fully loaded brush should be use. A short-nap roller can be use this will produce a smooth texture finish. We recommend to use an sprayer for larger areas..

Application Conditions

Condition	Surface	Ambient	Humidity
Normal	60˚-85˚F	60˚-85˚F	0-80%
Minimum	32˚F	32˚F	0%
Maximum	90˚F	105˚F	80%

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Thickness

During application, the wet film thickness should be checked using a wet film gauge. The gauge will indicate the thickness achieved. It is important to ensure that the first layer of wet film applied does not exceed 0.08”(2mm) thickness. After the first layer has dried to touch second layer of wet film of 0.16”(4mm) can be applied.

Curing Schedule

Drying time are dependent upon a number of factors:

- Temperature
- Air movement
- Humidity
- Thickness of Noxudol 3101
- Method of application

Noxudol 3101 can be over coated with itself as soon as the previous coat has skinned over. It may be advantageous to allow a longer drying time between coats as this will reduce the final drying time.

Sample guide to curing time based on airless sprayed.

Ambient temp	Humidity	Applied (Wet)	Curing time
80˚F	56%	0.08” (2mm)	6-8 hours

・5minutes after sprayed

↓

・35 minutes after sprayed
・dried to touch
・second coat can now be apply

↓

Completely cure

↓

Once the Noxudol 3101 has been applied to the specified DFT and is fully dry, it can be top coated with almost any type of paint.

Clean up and safety

Cleanup: Pump, mixer , pistol, tips and hose should be clean with soap and water after each use to avoid material to harden inside hose and pistol.

Safety: Read and follow all caution statements on this product data sheet and on the material

Technical data

Type of film:	solid after drying
Colour:	beige
Density:	68.1±1.9lbs/ft³(1090±30kg/m³)
Dry content:	64± 2%
Flash point:	> 212°F (100° C)
Cleaning and dilution:	water
Applying method:	sprayed, painted or rolled
Applying temperature:	60.8-86°F (16-30° C)
Spray nozzle airless:	0,025-0,045
Film thickness:	0.04-0.10in.(1,0-2,5mm)dry film/app.

Consumption of material: 0.31-0.82lbs/ft² (1,5-4kg/m²)

Storing temperature:	35.6-86°F (+2-+30° C)
Storing time:	12 months
Dry film heat resistance:	max 212°F (100°C)
Moisture pickup:	3% according to STD 1027,3375

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