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" LD
- Tip orifice: .039
- Hose length: 50’ maximum
- Fan width: 8’’

**Spray guns**
- **Mfg.**
  - Graco
- **Model**
  - XTR-HD
- **Tip**
  - 327-439

**Mixing**
Noxudol-3101 is supplied ready to use. This product will appear thick. A mixing blade must be used 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 used. A short-nap roller can be used this will produce a smooth texture finish. We recommend to use an sprayer for larger areas.

**Application Conditions**

<table>
<thead>
<tr>
<th>Condition</th>
<th>Surface</th>
<th>Ambient</th>
<th>Humidity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Normal</td>
<td>60°-85°F</td>
<td>60°-85°F</td>
<td>0-80%</td>
</tr>
<tr>
<td>Minimum</td>
<td>32°F</td>
<td>32°F</td>
<td>0%</td>
</tr>
<tr>
<td>Maximum</td>
<td>90°F</td>
<td>105°F</td>
<td>80%</td>
</tr>
</tbody>
</table>

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Sound damping compound Noxudol 3101 Application instructions

**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, a 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 overcoated 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.

<table>
<thead>
<tr>
<th>Ambient temp</th>
<th>Humidity</th>
<th>Applied (Wet)</th>
<th>Curing time</th>
</tr>
</thead>
<tbody>
<tr>
<td>80°F</td>
<td>56%</td>
<td>0.08&quot; (2mm)</td>
<td>6-8 hours</td>
</tr>
</tbody>
</table>

- 5 minutes after sprayed
- 35 minutes after sprayed
- dried to touch
- second coat can now be applied

Once the Noxudol 3101 has been applied to the specified DFT and is fully dry, it can be topcoated 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±1.9 lbs/ft³ (1090±30 kg/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: 0.31-0.82 lbs/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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