Precautions:

Consult the Material Safety Data Sheet prior to use. Keep adhesive container closed tightly when not in use. Do not use copper and its alloys to transfer, pump, spray, or as a substrate with this adhesive. Do not exceed the recommended open time, as performance will be reduced. Thinning of the adhesive is not recommended and will alter its performance.

Storage Conditions:

Store as supplied where temperature will not be less than 50°F (10°C) and should not exceed 90°F (32°C). Once opened, tightly seal after each use to avoid skinning and contamination. This product should not be stored in direct sunlight and it is not freeze/thaw stable. Product exposed to freezing temperatures will be rendered unusable. The shelf life of this material under recommended storage conditions in 6 months (180 days) from the date of manufacture.

Spray Equipment Guidelines:

HVLP as well as conventional spray equipment can be effectively used to produce excellent application results with little overspray. Using well maintained spray equipment, Dorus FD 311WDG can be consistently applied at the recommended application weight yielding greater productivity in the shop.

The following spray guns with the listed needle, spray tip and aircap, have shown excellent spray results for Dorus FD 311WDG. Other manufacturer's comparable spray guns and internal mechanisms are expected to perform equally as well.

Spray Gun Model	Spray Tip Model	Needle Model	Aircap Model
Binks 2001 (Conventional)	#67*SS*	#67*SS*	#67PB
CA Technologies L100C (Conventional)	#31-0622	#40-1122	#2167
Mach1 (HVLP)	#96	#96	#93P
CA Technologies L100H (HVLP)	#31-0216	#40-1100	#21-1094

A typical shop's spray system might consist of the following components. These settings and conditions are meant as guidelines for setting up a proper industrial spraying system, but do not include other related equipment such as ventilation, air filtration, etc… that may be warranted and/or required by OSHA. We recommend consulting with spray equipment manufacturers to design proper systems based upon the user's needs. Please consult your Henkel representative for a list of spray equipment manufacturers.

Equipment Description	Typical settings or conditions
Stainless steel HVLP spray gun	Use SS internal mechanisms; avoid brass
Stainless steel pressure pot	2.5 – 5 gallon size; use a plastic liner for pots other than *SS*
Fluid hose	3/8" – ½" ID; longer hoses may require ½" ID
Compressed air for pressure pot	15 – 25 psi; dependent upon number of guns per pot
Compressed air for atomization in gun	25 – 40 psi; controls atomization at the spray tip