

PRODUCT DATA SHEET

PT-113 NITROCELLULOSE LACQUER TOPCOAT PTI LACQUER SERIES

DESCRIPTION

PT-113 is intended for use as a general purpose interior or exterior coating for metal surfaces. PT-113 comes in most FED STD 595 colors and gloss ranges. Per TT-L-20A, different semi gloss colors have different gloss ranges. If a certain color is not called out in the spec. PTI's semi gloss range is 20 to 35 units on a 60 deg. meter.

COLORS

This coating can be provided in **any color & gloss range** as designated by the Federal Standard 595C. Custom colors are also available.

COATING PROPERTIES & CHARACTERISTICS

Flash Point	76°F
Reducer	TT-T-266 or PT-1003 TYIII
Recommended Primer	PT-402 and PT-562
Military Specification	TT-L-20A
Primer	PT-562 & PT-500
Recommended Dry Film Thickness	1 mil
Weight (lbs per gallon)	9 to 11 lbs
Theoretical Coverage	300 sq. ft./gallon

SHELF LIFE

Shelf life is only applicable for materials stored in unopened and undamaged original factory filled containers. 1 year when stored between 50°-85° Fahrenheit.

MIXING INSTRUCTIONS

Shake component A in a paint shaker for 5 – 10 minutes for optimal results.

Reduce: Use PT-1002 or PT-1003 TYIII to thin this product. For adverse weather conditions use PT-1900 solvent blend to aid gloss retention.

- **If Spraying:** Thin 1part paint to 1part thinner by volume if necessary.
- **If Brushing:** Thin 2 parts paint to 1 part thinner or as necessary.

APPLICATION

This product can be applied by brushing, rolling, conventional air spray equipment or a HVLP spray system. Please consult with a PTI representative for specific equipment recommendations and settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. Mix both paint and reducer thoroughly and filter/strain before spray application.
NOTE: It is not recommended to strain flat/matte coatings.
3. HVLP Spray Pressure: 7-10psi. Conventional spray pressure 15-30psi

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4. Always air-blow and tack wipe the surfaces to be painted. Aircraft should be grounded to prevent static.
5. Best application results: apply 2 coats: 1 fog/tack coat & 1 full coat from 0.6 – 1 mil thickness.
6. Do not allow more than 12 hours to pass before applying the second coat.
7. Recommended Dry Film Thickness is 1-1.2 mils. Some colors may require thicker films to achieve hiding.

NOTE: Application of PTI products requires the use of all OSHA approved safety equipment, including proper ventilation. Additionally, PTI products require the recommended temperature/humidity conditions and film thickness ranges for optimal performance.

DRYING & CURING SCHEDULE

Dry times are based on the dry film thickness between 1-1.2 mils (25-30 microns).

Air Dry Times (75°F / 25°C and 50% Relative Humidity)

Dries dust free in 3 to 5 minutes. Dries hard in 40 minutes; full cure in 72 hours.

Force Cure: Air dry for 10 minutes, then bake for no longer than 1 hour at 120°F

EQUIPMENT CLEANUP

Use the recommended reducers, IPA or Acetone. Do not allow material to dry or cure inside any equipment.

HEALTH, SAFETY, & STORAGE REQUIREMENTS

Refer to each individual material SDS (Safety Data Sheet) for specific requirements on the health, safety, storage and handling requirements. Follow all local, state, and national regulations during surface preparation, material application and cleanup.

PRODUCT INFORMATION & DISCLAIMER

Product Data Sheets are periodically updated to reflect new information. It is important to use the latest and most recent revision for the product being used. The foregoing information is accurate to the best of our knowledge. However, due to differences in customer handling, use and method of application which are not known and are beyond our control, Products Techniques, Inc. makes no warranties as to the end result.