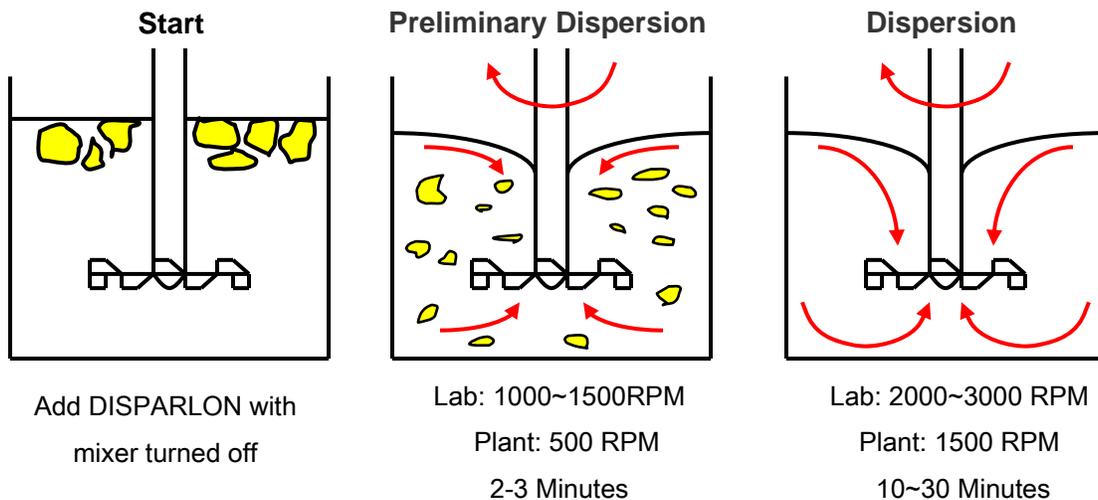


DISPARLON PASTE INCORPORATION



Tips:

- ** Blade diameter is better larger than smaller (generally 1/3 the diameter of the container),
- ** The teeth of the blade are better exaggerated than fine.

Incorporation Instructions

Pigmented or Filled Formulations:

** The easiest paste incorporation is to add it immediately after the grind and before the letdown. This is recommended for enamels or clearcoats with flattening silica or fillers. The pigment and fillers will help to disperse the DISPARLON paste.

1. **Start:** Add DISPARLON with the mixer turned off. DISPARLON will float to the surface. Lower blade to its lowest position.
2. **Preliminary Dispersion:** Start to mix at a slow speed to avoid air incorporation. Create only enough vortex to the shaft to draw in all the DISPARLON and get it into the flow of the mix.
3. **Dispersion:** Mix for 10 to 30 minutes avoiding air incorporation. Avoid dispersion temperatures above 40°C.
4. To check the dispersion, stop the mixer. Any large chunks of DISPARLON that did not get mixed will float to the surface. If large chunks are present, continue mixing.
5. As a final check of the incorporation, use a Hegman gauge. There should be no particles above 15 microns in particle size.

Clearcoats of Unfilled Formulations:

** The masterbatch technique is used when there are no pigments or fillers present in the paint. The masterbatch can be post added to the final paint. Masterbatches are typically prepared at 10 to 20% concentration.

Typical Masterbatch Formulation:

6900-20X	20 Parts
Xylene	40 Parts
Resin Solution	40 Parts

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