



Freeman No. 60 Pattern Coating

Description

The Freeman No. 60 Pattern Coating is a gray, sandable lacquer primer designed for use in cold box and no-bake sand systems. It is an ideal material for wood patterns for fast build-up and may also be used as a primer for the Freeman 90-1 Pattern Coatings.

Physical Properties

Viscosity @77°F	2,000 - 3,000 cps
Coverage (@ .001"	601 sq.ft./gal.
Dry Time (.001"- .002" DFT)	20-30 min.

**Dry time is dependent upon film thickness and atmospheric conditions. Heavier coat thicknesses will result in longer dry times.*

Directions for Use: Make sure surface is clean and dry before application. For application to wood surfaces with existing coatings, sand down to bare surface and ensure all dust has been removed before proceeding. It is advised to apply material in light coats as heavy coating may result in cracking. Material may cause a slight rise in wood grain, so light sanding of the initial coat before the application of subsequent layers is recommended for a smooth surface.

Reduction: Due to the many variables that factor into adequately thinning the No. 60 for any given application, proportions will need to be dialed in. Using Freeman 90-1 Fre-Thin Lacquer Thinner, it is recommended to start at 5%, increasing amount of thinner as necessary. For best results, do not exceed 20%.

Additionally, temperature will affect the viscosity of the No. 60, so, before adding thinner, it is advised to ensure the material is acclimated to ambient conditions before adding thinner to mitigate the chances of over-thinning.

Clean Up: Use toluene or MEK solvent to flush all equipment and spray guns after use.

The user shall determine the suitability of this product for their application and assumes all risks and liabilities associated with the use of this product. The exclusive remedy for all proven claims is replacement of our materials only and in no event shall Freeman Mfg. & Supply Co. be liable for special, incidental, or consequential claims.

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