

TECHNICAL BULLETIN

Correct Mixing Procedure for AVM System 620

The correct mixing procedure for AVM System 620

Mixing Procedure & Important Reminders

Proper mixing is critical to ensuring the coating cures correctly, maintains consistent color, and performs as intended.

1. **Pre-mix Part A:** Thoroughly mix Part A before adding any other components. Make sure the mixing paddle reaches the sides and bottom of the container.
2. **Add the color pack:** If the selected color requires a color pack, add the entire color pack to Part A and mix until the color is completely uniform.
3. **Pre-mix Part B:** Part B must be thoroughly mixed before it is added to Part A because it contains the UV stabilizers. Failure to properly mix Part B can result in color variations and inconsistent performance.
4. **Combine Parts A and B:** Pour the entire contents of Part B into Part A. Do not estimate the amount or leave any material behind in the Part B container.
5. **Mix thoroughly:** Using a clean mixing paddle and a low-speed drill, mix until the material is completely uniform. Move the paddle around the sides and bottom of the pail, ensuring there are no visible ribbons or streaks remaining. Hand mixing is not acceptable.
6. **Avoid introducing air:** Keep the mixing paddle submerged and do not mix at excessive speed. Introducing too much air can contribute to pinholes in the finished coating.
7. **Use immediately:** Once Parts A and B are combined, the curing process begins. Only mix as much material as the crew can apply within the approximate 20-minute working time. Working time may vary depending on material, substrate, and ambient temperatures.

Additional reminders:

1. Do not thin the material or add solvents unless the application has been discussed and approved in advance by me or the technical team. Xylene may be recommended under certain conditions.
2. Full kits should always be mixed whenever possible.
3. When partial kits are necessary, measure the components accurately at a ratio of four parts A to one part B. Do not estimate or “eyeball” the quantities—use a properly graduated measuring container.
4. Never attempt to extend the working time by adding additional Part A or solvents.
5. Confirm that the material, substrate, and ambient temperatures are within the published application requirements.
6. Incomplete mixing or insufficient Part B can result in soft, tacky, or uncured material, as well as color variations.
7. Always review the current Technical Data Sheet before beginning an installation.

Please make sure this information is communicated to distributors and applicators before they begin an AVM 620 installation. If there are any questions, please reach out to Joanne Roach or the technical team before mixing or applying the product.