

## DILUTION/SOLIDS & WFT/DFT CALCULATIONS

| Original Solids Content of Material Before Adding Thinner | Solids Content after Thinning |    |    |     |     |     |     |     |     |     |     |
|---|-------------------------------|----|----|-----|-----|-----|-----|-----|-----|-----|-----|
|   | 2%                            | 5% | 7% | 10% | 12% | 15% | 17% | 20% | 25% | 30% | 35% |
| 100%  | 98                            | 95 | 93 | 91  | 89  | 87  | 85  | 83  | 80  | 77  | 74  |
| 95%   | 93                            | 90 | 89 | 86  | 85  | 83  | 81  | 79  | 76  | 73  | 70  |
| 90%   | 88                            | 86 | 84 | 82  | 80  | 78  | 77  | 75  | 72  | 69  | 67  |
| 85%   | 83                            | 81 | 79 | 77  | 76  | 74  | 73  | 71  | 68  | 65  | 63  |
| 80%   | 78                            | 76 | 75 | 73  | 71  | 70  | 68  | 67  | 64  | 62  | 59  |
| 75%   | 74                            | 71 | 70 | 68  | 67  | 65  | 64  | 63  | 60  | 58  | 56  |
| 70%   | 69                            | 67 | 65 | 64  | 63  | 61  | 60  | 59  | 56  | 54  | 52  |
| 65%   | 64                            | 62 | 61 | 59  | 58  | 57  | 57  | 54  | 52  | 50  | 48  |
| 60%   | 59                            | 57 | 56 | 55  | 54  | 52  | 51  | 50  | 48  | 46  | 44  |
| 55%   | 54                            | 52 | 51 | 50  | 49  | 48  | 47  | 46  | 44  | 42  | 41  |
| 50%   | 49                            | 48 | 47 | 46  | 45  | 44  | 43  | 42  | 40  | 39  | 37  |
| 45%   | 44                            | 43 | 42 | 41  | 40  | 39  | 38  | 37  | 36  | 35  | 33  |
| 40%   | 39                            | 38 | 37 | 36  | 36  | 35  | 34  | 33  | 32  | 31  | 30  |
| 35%   | 34                            | 33 | 32 | 31  | 31  | 30  | 30  | 29  | 28  | 27  | 26  |
| 30%   | 29                            | 29 | 28 | 27  | 27  | 26  | 26  | 25  | 24  | 23  | 22  |
| 25%   | 24                            | 24 | 23 | 23  | 22  | 22  | 21  | 21  | 20  | 19  | 19  |

| Solid Contents after thinning | Wet Film Thickness Requirements<br>Dry Film Thickness (Microns) |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |
|-------------------------------|---|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
|                               | 50  | 75  | 100 | 125 | 150 | 175 | 200 | 225 | 250 | 275 | 300 | 325 | 350 | 375 | 400 | 425 |
| 100                           | 50  | 75  | 100 | 125 | 150 | 175 | 200 | 225 | 250 | 275 | 300 | 325 | 350 | 375 | 400 | 425 |
| 95                            | 53  | 80  | 105 | 132 | 158 | 184 | 211 | 237 | 263 | 290 | 342 | 362 | 368 | 385 | 421 | 447 |
| 90                            | 56  | 83  | 111 | 139 | 167 | 194 | 222 | 250 | 278 | 306 | 351 | 361 | 389 | 417 | 444 | 472 |
| 85                            | 59  | 88  | 118 | 147 | 177 | 206 | 235 | 265 | 294 | 324 | 382 | 382 | 412 | 441 | 471 | 500 |
| 80                            | 63  | 94  | 125 | 156 | 188 | 219 | 250 | 281 | 319 | 344 | 406 | 406 | 438 | 469 | 500 | 531 |
| 75                            | 67  | 100 | 133 | 167 | 200 | 233 | 267 | 300 | 333 | 367 | 433 | 433 | 467 | 500 | 533 | 567 |
| 70                            | 71  | 107 | 143 | 179 | 214 | 250 | 286 | 321 | 357 | 393 | 464 | 464 | 500 | 536 | 571 | 607 |
| 65                            | 77  | 115 | 154 | 192 | 231 | 269 | 308 | 345 | 385 | 423 | 462 | 500 | 539 | 577 | 615 | 654 |
| 60                            | 83  | 125 | 167 | 208 | 250 | 292 | 333 | 375 | 417 | 458 |     |     |     |     |     |     |
| 55                            | 91  | 136 | 182 | 227 | 273 | 318 | 364 | 408 | 455 |     |     |     |     |     |     |     |
| 50                            | 100   | 150 | 200 | 250 | 300 | 350 | 400 | 450 |     |     |     |     |     |     |     |     |
| 45                            | 111   | 167 | 222 | 278 | 333 | 389 | 444 |     |     |     |     |     |     |     |     |     |
| 40                            | 125   | 188 | 250 | 313 | 375 | 483 |     |     |     |     |     |     |     |     |     |     |
| 35                            | 143   | 214 | 286 | 357 | 429 |     |     |     |     |     |     |     |     |     |     |     |
| 30                            | 167   | 250 | 333 | 417 |     |     |     |     |     |     |     |     |     |     |     |     |
| 25                            | 200   | 300 | 400 |     |     |     |     |     |     |     |     |     |     |     |     |     |