

150 Series Modified Acrylic Enamel Topcoat

DESCRIPTION

The 150 Series is a medium solids, modified acrylic enamel topcoat which offers very good gloss with excellent dry times. The 150 Series is compliant with the national VOC rules.

COMPONENTS

- 150 Series color
 - H4
 - S9860/S9870/S9885/S9895
- Base
Hardener (optional)
Fast/Medium/Slow/Very slow - Reducers

Note: Uses NorthStar Urethane SHS tints for color formulas.

MIXING RATIO

Mix eight (8) parts 150 Series color with one (1) part H4 hardener. Should be reduced up to 25% by volume with selected reducer.

POT LIFE at 77° F

2 hours with hardener

CLEAN UP

Use **NORTHSTAR** Lacquer Thinner. (Check local regulations)

PHYSICAL DATA

Solids wt. (as mixed)	48% (average of colors)
VOC as mixed	4.4
Color	Full intermix from SHS tints

DRY / FLASH TIMES

Air Dry at 77° F

Flash between coats	10-30 minutes
Tape time	Overnight
Dust free	45 minutes
Tack free	30 minutes

Force Dry

Flash before force dry	15 minutes flash
Force dry time	30 minutes at 140° F

GUN SETUPS

Conventional

Gravity Feed	1.3 mm – 1.5 mm
Siphon Feed	1.3 mm – 1.5 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed	30 – 40 psi
Siphon Feed	35 – 45 psi
HVLP at cap	8 – 10 psi

SURFACE PREPARATION

Use **NORTHSTAR** Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.

APPLICATION

- Apply 2-3 medium wet coats over substrate
- Allow 10-30 minutes between coats
- Scuff after 24 hours before recoating
- Clean gun after spraying is completed

SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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