

DRY / FLASH TIMES

Air Dry at 77° F

Flash between coats	5-20 minutes
Tape time	20-45 minutes
Tack free	15 minutes
Dust free	20-30 minutes

Do not force dry basecoat

Force dry for clear – See appropriate data sheet

Flash time before clearcoat	30 minutes (minimum) 72 hours (maximum)
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GUN SETUPS

Conventional

Gravity Feed	1.2 mm – 1.5 mm
Siphon Feed	1.2 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 5-20 minutes between coats
- Scuff and re-basecoat after 72 hours before clear coating
- 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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