

## 990 Series

### OEM & Fleet Basecoat

09142016

#### DESCRIPTION

The 990 Series is a premium OEM and Fleet Basecoat which offers outstanding coverage, fast cure times, and excellent holdout. 990 Basecoat is easy to use and complies with all applicable VOC regulations when properly clear coated. For clear examples and VOC data, please refer to the following charts.

#### COMPONENTS

- 990 Series color
  - H5
  - H05
  - SB7175
  - SB075
- Base**  
**Activator**  
**Zero VOC Activator**  
**Base maker Reducer**  
**3.5 VOC Base maker Reducer**

#### MIXING RATIO

Mixing ratio is 4:4:1. Mix 16 fluid ounces 990 Series color to 16 fluid ounces selected base maker reducer and add 4 fluid ounces selected activator. 990 requires activator.

#### VOC DATA

<u>Clear Coat Used</u>	<u>System VOC (H5)</u>	<u>System VOC (H05)</u>
GM350	3.73	3.50*
MS210	2.80**	2.69**
SC280	2.80**	2.69**

\* Complies with BAAQMD Rule 45, SCAQMD Rule 1151, Group 2

\*\* Complies with SCAQMD Rule 1151, Group1

#### POT LIFE AT 77° F

2 hours minimum

#### CLEAN UP

Use NORTHSTAR Lacquer thinner or zero VOC solvents. (Check local regulations)

#### PHYSICAL DATA

Solids wt. (as mixed)	30% (avg of colors)
VOC as mixed	See chart
Color	Selected automotive and fleet colors

## DRY / FLASH TIMES

### Air Dry at 77° F

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

### Do Not Force Dry Basecoat

Force dry for clear	See appropriate data sheet
Flash time before clearcoat	30 minutes (min); 72 hours (max)

## 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.