

FL1

Universal Flattener

09142016

DESCRIPTION

FL1 is a universal flattening agent that can be used in all NorthStar systems except the 990 Basecoat system. FL1 is compliant with National VOC rules.

COMPONENTS

- FL1 Universal Flattener

MIXING RATIO

RULE 1: When using FL1 in the 928, 950, and 935 Series, if more than 32 ounces is used in a ¾ gallon of color, then the end user mixing ratio should be a **4-1-1 ratio**.

RULE 2: Add FL1 directly into the color formula by displacing some of the binder with FL1.

RULE 3: Spray out an activated, reduced sample and let dry completely to determine degree of gloss achieved.

If **adding to factory pack colors**, please observe **RULE 1**.

If more than 32 ounces is used per gallon, additional reducer may be needed to make it sprayable.

POT LIFE AT 77° F

No Affect

CLEAN UP

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

PHYSICAL DATA

Solids wt. (as mixed)	48.5%
VOC as mixed	4.8
Color	Milky

DRY / FLASH TIMES

Adding FL1 to your coating will have a tendency to speed up the flash. It will not affect the cure rate.

GUN SETUPS

Conventional	
Gravity Feed	1.4 mm – 1.5 mm
Siphon Feed	1.4 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

Note : Use the proper application instructions for the system in which you are using this additive.

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.