

135 Series

DTM Urethane Topcoat

09092016

DESCRIPTION

The 135 Series is a medium solids, modified urethane topcoat which offers very good gloss with excellent dry times and tenacious adhesion. The 135 Series may be used over properly primed substrates or used direct to metal (DTM) over properly prepared metal substrates. The 135 Series is compliant with national VOC rules and California rules including SCAQMD Rule 1107, Rule 1151 Groups 1 and 2.

COMPONENTS

- 135B Solid Binder
- 135M Metallic Binder
- 135SL Slow Binder
- SHS Tints (at 37%) Color Tints
- H05 2.8 VOC Activator
- H6 3.5 VOC Activator

MIXING RATIO

Mix four (4) parts 135 Series color with one (1) part selected activator. Paint is then ready to spray. The 135 Series must be activated.

NOTE: All 135 Series factory packaged colors are made with 135SL binder to ensure a proper flash time on larger jobs. **135B is a fast drying binder.**

POT LIFE AT 77° F

2 hours

CLEAN UP

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

PHYSICAL DATA

Solids wt. (as mixed)	53%(avg of colors)
VOC as mixed (H05 Activator)	2.8
VOC as mixed (H6 Activator)	3.5
Color	Intermix System

DRY / FLASH TIMES

Air Dry at 77° F

Flash	10-25 minutes
Tape Time	Overnight
Dust free	60 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 medium wet coats over substrate for solid colors
- May be cross-coated with solid colors
- Apply 2-3 medium wet coats over substrate for metallic or pearl colors.
- Allow 10-20 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.