

## 128 Series

### Modified Enamel DTM Topcoat

09092016

#### DESCRIPTION

The 128 Series is a medium solids, modified DTM enamel topcoat which can be used as a 1K single component topcoat or may be mixed 8-1 with a hardener to enhance its gloss and durability. The 128 Series has Super Anti-Sag properties that can be applied to high, wet film builds when using airless, air assist airless, or pressure pot systems. 128 Series complies with all applicable air regulations including SCAQMD Rule 1151. (Use H05 hardener and Zero VOC reducer to maintain VOC compliance).

#### COMPONENTS

- 128 Series color
  - H4, H05
  - S9860/S9870/S9885/S9895
  - S065, S075, S085, or S021 Series
  -
- |  |
|--|
| <b>Base</b>                                  |
| <b>Hardener (optional)</b>                   |
| <b>Fast/Medium/Slow/Very slow – Reducers</b> |
| <b>Zero VOC Reducers</b>                     |

**Note: Uses NorthStar Urethane SHS tints for color formulas.**

#### MIXING RATIO

As a 1K – Spray as supplied or may be reduced up to 25% with selected reducer.

As a 2K – Mix eight (8) parts 128 Series color with one (1) part H4 or H05 hardener. Can 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)	47%
VOC as mixed with VOC compliant products	2.8
VOC as mixed with standard VOC products	3.5
Color	Full intermix from SHS tints

#### DRY / FLASH TIMES

**Air Dry at 77° F**

Flash 15-30 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 10-15 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.