

## 150 Series

### Modified Acrylic Enamel Topcoat

09092016

#### DESCRIPTION

The 150 Series is a medium solids, modified acrylic enamel topcoat which offers very good gloss with excellent dry times. The 150 Series is compliant with the national VOC rules.

#### COMPONENTS

- 150 Series color
  - H4
  - S9860/S9870/S9885/S9895
- Base**  
**Hardener (optional)**  
**Fast/Medium/Slow/Very slow – Reducers**

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

#### MIXING RATIO

Mix eight (8) parts 150 Series color with one (1) part H4 hardener. Should 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)	48%
VOC as mixed	4.4
Color	Full intermix from SHS tints

#### DRY / FLASH TIMES

##### Air Dry at 77° F

Flash between coats	10-30 minutes
Tape Time	Overnight
Dust free	45 minutes
Tack free	30 minutes

##### Force Dry

Flash before force dry  
Force dry time

15 minutes flash  
30 minutes at 140° F

## GUN SETUPS

### Conventional

Gravity Feed  
Siphon Feed

1.3 mm – 1.5 mm  
1.3 mm – 1.5 mm

## AIR PRESSURES

### Conventional at Gun

Gravity Feed  
Siphon Feed  
HVLP at cap

30 – 40 psi  
35 – 45 psi  
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.