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TECHNICAL DATA SHEET

828FL FLAT DTM (DIRECT TO METAL) BINDER

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As a high performance Flat DTM Coating over suitable primers or over properly prepared substrates, including: Hot and Cold roll steel, Galvanized Steel, Aluminum, fiberglass, plastics and wood. Outstanding gloss and color retention.

- Field Applications:

- Heavy Industrial equipment
- Oil Field equipment
- Construction equipment
- Aircraft and Marine (above the water line)
- Airport ground support equipment
- Truck and Trailer Refinishing
- Equipment, Truck, Trailer OEM finishing



COMPONENTS

- 828FL Flat DTM (Direct to Metal) Binder
- H05 Fast Activator - Low VOC
- H5 Fast Activator - National Rule
- S065/S075/S085 Fast/Medium/Slow Low VOC Reducer
- S9860/9870/9885 Fast/Medium/Slow National Rule Reducers



MIXING RATIO

Mix Three (4) parts 828FL Flat DTM Binder to One (1) Part Selected Activator and One (1) selected suitable Northstar Reducer.



POT LIFE

2 hours at 68° F



CLEAN UP

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



PHYSICAL DATA

Solids wt. (as mixed) 35.79% (average)
Solids by Volume 31.73% (average)



DRY / FLASH TIMES at 68°F/20°C

Dust Free 1 hour
Dry to Touch 2-4 hours
Total Hardness 24 hours
Force Dry at 140°F/60°C 45 minutes
Flash 10-20 minutes between coats
Chemical Resistance Maximum resistance after 7 days



GUN SETUPS

HVLP Gravity Feed	1.3mm -1.5mm
Pressure Pot HVLP	1.0mm-1.1mm
Air Assist Airless	1.0mm-1.1mm
Conventional	1.4mm-1.7mm
Airless	Not Recommended
Film Build	3.0mil-5.0mils when applied as directed



SURFACE PREPARATION (FERROUS METALS)

• **Best Case:** SA2 sandblast Blow all dust and contaminants off and apply Suitable Northstar primer, followed by topcoat as directed.

• **Better:** Hot Phosphate wash system, blow dry and apply suitable Northstar primer, followed by topcoat as directed.

• **Good:** Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminants before and after mechanical abrasion with S20 Northstar wax and grease removal solvent, making sure all residue is removed. Apply suitable Northstar primer followed by topcoat as directed.

Aluminum: Clean surface with S20 Northstar wax and grease remover. Apply Northstar Epoxy Primer followed by topcoat for max performance.

• **Galvanized Steel:** Clean all dust, oil residue, and contaminants from surface using a S20 Northstar wax and grease remover. Light Sanding (320P grit) Clean again with S20 wax and grease remover using a wipe and dry process. Apply Northstar Epoxy Primer follow by topcoat as directed for max performance.



APPLICATION AT 77° F/25°C

Two medium wet coats, allow 10-20 minutes flash between coats or apply one medium coat follow by a medium cross coat.



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.

