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TECHNICAL DATA SHEET

928 SERIES BINDER

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NorthStar's 928-series is the tried and proven success of High Solids technology. 928 offers outstanding gloss retention, chemical resistance, and long lasting durability. 928 is a single stage paint system utilizing the Northstar SHS toner system. The 928 provides outstanding coverage and film build as when desired



COMPONENTS

- 928 Series
- H8 (2.8 VOC) Activator
- H7 (3.5 VOC) Activator
- S9870/S9885/S9895 Reducer
- * With H8 3.5 VOC, With H7 4.2 VOC
- S021 Fast Zero VOC Reducers
- S065/075/085 Zero VOC Reducers
- A544 Pot Life Extender



MIXING RATIO

Mix Three (3)parts 928 Series to One (1) Part Selected Activator.

- For Brush or Roller, reduce 10% with selected reducer.
- For Air assisted airless & pressure pot, reduce 15-25% with selected reducer
- For HLVP reduce 25-50% with selected reducer



POT LIFE

1.5 hours @ 77° F/25° C



CLEAN UP

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



PHYSICAL DATA

Solids wt. (as mixed) 60% (average)
Solids by Volume 53% (average)
Gloss (60° angle) 90+



DRY / FLASH TIMES

Air Dry at 77° F/25°C
Flash between coats 10-20 minutes
Dust Free 35 minutes
Tack Free 20-30 minutes
Sand & Buff Solid Colors 12 hours (Air Dry @ 77° F/25° C)

FORCE DRY

Flash before dry 15-20 min flash
Force dry time 40 minutes @ 140° F/60° C
Sand & Buff 1 hour after cooldown at minimum 77° F/25° C



GUN SETUPS

Conventional

Gravity Feed 1.5 mm – 1.8 mm
Siphon Feed 1.5 mm – 1.8 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed 35-45 psi
Siphon Feed 40-50 psi
HVLV at cap 8 – 10 psi



SURFACE PREPARATION

Use NORTHSTAR Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.



APPLICATION AT 77° F/25°C

- Apply medium wet coats over substrate to desired film thickness
- Allow 10-15 minutes between coats.

• DO NOT APPLY IF THE SURFACE TEMPERATURE OF THE OBJECT IS BELLOW 55° (12.7°C) OR ABOVE 110°F (48° C)

COMPATIBILITY WITH OTHER COATINGS:

928 Series may applied over the fsuitable Lusid Northstar Primers & Sealers.



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.

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