NORTHSTAR™

7162013

SX01

"STIXX" Adhesion Promoter

TECHNICAL DATA SHEET

DESCRIPTION

SX01 is a solvent-based adhesion promoter for all types of plastics, metals including aluminum, stainless steel, any Non Ferris metal, fiberglass, glass, porcelain and E-Coat substrates. SX01 has excellent performance on properly prepared bumper covers of all chemical makeup.

COMPONENTS

- SX01

MIXING RATIO

SX01 comes ready to spray.

POT LIFE AT 77° F

N/A

CLEAN UP

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

PHYSICAL DATA

Solids wt.	10%
Coating VOC	800.22 g/L (6.68 lbs/gal)
Material VOC	800.22 g/L (6.68 lbs/gal)
Color	Clear

DRY / FLASH TIMES

Air Dry at 77° F

Flash	5-10 minutes
To sand	Not recommended
To topcoat	10-30 minutes

Force Dry	Not recommended

GUN SETUPS

Conventional

Gravity Feed	1.4 mm – 1.6 mm
Siphon Feed	1.4 mm – 1.6 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed	30 – 40 psi
Siphon Feed	35 – 45 psi
HVLP at cap	8 – 10 psi

SURFACE PREPARATION

For raw new bumpers, release agent contamination is probable. Wipe and clean with S20 cleaner first followed by a hand scrub with S10 Clean Wipe and a gray scotch brite pad and wipe dry. Then bake the bumper at 140° F for 35 minutes and let cool. Follow up by wiping and cleaning again with S20 Cleaner and follow up with a hand scrubbing of S10 Clean Wipe and a gray scotch brite pad and then clean thoroughly again with S10 Clean Wipe and wipe dry. Then apply SX01 as described below.

Painted surface and primed areas should be sanded with 800P grit sandpaper by hand and 500P-600P when using an orbital sander and should not need adhesion promoter. Pre-primed bumpers should be sanded as above and should not need adhesion promoter.

For Non Ferris metals including aluminum, glass and any other substrate, degrease with a solvent based wax and grease remover such as GS8340 or NorthStar S20, then clean and dry using S10 Clean Wipe.

Use S10 Clean Wipe to clean substrate free of dirt, and foreign contaminants and tack off with a base coat tack rag only.

APPLICATION

- On aftermarket bumpers and plastic parts, always test pre-primed products with a solvent rub for wrinkling issues. If wrinkling occurs, then strip off the aftermarket primer before proceeding.
- Apply one medium coat over substrate to be painted. Avoid heavy or multiple coats.
- Re-apply another medium coat after 4 hours before applying topcoat.
- Clean gun after spraying is complete.

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.