

100 Series

Acrylic Enamel Topcoat

05132021

DESCRIPTION

The 100 Series is a medium solid's, air-dry acrylic enamel topcoat which offers good gloss with excellent dry times. The 100 Series complies with the National Rule for VOC.

COMPONENTS

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

MIXING RATIO

100 Series Acrylic Enamel does not require activator. For enhanced performance, mix eight (8) parts 100 Series color with one (1) part H4 hardener. Should be reduced 15-25% with S9860/S9870/S9885/S9895.

POT LIFE AT 77° F

2 hours with hardener.

CLEAN UP

Use NORTHSTAR Lacquer thinner or zero VOC solvent. (Check local regulations)

PHYSICAL DATA

Solids wt. (as mixed)	32%
VOC as mixed	4.4
Color	Black and White

DRY / FLASH TIMES

Air Dry at 77° F

Flash	10-15 minutes
Tape Time	8 hours
Dust free	20 minutes
Tack free	45 minutes

Force Dry

Flash before force dry	15 minutes flash
Force dry time	30-40 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 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.