



## Factory Pack

Paladin Factory Pack is a high quality DTM urethane topcoat designed to provide excellent UV protection and long lasting durability for transportation and marine applications (applied above the waterline). Paladin offers excellent abrasion and moisture resistance with exceptional gloss, DOI and color retention.



### Mix Ratio

3 parts Factory Pack Color (19-XXXX).

1 part Activator Medium (19-7014), Slow (19-7024) or Flattening Activator\* (19-7054).

1 part Paladin Zero VOC Reducers\*\*.

\* Flattening Activator (19-7054) is required for use in Hot Rod Black (19-7151) to achieve a matte effect.

\*\* Transtar 6700 and 6700-F Series reducers can be used. Using 6700 series reducer will increase VOC above the 2.8 limit in regulated areas.



### Suitable Substrates

- DTM over properly sanded & cleaned fiberglass, glass reinforced plastics (GRP), steel and plastic.



### Surface Prep & Application

Sand and clean all areas prior to application with SCAT Wax & Grease Remover. Ensure all residue is removed prior to application.

Apply 1 coat followed by 1 or 2 medium wet coats. Avoid heavy wet coats.



### Flash/Dry Times (Air Dry) @ 77°F (25°C)

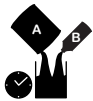
Flash Between Coats: 10 minutes.

Dust Free: 20 minutes.

To handle: 4 – 8 hours.

To recoat: 6 – 8 hours, overnight preferred.

Time to Assemble/Deliver: Overnight.



### Pot Life

2 hours @ 77°F (25°C).



### Polishing

Optimum Times: Air Dry: Overnight @ 77°F (25°C).

Sanding: Use 1500 grit or finer or use 1500 DA or finer.

Polishing: Use the Transtar Ultimate Finish System Compounds #5361, 5374, 5384 following the application information on these TDS.



**Gun Set-up**

*Conventional*

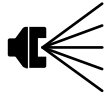
Siphon Feed: 1.3 – 1.6 mm

Gravity Feed: 1.3 – 1.6 mm

*HVLP/LVLP*

Siphon Feed: 1.3 – 1.6 mm

Gravity Feed: 1.3 – 1.6 mm



**Air Pressure**

*Conventional/Siphon Feed:* 45 – 55 psi at the gun

*Gravity Feed:* 45 – 55 psi at the gun

*HVLP/LVLP:* 8 – 10 psi at the gun



**Technical Data & Physical Properties**

*Mix Ratio*.....3:1

*Pot Life* .....2 hours

*Theoretical Dry Film*.....339 ft<sup>2</sup> @ 2.0 mil

*Dry Film Thickness* .....2.0 – 3.5 mils

*Volume Solids*.....57 – 77 %

*Actual VOC* .....See label for each color

*Regulatory VOC* .....See label for each color

*Viscosity (RTS)*..... 19 – 21 sec

Shelf Life – 3 years from date of manufacture when maintained in protected storage @ 40 – 100°F (4° – 38°C) (subject to inspection thereafter).



**Limitations**

Apply in good weather when air and surface temperatures are above 60°F (15°C) and surface temperature is at least 37°F (3°C) above the dew point. Humidity must be below 90%. Conditions should be within these limits for the full curing time of the coatings. Conditions of high humidity and/or low temperatures can adversely affect the curing and gloss of the coating. For optimum application properties, material should be between 70 – 90°F (21 – 32°C) prior to mixing and applying. Maintain unmixed material in a closed container in protected storage at 40 – 100°F (4° – 38°C).



**Safety**

Read all directions, safety warnings and SDS before using any Paladin Industrial Coating Products. **For use by professionally trained painters only. Not for sale or use by the general public. Keep out of reach of children.**

**LIMITED WARRANTY**

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Paladin Industrial Coatings warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within one year from date of shipment, Paladin Industrial coatings will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Paladin Industrial Coatings and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.