

Technical Data Sheet

The No Mix HS Low VOC Basecoat System is a high performance tinting system that requires no mechanical agitation. The system exhibits exceptional hiding, metallic and pearl control, which increase productivity, improve color match and reduce cycle times.

SUITABLE SUBSTRATES

Substrate	Substrate	Substrate
Bare Steel	Raw Plastic - Rigid (SMC, BMC) +	Primer - Self-Etching ✓
Bare Galvanized	Raw Plastic - Flexible (ABD, PPO) +	Primer - 1K ✓
Bare Aluminum	Raw Plastic - Soft (PUR) +	Primer - 2K ✓
OEM E-Coat**	Plastic Part - Primed ++	OEM Finish & Old Paint Work - Reversible
Fiberglass/SMC Unbroken Gel Coat	Body Filler	OEM Finish & Old Paint Work - Non-Reversible ✓

** Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

MIXING



By Volume: 1 part No Mix HS Basecoat
1½ part 6700 or 6700-F Series Urethane Grade Reducer*

Pot Life Unactivated - unlimited

Activated - 8 hour (activate only what you intend to spray as color may become seedy after 8 hours)

Use of LV-418 is mandatory for formulas containing LV-29 and for Lifetime Warranty of No Mix HS. It is optional for all other HS formulations, but highly recommended to improve chip resistance and flexibility especially when applying tri-coats. For additional mixing instructions, refer to the Additives section on the next page.

Note: For underhood, matt cladding and interior colors, activate the basecoat by adding ½ fl. oz. of LV-418 No Mix Activator to the ready to spray quart of color.

* Select reducer appropriate for shop conditions, job size and regulatory requirements. Using urethane grade reducer will increase VOC's. For the use of additives, please refer to next page.

FLASH TIMES/DRY TIMES



Flash Between Coats 5-10 minutes
Tape Time 20-25 minutes
Before Applying Clearcoat 10-15 minutes
Before Nib Sanding 25-30 minutes

SURFACE PREPARATION



Finish sand with 400-600 grit wet or dry.

Prepare blend areas using 800-1000 grit wet or dry.

* For more information on surface prep and application refer to next page.

SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.2 - 1.4	1.2 - 1.6
Air Pressure	10 PSI @ aircap	30 - 40 PSI @ gun inlet
Mil Thickness: 0.75-1.5 mils (dry film thickness)		

LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
 - Before use, read and follow all TDS, label and SDS precautions.
 - See next page for more detailed production application.
- Visit www.tat-co.com to assure you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).

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SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	HVLP/LVLP
Fluid Tip	1.2-1.4 mm	1.2-1.6 mm	1.2-1.4 mm
Air Pressure	25-35 PSI (@gun)	30-40 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	N/A

Always refer to gun manufacturer's recommendation for proper set up and spray pressure.

SURFACE PREPARATION

Cleaning: Clean area with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

Sanding: Finish sand with 400-600 grit wet or dry. Prepare blend areas using 800-1000 grit wet or dry or Scuff & Prep Paste 6338 with a gray scuff pad. Thoroughly degrease.

ADDITIVES

Additives: Appearance Improver (6487): DO NOT USE.
 Fisheye Remover (6737) - DO NOT USE.
 Universal Urethane Flex Additive (9194) - DO NOT USE.
 Kicker (6417): DO NOT USE.
 No Mix Activator (LV-418): Add ½ fl. oz. per ready to spray quart
 No Mix Activator (LV-418) Mixing by Weight:

Amount HS or MS	LV-418 grams	Amount HS or MS	LV-418 grams
¼ pint (4 oz)	2.3g	2 quarts (64 oz)	36.6g
½ pint (8 oz)	4.6g	3 quarts (96 oz)	54.0g
1 pint (16 oz)	9.2g	1 gallon (128 oz)	73.3g
1 quart (32 oz)	18.3g		

APPLICATION & FILM BUILD

Coats: Apply 2-3 medium wet coats. Allow 5-10 minute flash. Note: Flash times may vary due to shop temperature and reducer selection.

Film Build: 0.75 - 1.5 mils

Full Panel Application:

Apply 2-3 coats of until hiding is achieved, allow a 5-10 minute flash time between coats.

Dry Time: Allow 20-25 minute dry time before taping. Allow to dry 10-15 minutes before the application of clearcoat. Allow 25-30 minutes before nib sanding.

Spot Repair:

1. Apply 1-2 coats of Basecoat Blender LV-500 to the prepared blend area. Allow a 10-15 minute flash before application of basecoat.
 2. Apply 2-3 coats of basecoat to the repair areas or until hiding is achieved. Extend each coat slightly beyond the first and taper each coat. Allow proper flash time between coats.
 3. Mix 2 parts of LV-500 with 1 part of ready to spray basecoat and apply 1-2 coats over the blend area.
- Dry Time: Allow 20-25 minute dry time before taping. Allow to dry 10-15 minutes before the application of clearcoat.

3 Stage/Tri-Coat:

A letdown panel should be created prior to application to aid in color matching.

Ground Coat Application:

Follow application instructions above for either full panel or spot repair.

Dry Time: Allow ground coat to dry 15-20 minutes before the application of midcoat/pearl coat.

Midcoat Application:

Follow application instructions above for either full panel or spot repair. When performing a spot repair is it critical to keep the midcoat application within the ground coat application in order to produce an invisible repair.

Dry Time: Allow 20-25 minute dry time before taping. Allow midcoat to dry 20-30 minutes before the application of clearcoat. Failure to allow adequate dry time could result in solvent popping or wrinkling.

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PRODUCT SPECIFICATIONS

Color: Various solid, metallic, pearl and xirallc colors	Shelf Life: 3 years
RTS Solids by Weight: 25-44% depending on color	

REGULATORY

Category: Color Coating

Ready to spray mixed basecoat has a regulatory VOC of less than 3.5#/gal (420 g/l) when reduced with 6700-F Series Zero VOC Urethane Grade Reducers. Refer to mixed paint can or the No Mix software for VOC information for each mixed color.