

Technical Data Sheet

No Mix Single Stage Urethane is a 2K urethane topcoat for general automotive refinishing.

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: 3 parts No Mix Single Stage
1 part Single Stage Activator (LV-224/234/244)
1 part 6700 or 6700-F Series Urethane Grade Reducer*

Pot Life 1.5-2 hours

* 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 10-15 minutes
Before Applying Clearcoat 10-15 minutes
Delivery 16-24 hours @75°F (23°C)
Force Dry 40 minutes @ 140°F (60°C)

SURFACE PREPARATION



Finish sand with 400-600 grit dry or 600-800 grit wet.
Prepare blend areas using 800-1000 grit wet or dry.
Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 1391/1394.
Shake single stage well (6-8 minutes) before mixing with activator and reducer.

* 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	1.3 - 1.6	1.3 - 1.6
Air Pressure	10 PSI @ aircap	30 - 40 PSI @ gun inlet

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	1.3-1.6 mm	1.3-1.6 mm	1.3-1.6 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 320-500 grit dry or 500-800 grit wet. Prepare blend areas using 1200-1500 grit wet or dry or Scuff & Prep Paste 6338 with a gray scuff pad. Thoroughly degrease. To optimize hiding, apply Kwik Seal 6200 Series or Signature Series 2.1 Low VOC Sealer 9500 Series before topcoating.

ADDITIVES

Additives:

- Appearance Improver (6487): Can be used at a rate of 1 - 2 oz per sprayable quart. DO NOT use Appearance Improver if Kicker is being used.
- Fisheye Remover (6737) - Can be used at a rate of ½ oz per sprayable quart.
- Universal Urethane Flex Additive (9194) - Recommended when used on soft flexible substrates such as bumper & trim applications. May be used, refer to TDS for mixing recommendations.
- Kicker (6417): Can be used in temperatures BELOW 65°F (24°C) at 1/4 oz. per sprayable quart.

APPLICATION & FILM BUILD

Coats: Apply 3-4 coats or until hiding is achieved. Allow 10-15 minute flash between coats. Note: Flash times may vary due to shop temperature and reducer selection.

Full Panel Application - Solid & Metallics:

Apply 3 - 4 coats or until hiding is achieved, allow 10 - 15 minutes flash time between coats (Flash times may vary due to shop temperature, activator and reducer selection)

If mottling occurs or when spraying coarse metallics, use a cross coat application for uniform flake orientations. A cross coat application is done by spraying 45° to 90° of the last application.

Spot Repair - Solid Colors:

Apply 3 - 4 coats or until hiding is achieved. Extend each coat slightly beyond the previous and taper each coat, staying within the sanded area of the panel. The final coat should extend to the edge of the sanded area. Allow proper flash time between coats. Immediately after application of the final coat, lightly mist the blend area with Melt Away Edge Blender 6363. For larger blend areas, follow the instructions for metallic and pearl colors below.

Spot Repair - Metallic & Pearl:

Apply 1 - 2 coats of No Mix LV Basecoat Blender LV-500 to the prepared panels and allow a 15 minute flash time. Apply 3 - 4 coats or until hiding is achieved. Extend each coat slightly beyond the previous and taper each coat. Allow proper flash time between coats. Allow the Single Stage to flash 3 - 5 minutes and apply 1 coat of any* Transtar clearcoat over the remainder of the panel and extending 3 - 4 inches into the Single Stage.

Clearcoating:

No Mix Single Stage may be clearcoated to improve the gloss or if extensive sanding and polishing is required. Allow No Mix SS to flash 10 - 15 minutes before the application of clearcoat. Apply 1 - 2 coats of any* Transtar clearcoat allowing proper flash between coats.

* Use of MAX Clearcoat 7761-MTR/7764-MTR or Signature Series Speed Clearcoat 9451/9454 is not recommended. Always match the clearcoat activator and reducer speed to that used in the Single Stage.

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PRODUCT SPECIFICATIONS

Color: Various solid, metallic, pearl and xiralllic colors	Shelf Life: 1 year
RTS Solids by Weight: 25-44% depending on color	Activators: LV-224 (fast), LV-234 (medium), LV-244 (slow)

POLISHING

No Mix SS Urethane can be polished after 18 hours @ 75°F (23°C) or after a 1 hour cool down after force drying. For dirt removal, lightly nib sand with 1500 grit wet sandpaper and compound with Cutting Compound 5361/5364. Finish with Machine Polish 5374. For dark colors, use Swirl Remover 5384. It is best to compound within 24 hours of application.

REGULATORY

Cateogy: Single Stage

Ready to spray mixed single stage urethane has a regulatory VOC of less than 2.8#/gal (340 g/l). Refer to mixed paint can or the No Mix software for VOC information for each mixed color.