



No Mix Single Stage Urethane

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



Mix Ratio

3:1:1 - 1 part single stage to 1 part activator (LV-224/234/244) to 1 part reducer (LV-541/551 or LV-571/581)*

Pot life: 1.5-2 hours

* Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.



Suitable Substrates

- Primer - self-etching
- 1K primer
- 2K primer
- OEM finish & old paint work - non-reversible

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



Surface Prep & Application

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.

Application: 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 & Pearls: 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.

Additives

Kicker (6417) Can be used in temperatures BELOW 65°F (24°C) at 1/4 oz. per sprayable quart.

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 1/2 oz per sprayable quart.

Flex Additive (9194) Recommended when used on soft flexible substrates such as bumper & trim applications. May be used, refer to TDS for mixing recommendations.



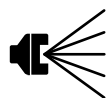
Flash Times/Dry Times

Flash between coats.....10-15 min
 To clearcoat.....10-15 min
 Delivery16-24 hrs @ 75°F (23°C)
 Force dry40 min @ 140°F (60°C)



Gun Set-up

Siphon feed.....1.3 - 1.6 mm Gravity feed..... 1.3 - 1.6 mm
 HVLP/LVLP1.3 - 1.6 mm



Air Pressure

Siphon feed (@ gun)25 - 35 psi Gravity feed (@ gun) 30 - 40 psi
 HVLP/LVLP (@ aircap).....10 psi



Product Specifications

Color.....Various solid, metallic, pearl and xirallic colors
 RTS solids by weight.....25-44% Shelf life 3 years
 ActivatorsLV-224 (fast), LV-234 (medium), LV-244 (slow)
 Activator size.....Quart
 * Refer to reducer TDS for product specifications on those items.



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

CategorySingle 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.

**Limitations & Precautions**

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

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. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. 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 Transtar Autobody Technologies, Inc. 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.