

NO MiX[®]

L O W V O C

REFINISH SYSTEM

TRANSTAR[®]
AUTOBODY TECHNOLOGIES, INC.

BENEFITS

- 175,000 color formulations
- High solids for superb coverage and reduced cycle times
- Superior metallic control
- Meets most stringent North American VOC regulations
- Nation-wide sales staff and technical representatives

No Mix High-Solids Basecoat from Transtar Autobody Technologies is the perfect option for anyone concerned with offering the highest-quality results that meet the nation's most stringent VOC regulations.

At Transtar, we know color match is everything and have made huge investments in our color formula development process and tools to ensure each and every project surpasses your expectations.

A total of 77 toners are available through the No Mix system that includes solids, metallics, pearls and xirallics that give you access to over 175,000 color formulations.

This unique system means you will reduce cycle times and save money by using fewer coats of paint because of No Mix's superior pigment distribution. And its composition eliminates the need for costly mixing banks. Just shake and pour!



No Mix Low VOC High-Solids Basecoat Instructions

The No Mix Low VOC High-Solids (HS) 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.

TECHNICAL DATA:

APPEARANCE: Various solid, metallic, pearl and xiralic colors

% SOLIDS: 25 - 44% by weight, solids of mixed colors will vary

SHELF LIFE: 1 year unopened

REDUCERS: Zero VOC Urethane Grade Reducer or Urethane Grade Reducer

MIX RATIO: 1:1½

POT LIFE: Unactivated - unlimited; Activated - 8 hours

SUITABLE SUBSTRATES:

No Mix MS can be applied to structurally sound surfaces that are sanded, degreased and properly prepared with Transtar primers.

SURFACE PREPARATION:

Finish sand with 500 - 600 grit dry or 600 - 800 grit wet. Prepare blend areas using 1200 - 1500 grit wet or dry, or 6338, Scuff and Prep Paste (TDS224) with a gray scuff pad. Thoroughly degrease.

MIXING:

Mix 1 part No Mix HS Basecoat to 1½ parts 6700-F Series Zero VOC Urethane Grade Reducer (TDS601) or 6700 Series Urethane Grade Reducer (TDS600) suitable to shop conditions and repair size. *Note: Adding reducer other than zero VOC reducer will increase V.O.C.*

For Lifetime Warranty, No Mix HS Low VOC Basecoat must be activated. Add ¼ oz of any 6800 Series Extra Solids Activator, any 7000 series Euro Clearcoat Activator or 9400 series Activator to 1 ready-to-spray quart of color.

Note: Recoat time of activated basecoat is 2 hours @ 77°F (25°C).

Note: For under hood, matt cladding and interior colors, activate the basecoat as above.

Apply 2 - 3 coats or until hiding is achieved. Allow a 5 - 10 minutes flash time between coats. (Flash times may vary due to shop temperature and reducer selection.)

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Conventional	1.2 - 1.4 mm	25 - 35 PSI max	n/a
HLVP	1.2 - 1.4 mm	10 PSI max	n/a
LVLP	1.2 - 1.4 mm	8 PSI max	n/a

APPLICATION:

FULL PANEL

Apply 2 - 3 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).

Dry Time: Allow 20 - 25 minute dry time before taping. Allow to dry 10 - 15 minutes before the application of clearcoat. (Dry times may vary due to shop temperature and reducer selection.) Allow 25 - 30 minutes before nib sanding.

SPOT REPAIR

1. Apply 1 - 2 coats of LV-500 Basecoat Blender to the prepared blend panels. Allow a 10 - 15 minutes flash before the application of basecoat. (Flash times may vary due to shop temperature and reducer selection.)

2. Apply 2 - 3 coats of basecoat to the repair areas or until hiding. Extend each coat slightly beyond the first and taper each coat. Allow proper flash time between coats.

3. Mix 2 parts of LV-500 Basecoat Blender with 1 part of ready to spray basecoat and apply 1 - 2 coats over the blend area.

APPLICATION (CONT.):

SPOT REPAIR (cont.)

Dry time: Allow 20 - 25 minute dry time before taping. Allow to dry 10 - 15 minutes before the application of clearcoat. (Dry times may vary due to shop temperature and reducer selection.)

3 STAGE/TRI-COAT

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

GROUND COAT APPLICATION

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

Dry time: Allow ground coat to dry 15 - 20 minutes before the application of the midcoat/pearlcoat. (Dry times may vary due to shop temperature and reducer selection.)

MIDCOAT APPLICATION

Follow the application instructions above for either full panel or spot repair. When performing a spot repair it is 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 coat to dry 20 - 30 minutes before the application of clearcoat. Failure to allow adequate dry time could result in solvent popping or wrinkling. (Dry times may vary due to shop temperature and reducer selection.)

REGULATORY:

Refer to mixed paint can or the No Mix software for VOC information for each mixed color.

TECHNICAL TIPS:

PERFORMANCE ADDITIVES

6417 Kicker (TDS700) – Do not use.

6487 Appearance Improver (TDS701) – Do not use.

6737 Fisheye Remover (TDS703) – Do not use.

9194 Universal Urethane Flex Additive (TDS711) – Do not use.

REDUCERS:

URETHANE GRADE REDUCER

Part Number	Size	Speed	Temperature
6701/6704/6705	Gallon/Quart/5 Gallon	Fast	60° - 70°F (16° - 20°C)
6711/6714/6715	Gallon/Quart/5 Gallon	Medium	65° - 80°F (18° - 26°C)
6721/6724/6725	Gallon/Quart/5 Gallon	Slow	75° - 90°F (24° - 32°C)

ZERO VOC URETHANE GRADE REDUCER

Part Number	Size	Speed	Temperature
6701-F/6704-F	Gallon/Quart	Fast	60° - 70°F (16° - 20°C)
6711-F/6714-F	Gallon/Quart	Medium	65° - 80°F (18° - 26°C)
6721-F/6724-F	Gallon/Quart	Slow	75° - 90°F (24° - 32°C)