

NORTHSTAR

928 Series 2.8 VOC Polyurethane Topcoat

DESCRIPTION

The 928 Series is a high solids 2.8 VOC polyurethane topcoat which offers outstanding chemical resistance and a premium gloss. This single stage paint system offers excellent coverage and color holdout with fast drying properties and easy application. 928 Series is compliant with all applicable air regulations including SCAQMD Rule 1151.

COMPONENTS

- | | |
|---------------------------|---------------------------------------|
| • 928 Series color | Base |
| • H8 | 2.8 VOC Activator |
| • H7 | 3.5 VOC Activator |
| • S9860/S9870/S9885/S9895 | Fast/Medium/Slow/Very Slow - Reducers |
| • S021 Fast/Medium/Slow | Low VOC Reducers |
| • S065/S075/S085 | Fast/Medium/Slow - Zero VOC Reducers |

MIXING RATIO

Mix three (3) parts 928 Series color with one (1) part selected activator. Reduce 25% – 50% with S9860/S9870/S9885/S9895 reducers for 3.5 VOC compliance. Reduce 25% - 50% with selected low/zero VOC reducer to maintain a 2.8 VOC. A566 accelerator may be used up to 1 ounce per gallon (optional). A544 pot life extender may be used up to 4 ounces per gallon. (optional)

POT LIFE at 77° F

1.5 hours (with no accelerator)

CLEAN UP

Use **NORTHSTAR** Lacquer Thinner or zero VOC solvents. (Check local regulations)

PHYSICAL DATA

Solids wt. (as mixed)	60% (average of colors)
VOC as mixed	2.8
Color	Fleet colors from SHS Tints

DRY / FLASH TIMES

Air Dry at 77° F

Flash between coats	10-20 minutes
Tape time	Overnight

Tack free	30 minutes
Dust free	45 minutes

Force Dry

Flash before force dry	15 minutes flash
Force dry time	40 minutes at 140° F

GUN SETUPS

Conventional

Gravity Feed	1.4 mm – 1.5 mm
Siphon Feed	1.4 mm – 1.5 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed	30 – 40 psi
Siphon Feed	35 – 45 psi
HVLP at cap	8 – 10 psi

SURFACE PREPARATION

Use **NORTHSTAR** Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.

APPLICATION

- Apply 2 medium wet coats over substrate
- Allow 10-15 minutes between coats
- Scuff after 24 hours before recoating
- Clean gun after spraying is completed

SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

NORTHSTAR COATINGS

Division of Lusid Technologies, Inc. • Salt Lake City, UT • Phone 877 973-7600 • Fax 801 966-6876