

NO MIX[®]

L O W V O C

REFINISH SYSTEM

TRANSTAR[®]
AUTOBODY TECHNOLOGIES, INC.

BENEFITS

- Easy to spray
- 70,000 color formulations
- Great metallic control
- Excellent gloss
- Ideal for auto repair, light commercial industries, and municipal vehicles

Are you looking for an economic solution that will save you time?

Transtar Autobody Technologies' No Mix Single Stage Urethane has superior metallic control, requires less effort in the booth, and has excellent vertical hang. Flow and leveling are easy to achieve, and the appearance is enhanced by its outstanding gloss.

Transtar's No Mix Single Stage has over 70,000 color formulations available in solid, metallic and pearl.

This is a great choice if you paint light, commercial vehicles, fleets such as taxi cabs and rental cars, municipal vehicles, trailers and more!

You will find mixed colors available through your local jobber.



No Mix Low VOC Single Stage Urethane Instructions

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

TECHNICAL DATA:

APPEARANCE: Various solid, metallic, pearl and xirallc colors

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

SHELF LIFE: 1 year unopened

ADDITIONAL COMPONENTS: LV-201 - Single Stage Converter, LV-224 - Fast Activator, LV-234 - Medium Activator, LV-244 - Slow Activator

REDUCERS: Zero VOC Urethane Grade Reducer or Urethane Grade Reducer

MIX RATIO: 3:1:1

POT LIFE: 1.5 - 2 hours

SUITABLE SUBSTRATES:

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

SURFACE PREPARATION:

Finish sand with 320 - 500 grit dry or 500 - 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. To optimize hiding, apply 6200 Series Kwik Seal (TDS211) or 9531, Signature Series 2.1 Low VOC Sealer (TDS231) before topcoating.

MIXING:

Shake mixed color well (6 - 8 minutes) before use.

Mix 3 parts No Mix Single Stage to 1 part Single Stage Activator to 1 part 6700-F Series Zero VOC Urethane Grade Reducer (TDS601) or 6700 Series Urethane Grade Reducer (TDS600).

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Conventional	1.3 - 1.6 mm	25-35 PSI max	n/a
HLVP	1.3 - 1.6 mm	10 PSI max	n/a
LVLP	1.3 - 1.6 mm	8 PSI max	n/a

APPLICATION:

FULL PANEL - 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 6363, Melt Away Edge Blender (TDS312). For larger blend areas, follow the instructions for metallic and pearl colors.

APPLICATION (CONT.):

SPOT REPAIR - METALLIC & PEARL

Apply 1 - 2 coats of LV-500, No Mix LV Basecoat Blender (TDS518) 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.

DRY TIME

Allow to dry 10 - 15 minutes before the application of clearcoat. Dry to sand and polish is 16 - 24 hours @ 75°F (23°C) or 40 minutes @ 140°F (60°C). (Dry times may vary due to shop temperature, activator and reducer selection.)

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 7761-MTR, MAX Clear (TDS517) or 9451, Signature Series Speed Clearcoat (TDS515) is not recommended.

Always match the clearcoat activator and reducer speed to that used in the Single Stage.

REGULATORY:

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

TECHNICAL TIPS:

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 5361, Cutting Compound (TDS404). Finish with 5374, Machine Polish (TDS405). For dark colors, use 5384, Swirl Remover (TDS406). It is best to compound within 24 hours of application.

PERFORMANCE ADDITIVES

6417 Kicker (TDS700) – Can be used in temperatures BELOW 65°F (24°C) at 1/4 oz. per sprayable quart.

6487 Appearance Improver (TDS701) – Can be used at a rate of 1 - 2 oz. per sprayable quart. DO NOT use Appearance Improver if Kicker is being used.

6737 Fisheye Remover (TDS703) – Can be used at a rate of 1/2 oz. per sprayable quart.

9194 Universal Urethane Flex Additive (TDS711) – Recommended when used on soft flexible substrates such as bumper & trim applications. May be used, refer to TDS for mixing recommendations.