

No Mix HS Basecoat

The No Mix HS Low VOC 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.



Mix Ratio

1:1½ - 1 part basecoat to 1½ part reducer*

Pot life: Unactivated - unlimited, Activated - 8 hours

Use of LV-418 is mandatory for formulas containing LV-29 and for Lifetime Warranty of No Mix HS. It is optional for all other HS formulations, but highly recommended to improve chip resistance and flexibility especially when applying tri-coats. For additional mixing instructions, refer to the Additives section on the next page.

Note: For underhood, matt cladding and interior colors, activate the basecoat by adding ½ fl. oz. of LV-418 No Mix Activator to the ready to spray quart of color.

* 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 400-600 grit wet or dry. Prepare blend areas using 800-1000 grit wet or dry or Scuff & Prep Paste 6338 with a gray scuff pad. Thoroughly degrease.

Application: Coats: Apply 2-3 medium wet coats. Allow 5-10 minute flash. Note: Flash times may vary due to shop temperature and reducer selection.

Film Build: 0.75 - 1.5 mils.

Full Panel Application: Apply 2-3 coats of until hiding is achieved, allow a 5-10 minute flash time between coats. Dry Time: Allow 20-25 minute dry time before taping. Allow to dry 10-15 minutes before the application of clearcoat. Allow 25-30 minutes before nib sanding.

Spot Repair: Apply 1-2 coats of Basecoat Blender LV-500 to the prepared blend area. Allow a 10-15 minute flash before application of basecoat. Apply 2-3 coats of basecoat to the repair areas or until hiding is achieved. Extend each coat slightly beyond the first and taper each coat. Allow proper flash time between coats. Mix 2 parts of LV-500 with 1 part of ready to spray basecoat and apply 1-2 coats over the blend area. Dry Time: Allow 20-25 minute dry time before taping. Allow to dry 10-15 minutes before the application of clearcoat.

3 Stage/Tri-Coat: A letdown panel should be created prior to application to aid in color matching.

Ground Coat Application: Follow application instructions above for either full panel or spot repair. Dry Time: Allow ground coat to dry 15-20 minutes before the application of midcoat/pearl coat.

Midcoat Application: Follow application instructions above for either full panel or spot repair. When performing a spot repair is it 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 to dry 20-30 minutes before the application of clearcoat. Failure to allow adequate dry time could result in solvent popping or wrinkling.

Additives

Kicker (6417) Do not use.

Appearance Improver (6487)..... Do not use.

Fisheye Remover (6737) Do not use.

Flex Additive (9194) Do not use.

No Mix Activator (LV-418) ...Add 1/2 fl. oz. per ready to spray quart



Flash Times/Dry Times

Flash between coats..... 5-10 min

Dry to tape..... 20-25 min

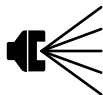
To clearcoat..... 10-15 min

Before nib sanding 25-30 min



Gun Set-up

Siphon feed.....	1.2 - 1.4 mm	Gravity feed.....	1.2 - 1.6 mm
HVLP/LVLP	1.2 - 1.4 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

Regulatory

Category Color coating

Ready to spray mixed basecoat has a regulatory VOC of less than 3.5#/gal (420 g/l) when reduced with 6700-F Series Zero VOC Urethane Grade Reducers. 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.