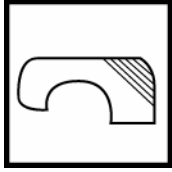




# 3.5 VOC Urethane Enamel



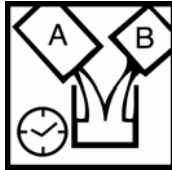
PRODUCT AT-A-GLANCE



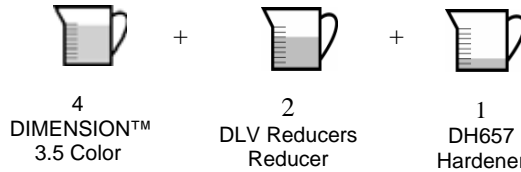
## SUITABLE SUBSTRATES

OEM Enamels  
Aged Refinishes

DIMENSION™ sealers and surfacers



## MIXING - COLOR



### Reducer Temperature Ranges

DLV643	60° - 75°F
DLV645	70° - 95°F
DLV648	90° - 100°F+

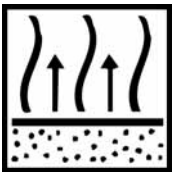
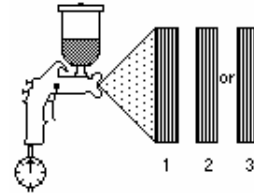
## MIXING – INTEGRATING CLEAR (OPTIONAL)

- Mix 2 parts of DM629 Mixing Clear to 1 part DH657 Hardener, then mix 1 part of the DM629/DH657 mixture to 4 parts ready to spray color.
- For additional durability, add 1 ounce of DA30 UV Additive per ready to spray quart of color.



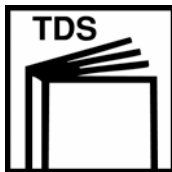
## APPLICATION

- Apply 2 medium wet coats or until hiding is achieved.
- Allow each coat to flash until hand slick.
- 10 psi HVLP  
40-45 psi conventional gravity feed  
10-12 fluid ounces per minute and 30-35 psi w/pressure pot



## DRYING SCHEDULE

Air dry	Out of Dust	40 minutes @ 70° F
	To Deliver	Overnight or 2 hours after force dry
Force Dry	30 minutes at 120° F surface temperature	
Buffing Times	Air Dry	After 24 hours
	Force Dry	30 minutes after cool down



## NOTES

- Pot Life: 2 hours at 75 °
- If fisheyes are a problem, add DA667 fisheye eliminator in the following amounts:
  - 2 - 6 capfuls per quart of **unreduced** color
  - 1 - 3 capfuls per quart of **ready to spray** color
  - 1 capful = 1/3 ounce or 9 grams



## PERSONAL PROTECTION

- For use by trained professionals only.
- Read label, directions, and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing and spraying.



# 3.5 VOC Urethane Enamel



## PRODUCT DESCRIPTION

DIMENSION™ PRO 3.5 Urethane Enamel is a low cost, single stage urethane enamel line with thousands of similar color matches to the vehicle's original color. PRO 3.5 offers improved hiding, improved metallic control, shorter bake times, as well as outstanding gloss holdout and Distinctness Of Image (DOI). DIMENSION™ PRO 3.5 Urethane Enamel meets 3.5 VOC requirements and is designed for overall refinishing. PRO 3.5 will use an intermix prefix of "D3".

## APPLICATION TECHNIQUES

Adjust air pressure to 10 psi cap pressure for HVLP, 40 - 45 psi for conventional gravity feed, and 10 - 12 fluid ounces per minute and 30-35 psi inlet atomizing pressure with a pressure pot. Apply 2 medium wet coats or until hiding is achieved with a 50% overlap allowing each coat to become handslick before the next coat. Apply at a gun distance of 6-8 inches. A cross-coat method (horizontal one coat, vertical the next) can be used for metallic colors to make them more uniform. If further metallic orientation is needed, immediately apply a mist coat by increasing the gun distance to 10-12 inches or reducing air pressure. Recommended dry film thickness is 2.0 - 2.5 mils. For additional depth and gloss the integrating clear option can be used in the last coat.

## BUFFING

If necessary, after 24 hours air dry, or 30 minute force dry, sand with 2000 grit sandpaper followed by cross-sanding with 3000 grit sandpaper, checking frequently to ensure that the 2000 scratches are being removed. Take care in sanding and polishing single-stage metallics. Aggressive sanding can distort metallic appearance. Sanding should be limited to de-nibbing imperfections. Buff by machine with polishing pad, using a quality microfinishing compound, and follow with a microfinishing glaze. For ultimate appearance, hand glaze with a soft clean cloth. Buffing is easiest when done within the first 48 hours following application.

## REGULATORY DATA

	As Packaged		As Applied	
	G/L	Lbs/Gal	G/L	Lbs/Gal
VOC Total	356	2.97	253	2.11
VOC Less Exempt	444	3.71	422	3.52
	Lbs/Gal Solids	Lbs/Lbs Solids	Lbs/Gal Solids	Lbs/Lbs Solids
HAPs	4.19	0.42	3.06	0.31
	Wt. %	Vol. %	Wt. %	Vol. %
Volatiles	53.9	61.2	64.7	69.2
Water	NA	NA	NA	NA
Exempt Compounds	17.7	19.8	39.6	39.8
	G/L	Lbs/Gal	G/L	Lbs/Gal
Density	984	8.22	1015	8.47