# 3.5 VOC H.S. URETHANE ENAMEL

## TECHNICAL DATA SHEET

### DESCRIPTION

DIMENSION™ Low VOC H.S. Urethane Enamel is a low cost alternative high solids urethane enamel line with thousands of similar color matches to the original vehicle's color. DIMENSION™ Low VOC H.S. Urethane Enamel is primarily an overall refinish line.

### PHYSICAL DATA

| | | | |
|---|---|---|---|
| Pot Life at 70°F: | 2 hours | **DA666** Fisheye Eliminator | ¼ to 1 oz/RTS qt. |
| VOC Ready to Spray: | <3.5 lbs/gal | **DA664** Retarder | 1 capful/RTS qt. |

### SUBSTRATES

Properly prepared and cleaned OE painted surfaces and Western® sealers and surfacers.

### MIXING WITH STANDARD REDUCERS

| **5** DIMENSION™ Color | + | **1** DIMENSION™ Reducer | + | **1** DH653/DH655 Hardener |
|---|---|---|---|---|

Reducer Selection Chart

| | |
|---|---|
| DR631 | 50°-65°F |
| DR632 | 60°-75°F |
| DR633 | 70°-80°F |
| DR634 | 75°-90°F |
| DR635 | 85°F and above |
| DR636* | 100°F and above |

*DR636 is formulated for use in extreme tropical and desert conditions.

**NOTE**: Ranges based on single panel. For spot repairs, move one solvent faster. For multiple panels move one solvent slower.

### APPLICATION

1. Apply 2-3 coats to hiding.
2. Apply a mist coat to even out metallics.
3. 10-15 minutes flash between coats.

| | |
|---|---|
| HVLP | 8 - 10 psi |
| Siphon Feed | 50 - 60 psi |

### DRYING

| **Air Dry Times at 70°F** | **DH653** | **DH655** |
|---|---|---|
| Dust Free | 80 minutes | 60 Minutes |
| Tape Free | 12 hours | 12 hours |
| To Deliver | Overnight or 4 hours after force dry | |

**Force Dry at 140°F** 30 minutes

No recommendation to apply clearcoat at this time.

### BUFFING

If necessary, after 24 hours air dry, sand with 1500 or finer grit paper and buff with the appropriate compound. Buffing is easiest when done within the first 48 hours following application. Take care in sanding and polishing single-stage metallics. Aggressive sanding can distort metal appearance. Sanding should be limited to de-nibbing imperfections with 2000 to 2500 grit sandpaper.

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