



## PRODUCTION SHOP TECHNICAL DATA SHEET



### DESCRIPTION

DIMENSION™ Low VOC Alkyd Enamel is a low cost alternative alkyd enamel line with thousands of similar color matches to the original vehicle's color. DIMENSION™ Low VOC Alkyd Enamel is primarily an overall refinish line.

### PHYSICAL DATA

Pot Life at 70°F:	4 hours	<b>DA666</b> Fisheye Eliminator	¼ to 1 oz/RTS qt.
VOC Ready to Spray:	3.5 lbs/gal	<b>DA664</b> Retarder	1 capful/RTS qt.



### SUBSTRATES

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



### MIXING



#### Reducer Selection Chart

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

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

### 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 |

**NOTE:** Ranges based on overall painting. For spot/panel repairs, move one solvent faster.



### DRYING

#### **Air Dry Times at 70°F**

Dust Free	80 minutes
Tape Free	Overnight
To Deliver	Overnight or 12 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.

