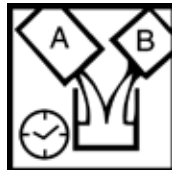




SUITABLE SUBSTRATES

- OEM Enamels
- Aged Refinishes
- Dimension® Undercoats



MIXING



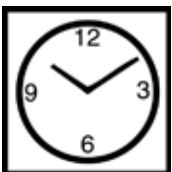
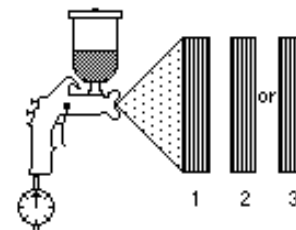
REDUCER SELECTION CHART	
DIR646 Medium	55°F-85°F
DIR648 Slow	85°F-95°F
DIR650 Very Slow	95°F & Up

***NOTE: Consider size of repair, air flow and spray conditions with reducer selection**



APPLICATION

- Apply 2-3 medium coats or until hiding is achieved
- Allow each coat to flash 10-15 minutes
- 8-10 psi at air cap - HVLP
- 22-24 psi inlet - compliant spray gun
- 10-12 fluid ounces per minute and 30-35 psi - pressure pot
- See page 2 for application techniques

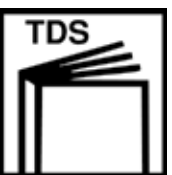


RECOAT

- May be recoated with itself up to 24 hours, must be scuffed or sanded after 24 hours.

NOTES

- Pot Life: 4 hours at 75°F
- If a mist coat is needed, apply immediately following last coat while increasing gun distance an additional 2" – 4"
- To achieve different gloss levels add DIMENSION® Flattener DA668, for more information please refer to product data sheet W10422
- If fisheyes are a problem, add DIMENSION® fisheye eliminator DA667 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, product data sheet, and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing and spraying.



DIMENSION®
NATIONAL RULE ALKYD ENAMEL
PRODUCTION SHOP
SINGLE STAGE
INTERMIX COLOR: 5E

PRODUCT DESCRIPTION:

DIMENSION® National Rule Alkyd Enamel Production Shop Single Stage is a cost effective alternative alkyd enamel capable of producing thousands of colors capable of matching a vehicle's original color; and is designed for overall refinishing. This product Stage meets National Rule requirements and uses the intermix prefix of "5E".

SURFACE PREPARATION:

1. Clean with appropriate Sherwin-Williams® surface cleaner* and wipe dry with a clean cloth.
2. Treat sand-throughs to bare metal with DIMENSION® LCF Etch Primer DE830.
3. When sealing, final sand repair area with P320 – P400 grit sandpaper. If directly top coating over primer, final sand with P400 – P600 grit sandpaper.

**Note: check local regulations regarding the use of solvent cleaners.*

APPLICATION TECHNIQUES

Apply 2 medium wet coats or apply 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 help achieve uniform metallic orientation. 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.

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 scratches made with the 2000 grit sandpaper 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.

DRYING SCHEDULE:

Air dry	Out of Dust	50 minutes @ 75° F
	To Deliver	Overnight or 8 hours after force dry
Force Dry	30 minutes at 140° F surface temperature	
Buffing Times	Air Dry	After 24 hours
	Force Dry	30 minutes after cool down

REGULATORY DATA

	<u>As Packaged</u>		<u>As Applied</u>	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	7.98	956	7.74	927
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	63.4	72.6	72.2	79.2
Water	0.0	0.0	0.0	0.0
Exempt Compounds	4.6	5.5	6.9	8.2
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	4.69	562	5.05	605
VOC Less Exempt	4.97	595	5.50	659
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	2.22	0.266	1.71	0.205