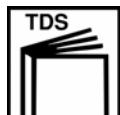




5.0 VOC ACRYLIC ENAMEL



PRODUCTION SHOP TECHNICAL DATA SHEET

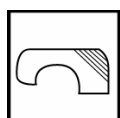


DESCRIPTION

DIMENSION™ National Rule Compliant Acrylic Enamel is a low cost alternative acrylic enamel line with thousands of similar color matches to the original vehicle's color. DIMENSION™ National Rule Compliant Acrylic Enamel is primarily an overall refinish line.

PHYSICAL DATA

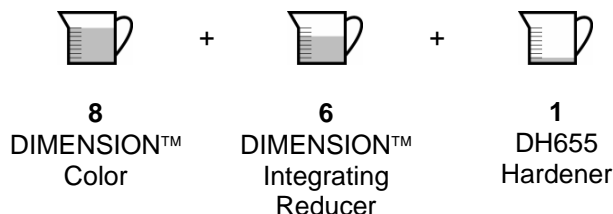
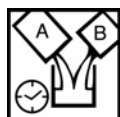
Pot Life: 2 hours **DA666** Fisheye Eliminator ¼ to 1 oz/RTS qt.
VOC Ready to Spray: 5.0 lbs/gal **DA664** Retarder 1 capful/RTS qt.



SUBSTRATES

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

MIXING



Reducer Selection Chart

DIR644	55°-70°F
DIR646	70°-85°F
DIR648	85°-95°F
DIR650	95°F and above

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

Drier Selection Chart

DA609C	< 60° F
DA609	≥ 60° F

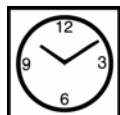
NOTE: Ranges based on metal temperature of panel. DA609C may also be used for lower bake temperatures.

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

Dust Free	40 minutes
Tape Free	6 hours
To Deliver	Overnight or 3hours after force dry

Force Dry at 140°F 30 minutes

BUFFING



If necessary, sand with 1500 or finer grit paper after 24 hours and polish. Buff with the appropriate compound after 48 hours. Buffing is easiest when done within the first 72 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.