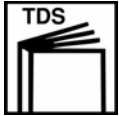




2.8 VOC HS URETHANE ENAMEL



TECHNICAL DATA SHEET



DESCRIPTION

DIMENSION™ 2.8 VOC H.S. Urethane Enamel is a low cost alternative high solids urethane enamel line with thousands of similar solid color matches to the original vehicle's color. DIMENSION™ 2.8 VOC H.S. Urethane Enamel is primarily an overall refinish line.

PHYSICAL DATA

Pot Life at 70°F: 1 hour **DA666** Fisheye Eliminator ¼ to 1 oz/RTS qt.
VOC Ready to Spray: <2.8 lbs/gal **DA664** Retarder 1 capful/RTS qt.



SUBSTRATES

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

MIXING



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.

*Use DH655 for faster out-of-dust times or on smaller units where edge melt-in is not a factor. DH653 will provide a longer wet-edge for melt-in properties and should be used when painting larger areas.

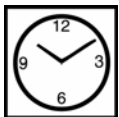
NOTE: Ranges based on single panel. For spot repairs, move one solvent faster. For multiple panels move one solvent slower.

APPLICATION



- Apply 2-3 coats to hiding.
 - 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	Overnight or 4 hours after force dry
Force Dry at 140°F	45 minutes	45 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.