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# TECHNICAL DATA SHEET

## 928FL3 SERIES SEMI GLOSS BINDER

05252021



NorthStar's 928FL3-series is the tried and proven success of High Solids technology. 928FL3 offers outstanding semi-gloss appearance, chemical resistance, and long lasting durability. 928FL3 is a single stage paint system utilizing the Northstar SHS toner system. The 928FL3 provides outstanding coverage and film build as when desired



### COMPONENTS

- 928FL3 Series
- H8 (2.8 VOC) Activator
- H7 (3.5 VOC) Activator
- S9870/S9885/S9895 Reducer
- \* With H8 3.5 VOC, With H7 4.2 VOC
- S021 Fast Zero VOC Reducers
- S065/075/085 Zero VOC Reducers
- A544 Pot Life Extender



### MIXING RATIO

Mix Three (3)parts 928FL3 Series to One (1) Part Selected

#### Activator.

- For Brush or Roller, reduce 10% with selected reducer.
- For Air assisted airless & pressure pot, reduce 15-25% with selected reducer
- For HLPV reduce 25-50% with selected reducer



### POT LIFE

1.5 hours @ 77° F/25° C



### CLEAN UP

Use NORTHSTAR Lacquer Thinner or zero VOC solvents. (Check local regulation)



### PHYSICAL DATA

Solids wt. (as mixed) 60% (average)  
Solids by Volume 53% (average)  
Gloss (60° angle) 90+



### DRY / FLASH TIMES

Air Dry at 77° F/25°C



### GUN SETUPS

#### Conventional

Gravity Feed 1.5 mm – 1.8 mm  
Siphon Feed 1.5 mm – 1.8 mm

#### AIR PRESSURES

#### Conventional at Gun

Gravity Feed 35-45 psi  
Siphon Feed 40-50 psi  
HVLV at cap 8 – 10 psi



### SURFACE PREPARATION

Use NORTHSTAR Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.



### APPLICATION AT 77° F/25°C

- Apply medium wet coats over substrate to desired film thickness
- Allow 10-15 minutes between coats.

• DO NOT APPLY IF THE SURFACE TEMPERATURE OF THE OBJECT IS BELLOW 55° (12.7°C) OR ABOVE 110°f (48° C)

### COMPATIBILITY WITH OTHER COATINGS:

928 Series may applied over the fsuitable Lusid Northstar Primers & Sealers.



### SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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