

SC280

2.1 VOC Automotive Satin Clear

09142016

DESCRIPTION

SC280 is a premium automotive 2.1 VOC satin finish clear which is required in certain applications, such as the sign industry and other OEM applications requiring a 35° gloss rating.

COMPONENTS

- SC280 Clearcoat
- H05 Zero VOC Activator

MIXING RATIO

Mix three (3) parts SC280 clear with one (1) part H05 or H5 activator. Product is then ready to spray.

POT LIFE AT 77° F

2 hours (without accelerator)

CLEAN UP

Use NORTHSTAR Lacquer thinner or zero VOC solvents. (Check local regulations)

PHYSICAL DATA

Solids wt. (as mixed)	41%
VOC as mixed	2.1
Gloss ratio	35%

DRY / FLASH TIMES

Air Dry at 77° F

Flash between coats	10-15 minutes
Dust free	30 minutes
Tack free	60 minutes

Force Dry

Flash before force dry	15 minutes flash
Force dry time	40 minutes at 140° F

COLOR SANDING

Not recommended

GUN SETUPS

Conventional

Gravity Feed

1.3 mm – 1.4 mm

Siphon Feed

1.3 mm – 1.4 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed

30 – 40 psi

Siphon Feed

35 – 45 psi

HVLP at cap

8 – 10 psi

SURFACE PREPARATION

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

APPLICATION

- Apply 2 medium wet coats over substrate to desired film thickness
- Allow 10-15 minutes between coats
- Scuff after 24 hours before recoating
- Clean gun after spraying is completed

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.