

# NO MIX<sup>®</sup>

Low V.O.C.

## A unique basecoat that will save you time & money!

- Meets most stringent North American VOC regulations [3.5 #/gal (420 g/l) or less]
  - Over 175,000 color formulations
  - Full range of alternate formulas
- Increased productivity and reduced cycle times
  - Most colors are 2-3 coats to hiding
- Superior pigment distribution that eliminates mottling
- Mixed colors available through your local jobber



# TRANSTAR<sup>®</sup>

AUTOBODY TECHNOLOGIES, INC.

2040 Heiserman Drive  
Brighton, MI 48114  
(tel) : (800) 824-2843  
(fax): (800) 477-7923  
[www.tat-co.com](http://www.tat-co.com)

## No Mix Low VOC Basecoat Instructions

The No Mix Low VOC Basecoat System is a high performance basecoat system that exhibits exceptional hiding, metallic and pearl control, which increases productivity, improves color match and reduces cycle times.

### Technical Data:

Appearance: Various solid, metallic, pearl and xirallc colors

Shelf Life: 1 year unopened

Reducers: 6700-F Series Zero VOC Urethane Grade Reducers

Mix Ratio: 1:1½

Pot Life: Unactivated - unlimited; Activated - 8 hours

VOC: Regulatory: 3.38#/gal (405 g/l) Actual: 1.55#/gal (186 g/l)

### Suitable Substrates:

No Mix Low VOC may be applied to sound existing surfaces that have been sanded and degreased or to surfaces properly prepared with Transtar primer.

### Surface Preparation:

Finish sand with 500-600 grit dry or 600-800 grit wet. Prepare blend areas using 1200-1500 grit wet or dry, or 6338 Scuff and Prep Paste with a gray scuff pad. Thoroughly degrease.

### Mixing:

Mix 1 part No Mix Low VOC Basecoat to 1½ part 6700-F series Zero VOC Urethane Grade Reducer suitable to shop conditions and repair size. For Lifetime Warranty No Mix Low VOC Basecoat must be activated. Add ¼ oz of any Transtar branded clearcoat activator to 1 ready to spray quart of color.

*Note: Recoat time of activated basecoat is 2 hours @ 77°F (25°C).*

*Note: For underhood, matte cladding and interior colors, activate the basecoat as above.*

### Gun Set Up:

Gun Type	Fluid Tip	Air Pressure	Fluid Pressure
Conventional	1.2 - 1.4 mm	25 - 35 PSI (@ gun)	n/a
HVLP	1.2 - 1.4 mm	10 PSI max. (@ aircap)	n/a
LVLP	1.2 - 1.4 mm	8 PSI max. (@ aircap)	n/a

### Application:

**Full Panel** - Apply 2 - 3 coats or until hiding is achieved. Allow a 5-10 minutes flash time between coats. (Flash times may vary due to shop temperature and reducer selection.) Allow No Mix Low VOC Basecoat to dry 10-15 minutes before the application of clearcoat. (Dry times may vary due to shop temperature and reducer selection.)

**Spot Repair** - Apply 1 - 2 coats of LV-500 to the prepared blend panels allow a 10 - 15 minutes flash before the application of basecoat. (Flash times may vary due to shop temperature and reducer selection.) Apply 2 - 3 coats of basecoat to the repair areas or until hiding. Extend each coat slightly beyond the first and taper each coat. Allow proper flash time between coats. Mix 2 parts of LV-500 with 1 part of ready to spray basecoat and apply 1 - 2 coats over the blend area. Allow NO MIX Low VOC Basecoat to dry 10 - 15 minutes before the application of clearcoat. (Dry times may vary due to shop temperature and reducer selection.)

**3 Stage/Tri-Coat** - A let down panel should be created prior to application to aid in color matching.

**Ground Coat Application** - Follow the application instructions above for either full panel or spot repair. Allow ground coat to dry 15 - 20 minutes before the application of the midcoat/pearlcoat. (Dry times may vary due to shop temperature and reducer selection.)

**Midcoat Application** - Follow the application instructions above for either full panel or spot repair. When performing a spot repair it is critical to keep the midcoat application within the ground coat application in order to produce an invisible repair. Allow midcoat coat to dry 20 - 30 minutes before the application of clearcoat. Failure to allow adequate dry time could result in solvent popping or wrinkling. (Dry times may vary due to shop temperature and reducer selection.)

### Fisheye Remover/Kicker:

Do not use Fisheye Remover or Kicker with No Mix Low VOC Basecoat.

## No Mix Low VOC Basecoat Blender

### Instructions

LV-500 Basecoat Blender is designed to aid in the blending of No Mix Low VOC metallic, pearl and tri-coat colors. LV-500 can also be used as a fast drying cut-in clear and an inter-coat clear for tape outs of two tones and multi-color graphics. No Mix Low VOC Basecoat Blender is UV stable and ready to spray.

### Technical Data:

Appearance: Water white clear

% Solids: 11%

Density: 8.09 #/gal

VOC: Regulatory: 4.5 #/gal (540 g/l) Actual: 1.22 #/gal (147 g/l)

### Surface Preparation:

Please refer to No Mix Low VOC Basecoat Data Sheet for surface preparation instructions.

### Application and Mixing:

**Blending** - Apply 1 - 2 coats of LV-500 to the prepared blend panels and allow a 10 - 15 minutes flash before the application of basecoat. Apply 2-3 coats of basecoat to the replacement panels/ repair areas or until hiding. Extend each coat slightly beyond the first and taper each coat. Allow proper flash time between coats. Refer to No Mix Low VOC Basecoat Data Sheet for specific reduction and application instructions. Mix 2 parts of LV-500 with 1 part of ready to spray basecoat and apply 1 - 2 coats over the blend area. Allow 10 - 15 flash time and apply desired Transtar clearcoat.

**Inter-coat Clear** - If necessary follow the instructions above. Allow color to flash 10 - 15 minutes. Apply 1 - 2 coats of LV-500 to the entire panel and allow a 15 - 20 minute dry time before applying masking tape for two-tone or graphics.

**Cut-in Clear** - Allow color to flash 10 - 15 minutes. Apply 2 - 3 coats of LV-500. Allow 15 - 20 minutes before handling/assembly. To increase gloss additional coats of LV-500 may be applied up to a maximum of 6 coats.

### Reducer Selector:

Part Number	Size	Speed	Temperature
6701-F	Gallon	Fast	60° - 70°F (16° - 21°C)
6704-F	Quart	Fast	60° - 70°F (16° - 21°C)
6711-F	Gallon	Medium	65° - 80°F (18° - 26°C)
6714-F	Quart	Medium	65° - 80°F (18° - 26°C)
6721-F	Gallon	Slow	75° - 90°F (24° - 32°C)
6724-F	Quart	Slow	75° - 90°F (24° - 32°C)

## Distributed By:



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