**TECHNICAL DATA SHEET**

****** 06052014

***NORTHSTAR***

**MP Series Aircraft and Marine Polyurethane Topcoat**

# DESCRIPTION

The MP Series is a premium, high solids polyester polyurethane that offers outstanding chemical resistance, gloss retention, and long lasting durability. This single stage paint system offers excellent coverage and color holdout in marine applications like yachts as well as light aircraft. The MP Series works well on fleet and large vehicle refinishing and is ideal for manufacturers. MP is compliant with most known applicable air regulations when the proper activator and reducers are used.

# COMPONENTS

**To Mix the Color:**

Add SHS Tints according to the Northstar Formula; (50%-60% Tint Load)

Add MPB, MPBS, or 777 Binder at (40%-50% Binder Load)

Then Mix completed formula as directed by the mixing instructions below.

* MP Series color Base component
* H5 3.5 VOC Activator
* H05 2.8 VOC Activator
* HLX 3.5 VOC Activator
* S021/Fast/Medium/Slow Low VOC Reducers
* S065/S075/S085 Fast/Medium/Slow - Zero VOC Reducers
* MPS20 Preferred standard reducer
* S9860/S9870/S9885/S9895 Fast/Medium/Slow/Very Slow - Reducers
* A566 Accelerator (optional) ¼ ounce per quart
* A544 Pot life extender (optional)

# MIXING RATIO

Mix one (1) part MP Series color with one (1) part selected activator. MP Series may be reduced 10-20% by volume prior to application with selected reducer.

# POT LIFE at 77° F

2-hour minimum (without accelerator)

# CLEAN UP

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

# PHYSICAL DATA

Solids wt. (as mixed) 55% (average of colors)

VOC as mixed 3.5 (2.8 with H05)

Color Fleet colorsDRY / FLASH TIMES

## Air Dry at 77*°*F

Flash between coats 20-40 minutes

Tack free 1 hour

Dust free 2 hours

Tape Time 24-48 hours

# GUN SETUPS

## CONVENTIONAL

Gravity Feed 1.4 mm – 1.6 mm

Siphon Feed 1.4 mm – 1.8 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
* MP may be reduced 10-20%
* Allow 20-40 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.

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