

Product Description Pro-Spray® Single Stage (National Rule) is a high gloss and durable topcoat system. Colors utilize the current Pro-Spray intermix system to provide a full range of solid and metallic colors that can be mixed in normal, medium and high coverage options. Thousands of formulas are available on the Pro-Spray color retrieval software.

Components



Basecoat
Activators
Thinners

Mixed Single Stage Color
ICA Series 799–803
ICR Series 1692–1695

Typical Substrates

- Pro-Spray 2K sealers
- Pro-Spray 2K primers
- Properly prepared OE finishes
- DTM primers
- Epoxy primers

Surface Preparation



Finish sand with P400–P600. Clean area with ICR-1402™ or ICR-0014™ wipe and dry thoroughly. Use of Pro-Spray 2K sealer is recommended.

Mix Ratio

Color 3 Parts
Activator 1 Part
Thinner 1 Part



Pot Life @ 72°F / 22.2°C



2 hours

Viscosity @ 72°F / 22.2°C

15–17 secs DIN4

Gun Set Up



High Efficiency 1.2mm–1.4mm
HVLP 1.2mm–1.4mm

Air Pressure



High Efficiency 15–29psi @ the gun
HVLP 6–10 psi max @ the cap

NOTE: Refer to individual gun manufacturer for proper spray gun setting.

Application



- 2–3 medium wet coats.
- 5–10 minutes flash between coats.
- Use of drop coats on metallics is acceptable.
- Use of slow activator and slow thinner is recommended for best appearance.

Dry Times @ 72°F / 22.2°C



Flash 5–10 minutes between coats
Air Dry 6 hours–overnight
Baking 20 minutes @ 140°F/60°C
Short Wave Refer to the infrared manufacturer's guide for set-up regulations

Single Stage (National Rule)

Polishing / Buffing



Buffing is normally not required since single stage colors have a high gloss finish. However, on solid colors only you may sand with 1500 grit or finer and polish as needed after the finish has fully cured (overnight).

Special Notes / Clean Up



Note Use slow activator and thinner for best results.

Clean Up Clean equipment after use with a cleaning solvent. Dispose of solvent according to state, local and federal regulations.

Physical Data

VOC (RTS) per U.S. Gal	4.6 lbs (maximum)
Recommended Dry Film Thickness	2.0–3.0 mils
Total Solids by Weight (RTS)	51.7%
Coverage - Sq. Ft./100 ml (RTS)	5.19

Health and Safety



For professional use only. KEEP OUT OF REACH OF CHILDREN. WARNING! CONTENTS ARE FLAMMABLE. VAPOR AND SPRAY MIST IS HARMFUL. SKIN AND EYE IRRITANT.

Do not handle the Pro-Spray products until the Material Safety Data Sheets have been read and understood in their entirety. Ensure that all employees are trained on Material Safety Data Sheets and all chemicals with which they come into contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist. Wear protective clothing, gloves and eye safety with a side shield.

This data sheet information is given in good faith but without warranty. The information contained herein represents the current state of our knowledge and is intended as a guide to our products and their uses; it is not intended for insurance of certain product properties or of their specific applications.

Follow all warnings on product labels.