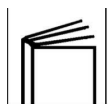


www.orionautomotivefinishes.com

Orion Automotive Finishes Acrylic Urethane Basecoat

Orion Base Technical Data Sheet

Description: Orion Basecoat is a 1:1 mix ratio with our universal urethane grade reducer. Orion's high-performance automotive base has a wide range of colors across the entire color spectrum; they are supremely clean and high intensity colors. Orion's paint universe spans O.E.M (domestic & import), as well as your custom paint needs.



Orion
Automotive Finishes

Substrate:

- Properly Prepared Orion Epoxy or DTM 2k Primer
- Orion Basecoats
- Properly cured and prepared OEM Finishes

Compatible surfaces:

- Clean, sanded O.E.M topcoats
- Orion Epoxy Primer
- Orion 2K DTM Primer
- Orion Adhesion Promoter
- Orion Intercoat Clear

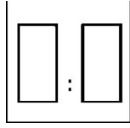
Orion Universal Reducer

- 594-60 Cool Temperature (60 – 70°F)
- 594-70 Medium Temperature (65 – 80°F)
- 594-80 Warm Temperature (75 – 90°F and above)

Orion Tip: OH-57 must be used to catalyze entire basecoat film when applied in multi-layer applications (Example: OEM Tri-coat or multi-color)

3. POT LIFE @ 77°F (25°C)

- Sprayable up to 2 hours with OH-57



SURFACE PREPARATION:
Mix Ratio:

- 1 parts Orion Basecoat
- 1 part Orion Universal Urethane grade reducer

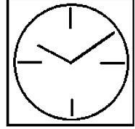
When sealing, final sand repair area with P400-P800 grit sandpaper. If directly top coating over primer, final sand with P600-P800 sandpaper. Sanding can be done either wet or dry.

1. Solvent clean with appropriate Orion Automotive Finishes surface cleaner and wipe dry with a clean cloth.
2. Treat sand-throughs to bare metal with an appropriate Orion epoxy, or DTM primer.

Preparation for Blending Panels (Prior to Basecoat Application):

1. Solvent clean with appropriate Orion Automotive Finishes surface cleaner and wipe dry with a clean lint free cloth.
2. Blend panel should be sanded with P800-P1000 grit sand paper on a random orbital sander or with Any brand scuffing paste, and water using a gray nylon-scuffing pad. Rinse surface thoroughly and wipe dry with a clean dry cloth.
3. Repeat step one - then thoroughly tack the surface to be painted with a clean tack cloth.

TECHNICAL DATA



Color: Any Orion Base

Mixing Ratio: 1:1

Viscosity #2 Zahn (RTS):n 15-18 seconds

Film Build: .04 on average (number of coats vary)

Pot Life: None, mix thoroughly

Coverage (Depending on color): 144-225 sq. ft.

Tack Free: 10 minutes

Tape Time: 20-40 minutes, varies on temps

V.O.C. (RTS) 6.0 - 6.6 lbs/gal

Disposal/Safety: SDS for this product

Striping or Two Toning:

70°F and 50% relative humidity. All striping, two toning and clear-coating must be completed within 24 hours. If allowed to dry for more than 24 hours, Orion Basecoat must be sanded and reapplied. You also may use Orion's Adhesion promoter to bring back your missed adhesion window. Eliminating the required sanding.

Gun Setups by some of the top manufacturers..

See manufacturer's suggestions. Here is some info that many painters typically use. Remember all guns spray in the specific way they were designed.

Iwata Supernova: 1.3 or 1.4, fluid open, trigger pull full, 1 turn in on fan, 26 psi

Iwata WS400 evo: 1.3hd fluid open, trigger pull full, 1 turn in on fan, 30 psi

Iwata LPH 400: 1.3 or 1.4 fluid open, trigger pull full, 1 turn in on fan, 20 psi (this is an lvp gun recommended by the manufacturer to be no higher than 19 psi but the extra pressure helps atomize the clear for a smoother finish)

Sata RP 4000/5000: 1.3 or 1.4 fluid open, trigger pull full, fan open, 28-30 psi

Sata 4000/5000 hvlp: 1.3 or 1.4 fluid open, trigger pull full, fan open, 29-32 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE10 fluid open, trigger pull full 28 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE20 24-26 psi
Harbor Freight Purple: 1.3 or 1.4 fluid open, 35-40 PSI
Harbor Freight Black Widow: 1.3 HTE model fluid open, 26-29 PSI



At Orion Automotive Finishes, we recommend using CSI polish system over other brands of compounds. This offers quick results for any level of experience.

CSI tech sheet for Ceram-X 62-203

Advantages

Water based - easy clean up.

Anti static - dust blows off.

One product design - no need to use any other product.

1. Apply Ceram-X directly to wool pad 62-309
2. Using 1000 rpm apply a small amount of pressure to the surface and turn the buffer on.
3. Increase RPM up to 1500.
4. Remove all color sanding scratches.
5. Check your work before going to red foam pad 62-312.
6. Notice the surface should have great color definition compared to any previous compounds. All scratches should be gone.
7. Apply Ceram-X directly to red foam pad 62-312
8. Using 800 rpm apply a small amount of pressure and buff area, increase to no more than 1000rpm.
9. Surface should be swirl free.
10. If a small swirl still exists, use a small amount of product and rebuff with a red foam pad.

Watch this Video PRIOR to use!

<https://m.youtube.com/watch?v=OHnm2gA2x5k>

SAFETY: To prevent accidents recommended to use: mask with organic vapor cartridge, safety glasses, latex gloves, work clothes. It is very important that it is applied in a ventilated place.

IMPORTANT: The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION CALL INFOTRAC 1- 800-535-5353

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Orion Automotive Finishes warrant freedom from patent infringement in the use of any formula or process set forth herein.

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