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***From the Stars to your Cars***

Technical Data Sheet

## **Orion Single Stage Color**

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### **Product Description and Purpose**

Orion Single Stage is a high performance single stage urethane finish. Designed to provide painters with easy application, adjustability, and superior gloss.

### **Quick Start Guide**

Product: **Orion Single Stage Color**

Mix Ratio:           4 Parts           Orion Single Stage Color  
                          1 Part           High Performance Hardener    11-10  
                          1 Part           Orion Urethane Reducer 594-UR60, 70, or 80

Number of layers:           2-3 Coats to achieve hiding and gloss

Items Needed:           Orion Single Stage Color, High Performance Hardener,  
                                  and Orion Urethane Reducers UR60, UR70, or UR80

### **Acceptable Substrates**

Orion Brand Primers, Surfacer, and Sealers.

Orion Basecoat solid, metallic, and pearl colors, Single Stage Colors, Custom mixed Orion Base Colors, and OEM Finishes

## Substrate Preparation

All surfaces shall be cleaned prior to performing sanding or spraying activity.

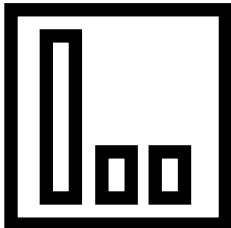
594-30 Wax and Grease Remover

Orion Brand Undercoats Sand with P320-P400 Dry P600-P800 Wet

Orion Base Colors should be completely flash dried, approx 20-30 minutes

OEM Finishes: Sand with P320-P400 Dry P600-P800 Wet

## Mixing Ratios and Optional



4 Parts	Orion Single Stage Color
1 Part	High Performance Hardener 11-10
1 Part	Orion Urethane Reducers 594-UR60, 70, or 80

## Application

2-3 Single coats. A color sprayout will help determine number of coats needed.

Topcoat grade gun 1.3-1.5 @ 16-20 PSI individual guns vary.

Allowing adequate flash times will improve cure and speed overall dry times.

## Additives

Orion Automotive Finishes does not offer, or require, any additives for this product.

## **Dry Times/Pot Life @ 77F/25C**

(Dry/Flash times dependent on layer thickness)

Flash time between coats:	5-10 minutes (tacky)
Dry to handle:	1-2 Hours
Bake time:	Allow 10 minute purge time 30-40 minutes @140F/60C Cool down 4-5 hours
Pot Life:	3 Hours

## **Recoating**

Polishing can be done after 24 Hours.

Recoating with itself, addition of a graphic art plan, or finish repair can be done after 24 hours. Follow preparation instructions for existing finishes.

## **Safety and Emissions Data**

Color: Various

Film Build: 1-2 mil per layer

The appropriate selection of this product is based on many local factors and is ultimately most accurate when made by the customer. To assist in issues with regard to product selection please contact Orion Automotive Finishes.

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

### **SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION**

**NOTE: Orion Automotive Finishes products are not recommended for use in temperatures below 65°F. Use below these temperatures will effect dry times and performance**