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From the Stars to your Cars

Technical Data Sheet **Orion Basecoat Color**

Product Description and Purpose

Orion Basecoat Color offers the professional collision painter a complete range of OEM style 2 and 3 stage colors and effects. For the custom effect painter, the clean and brilliant toner allow for “out of this world” possibilities from vibrant colors combinations to the deep candy finishes for use on world class projects

Quick Start Guide

Product:	Orion Base Color
Mix Ratio:	1 Part Orion Base Color 1 Part Color Base Reducer 594-CB60, 70 , or 80
Number of layers:	2-4 as indicated by spray sample
Items Needed:	Orion Base Color and Color Base Reducer 594-CB60, 70 , or 80

Acceptable Substrates

Orion Brand primers, surfacers, sealers
OEM finishes
OEM primed plastics

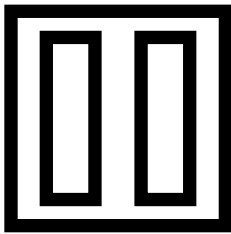
Substrate Preparation

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

594-30 Wax and Grease Remover

OEM primed plastic: Sand Dry or P320-P400 or P600=P800 Wet
OEM finishes: Sand Dry or P320-P400 or P600=P800 Wet
Orion Brand undercoats Sand Dry or P320-P400 or P600=P800 Wet

Mixing Ratios and Optional



1 Part Orion Base Color
1 Part Orion Color Base Reducer
594-CB60 Cool temp/small jobs
594-CB70 Mild temp/mid sized jobs
594-CB80 Warm temp/large jobs

Optional ratio:

Hardener 11-10 may be used in Orion Base Color to increase adhesion, and flexibility in multi layer, flexible, or custom applications.

Mix 1:1 with Orion Color Base Reducer, then, add 5% 11-10

Additives

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

Application

2-4 according to design sprayout. If more coats are required for hiding consider the use of an appropriate color ground color.

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

Proper flash times will improve cure and speed overall dry times.

Dry Times/Pot Life @ 77F/25C

(Dry/Flash times dependent on layer thickness)

Flash time between coats: 5-10 Minutes until dry to touch

Dry to Sand: 15-30 minutes, if sanding is needed to correct minor surface imperfections, base color will need to be reapplied prior to clear coat or scratches will show.

Pot Life: Indefinite when mixed 1:1
2 hours @ 70F when 5% hardener is used

Recoating

Orion Basecoat Color can be recoated after flash time up to 24 hours.

If additional time to clear is needed apply 1 single coat of 1610-00 Interstellar Intercoat Clear to surface. When returning to the job, scuff, clean, and continue with artwork or graphics plan.

Additional colors can be applied after approximately 60 minutes when the surface can be securely handled, taped, and tacked in preparation for subsequent artwork or graphics plan.

Upon final color application the base color must be clear coated.

The following Orion Brand 2K Urethane clearcoats may be used:

Meteor Fast Dry Panel Clear	1610-06	TDS# 5.1
EEZEE Spray MS Clear	1610-01	TDS# 5.2
StarGazer High Performance Clear	1610-10	TDS# 5.3
Matte Clear	1610-15	TDS# 5.4
EuroStyle Clear	1610-20	TDS# 5.5

Safety and Emissions Data

Color: Various

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.