



VB-14

STARFIRE™

VM4206 Red
VM4207 Blue

VM4210 Green II
VM4212 Yellow II

STARFIRE™ toners are special colored aluminum pigments that are part of the VIBRANCE COLLECTION® which may be used with DELTRON® DBC 2000 and DELTRON® NXT Basecoats to enhance the basecoat color capability.

These pigments may also be used in DBC500 color blender and VWM500 Custom Midcoat, or sprayed alone to produce custom special effect colored groundcoats and midcoats.

For procedures relating to custom and/or restoration work refer to PPG's Custom Restoration Guide available at ppgrefinish.com under Training.



Compatible Products and Systems

Starfire toners are used in conjunction with the systems shown below:

- DELTRON® DBC 2000 Refinish System - Follow P-175 *Deltron* DBC recommendation for proper preparation and compatible primers.
- DELTRON® NXT Refinish System - Follow P-251 *Deltron* NXT recommendation for proper preparation and compatible primers.
- DBC500 Color Blender - Follow P-176 *Deltron* DBC500 recommendations for proper preparation and compatible primers.
- VWM500 *Vibrance Collection* Custom Midcoat - Follow VB-22 recommendations for proper preparation and use.

Note: Custom or exotic finishes are excluded from coverage under the PPG Paint Performance Guarantee.

Surface Preparation



- When working on custom finishes close attention to details outlined for standard basecoat preparation, sanding, and cleaning is needed to achieve the optimum results.
- *Starfire* colors are designed to be applied over properly cleaned, sanded, and primed surfaces.
- For use over ENVIROBASE® High Performance EHP, use VWM500 Custom Midcoat (VB-22)

VM42xx**Mixing Ratio:**

(adding VM42xx to a
basecoat color or
blender)



For a custom formulation you may add a maximum of 10% *Starfire* pigment to un-reduced color or 5% to ready-to-spray mix of DBC, BC, DBC500 and D895 or up to 14% to unreduced of VWM500.

Reducing:

(basecoat color or
blender already
containing VM42xx)

**Reduction of basecoat color or blender already containing VM42xx**

For detailed *Deltron* DBC 2000 reduction specifics see data sheet P-175**

For detailed *Global Refinish System* BC reduction specifics see data sheet EU02**

For detailed DBC500 reduction specifics see data sheet P176**

For detailed D895 reduction specifics see data sheet EU113**

For detailed VWM500 reduction specifics see data sheet VB-22

DX57 or D888 activator **must be used in DBC or BC colors containing VM42xx or DBC, DBC500, BC or D895 colors containing *Starfire* color. When using *Starfire* basecoat colors, DX57 or D888 activator **must** be used in both the ground coat and mid-coat colors.

**Pot Life:**

See specific product data sheet listed above

Using activated material beyond 1 hour may result in wrinkling or other product failures (especially on multiple colors).

Additives:

See specific product data sheet listed above

**Air Pressure
And Gun Setup:****HVLP:**

8 - 10 psi at the air cap

Compliant:

29 - 40 psi at the gun

Gun Setup:

1.1 - 1.5 mm or equivalent

Refer to spraygun manufacturer's recommendations for inlet air pressures.

Application:**Apply:**

Sufficient number of coats to achieve desired effect.
Spraying a test panel is recommended to determine desired effect.

Drying Times**Between Coats:**

See specific product data sheet listed above

**Air Dry:****Tape Time:**

See specific product data sheet listed above

**Dry to Clearcoat:**

See specific product data sheet listed above
24 hour maximum to clear coat

Note: Basecoat colors are designed to dry low in gloss. This makes color match and its approval difficult to see until the clearcoat is applied. **A good technique is to spray the basecoat and clearcoat on a small test panel before spraying the job.**

If the basecoat color is allowed to dry more than 24 hours, it must be scuffed and new basecoat color applied.

Tri-Coat Mixing

When mixing for a tri-coat applications, 5% DX57 Basecoat Activator (DBC) or D888 Basecoat Activator (BC) should be added to the reduced basecoat prior to spraying in **BOTH** the ground coat and mid coat.

Starfire toner can be blended as a mid-coat color with DBC500 Color Blender (DBC), VWM500 Custom Midcoat, or D895 Color Blender (BC). In doing so you can achieve more transparency, when combined with varying ground coat colors and create different degrees of custom effects. DBC500, VWM500, or D895 can be used in any quantity necessary to achieve the desired effect.

VM42xx

Striping or Two Toning

Tape Times:

Tape time of DBC and NXT is 30 - 60 minutes at 70°F (21°C) and 50% relative humidity.
Tape time of VWM500 is 45 - 60 minutes (additional coats may require longer dry time).

All striping, two toning must be completed within 24 hours. If allowed to dry for more than 24 hours, it must be sanded and reapplied.

When applying DBC or NXT basecoats, 5% DX57 Basecoat Activator **must** be added to the reduced basecoat prior to spraying in **BOTH** the ground coat and mid coat.

Clearcoating:

Clearcoat *Starfire* colors with any *Vibrance Collection* clearcoat or any clear recommended for *Deltron* DBC 2000 (P-175), *Deltron* NXT (P-251), or *Envirobase* High Performance EHP (see EB-143 for complete listing)

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc., should be cleaned thoroughly after each use with any appropriate PPG general purpose solvent.

Technical Data	<u>DBC</u>	<u>NXT</u>	<u>DBC500</u>
Package VOC Actual	4.86 - 6.16 lbs./gal (582 - 738 g/L)	5.91 - 6.42 lbs./gal (708 - 769 g/L)	5.20 - 5.62 lbs./gal (623 - 673 g/L)
Package VOC Regulatory (Less water, less exemptions)	4.86 - 6.16 lbs./gal (582 - 738 g/L)	5.91 - 6.42 lbs./gal (708 - 769 g/L)	5.20 - 5.62 lbs./gal (623 - 673 g/L)
RTS Volume Ratio	1:1 + 5%	1:1 + 5%	1:1 + 5%
RTS VOC Regulatory (Less water, less exemptions)	5.49 - 6.20 lbs./gal (658 - 743 g/L)	5.54 - 6.20 lbs./gal (664 - 743 g/L)	5.87 - 6.49 lbs./gal (704 - 778 g/L)

	<u>VWM500</u>
Package VOC Actual	1.52 - 1.55 lbs./gal (182 - 189 g/L)
Package VOC Regulatory (Less water, less exemptions)	3.33 - 3.66 lbs./gal (400 - 439 g/L)
RTS Volume Ratio	1:1 + 5%
RTS VOC Regulatory (Less water, less exemptions)	5.50 - 5.88 lbs./gal (659 - 705 g/L)

For detailed DBC recommendations and VOC specifics see data sheet P-175
For detailed NXT recommendations and VOC specifics see data sheet P-251

For detailed DBC500 recommendations and VOC specifics see data sheet P176
For detailed VWM500 recommendations and VOC specifics see data sheet VB-22

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

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.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. 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 PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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