



Technical Data Sheet

MATTE BLACK SINGLE STAGE

DESCRIPTION:

Matte Black Single Stage is a 2-component acrylic urethane coating that is designed for wheels that have semi-gloss, eggshell or flat finishes. The gloss level is variable depending on the mixing ratio of matte black to hardener.

***SHAKE WELL PRIOR TO USING**

FEATURES:

- *Easy Mix Ratios
- *True 2K Urethane Durability
- *Excellent Stability from UV Light
- *Great Rub Resistance
- *Three Gloss Levels / One Product
- *Uniform Jet-Black Color
- *Fast Dry
- *Chemical Resistance

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Matte Black Single Stage	154015	Pint
Matte Hardener	154005	½ Pint

COMPATIBLE SUBSTRATES:

DTA Foundation Coating
Wheelkote 2K Epoxy Primers
OEM Finishes

SAFETY ASPECTS:



Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS are available on the ordering portal. Click on the SDS button located under each product. You can also locate the SDS on the tech center website or call the technical department and request them.



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MIXING RATIOS:
Various Gloss Levels

MIX 4:1 (Semi-Gloss / High Sheen)
 4 parts: Matte Black Single Stage
 1 part: Matte Hardener

MIX 5:1 (Eggshell / Medium Sheen)
 5 parts: Matte Black Single Stage
 1 part: Matte Hardener

Mix 6:1 (Flat / Low Sheen)
 6 parts: Matte Black Single Stage
 1 part: Matte Hardener


Optional: 0-5% Reducers may be used in any mixing ration if desired.

GUN SETUP: 	TYPE	FLUID TIP	SPRAYING PRESSURE
	Mini Jet Gravity	1.3 mm – 1.4 mm	25-30 psi @ gun
	HVLP Gravity	1.2 mm – 1.4 mm	10 psi @ gun

NUMBER OF COATS: For best results the first coat of Matte Black should be one full wet coat allowing to flash approximately 5-10 minutes, depending on temperature. Then apply a second medium coat.

FLASH TIMES: 5-10 minutes.

PURGE TIME: 15 minutes.

DRYING TIMES: 	METAL TEMP	DUST FREE	TACK FREE	DRY
	72°F/22°C	10-15 minutes	15-20 minutes	N/A
	140°F/60°C	N/A	N/A	15-20 minutes

Note: Purge time before force dry is generally 15 minutes.

RECOATABILITY: Matt Black SS may be recoated after bake cycle when wheel has completely cooled down. Air dry repair can be done after 3-4 hours. For best results in air dry situations repair next day.

FILM THICKNESS: Approximately 1.0 -1.2 mils per single wet coat.



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POLISHING: *NO SANDING OR POLISHING CAN BE PERFORMED.*



DECALS: Decals, lettering or stripes can be applied after 24 hours.

CLEANING EQUIPMENT Clean equipment immediately with lacquer thinner.

TECHNICAL DATA:



Color	Satin Black
Activator/Hardener	Matte Hardener
Mix Ratio	4:1 / 5:1 / 6:1
Reducer	0-5% optional
Additives	N/A
Number of Coats	1 full wet coat / by 1 medium coat
Flash Time	5 - 10 minutes
Purge Time	15 minutes
Dry Time	4-6 hours @ 72°/22°C 15-20 minutes @ 140°F/60°C
Gun Set-Up	Refer to Table on Page 1
Air Pressure @ Gun	Refer to Table on Page 1
Pot Life	60 min @ 72°/22°C
Sprayable V.O.C.	2.8 lbs./gal
Package Size	Pint
Shelf Life	12 months unopened

All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.

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