

Technical Data Sheet

GLOSS BLACK SINGLE STAGE

DESCRIPTION:

Gloss Black Single Stage has been formulated for the mobile wheel repair industry. Gloss Black Single Stage is a 2-component acrylic urethane with superior UV and chemical resistance and offers a fantastic appearance. It mixes 3:1 with a 5% optional reduction if desired. Providing excellent gloss and DOI with uniform jet black color.

*SHAKE PRIOR TO USING

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Gloss Black Single Stage	154025	Pint
Gloss Black Single Stage Hardener	154020	½ Pint
Reducer: (ONLY IF NEEDED)	Various	Qt/Gal

COMPATIBLE SUBSTRATES:

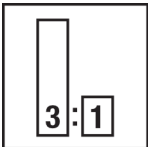
DTA Foundation Coating
 Wheelkote 1K Primers
 Wheelkote 2K Epoxy Primers
 OEM Finishes

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.

MIXING RATIOS:



MIX 3:1

3 parts: Gloss Black Single Stage
 1 part: Gloss Black Single Stage Hardener
Optional: 0-5% Wheelkote Reducers

Additional reducer may raise V.O.C.

GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Mini Jet Gravity	1.2 mm – 1.3 mm	20 - 30 psi @ gun
HVLP Gravity	1.3 mm – 1.4 mm	8 - 10 psi @ gun

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NUMBER OF COATS: Apply 2 medium wet coats. Apply the first even medium wet coat then allow 5 – 10 minutes flash time prior to application of the second even medium wet coat.

FLASH TIMES: 5 - 10 minutes (depends on ambient temperature)

PURGE TIME: 5 - 10 minutes (depends on ambient temperature)

DRYING TIMES:



METAL TEMP	DUST FREE	TACK FREE	
75°F/24°C	5-10 minutes	10 - 15 minutes	5 - 10 minutes.
130°F/49°C	N/A	N/A	20 minutes.

Note: Purge time before force dry is generally 5 minutes.

RECOATABILITY: Gloss Black Single Stage may be recoated after bake cycle when metal has completely cooled down. Air dry repair can be done after 6 - 8 hours. For best results in air dry situations repair next day.

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

POLISHING:



For optimum results, allow cool down after baking or 6 - 8 hours if air dried. Allow these times if sanding, light de-nib with 2000 grit. Recommended to use foam pads if compounding and/or polishing.

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

CLEANING EQUIPMENT Clean equipment immediately with lacquer thinner.

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TECHNICAL DATA:



Color	Jet Black
Activator/Hardener	Gloss Black Single Stage Hardener
Mix Ratio	3:1
Reducer	Optional 5%
Additives	N/A
Number of Coats	2 medium wet coats
Flash Time	5 - 10 minutes
Purge Time	5 - 10 minutes
Dry Time	6 – 8 hours @ 75°/24°C 20 minutes @ 130°F/49°C
Gun Set-Up	Refer to Table on Page 1
Air Pressure @ Gun	Refer to Table on Page 1
Sprayable V.O.C.	2.8 lbs/gal VOC
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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