

105K0099

DTM Acrylic Enamel

Chassis Black Topcoat

09092016

DESCRIPTION

The 105K0099 is a medium solids, air dry (direct to metal) acrylic enamel topcoat, which offers good adhesion with rust inhibitive properties and excellent dry times. Please check your local regulations for VOC requirements.

COMPONENTS

- 105K0099 Chassis Black
- H4
- S9860/S9870/S9885/S9895

Base
Hardener (optional)
Fast/Medium/Slow/Very slow – Reducers
(optional)

MIXING RATIO

105K0099 Acrylic Enamel does not require activator. For enhanced performance, mix eight (8) parts 105K0099 color with one (1) part H4 hardener. 105K0099 is ready to spray but can be reduced up to 10% with appropriate reducer.

POT LIFE AT 70° F

2 hours with hardener.

CLEAN UP

Use **NORTHSTAR** Lacquer thinner. (Check local regulations)

PHYSICAL DATA

Solids wt. (as mixed)	38%
VOC as mixed	4.0
Color	Black
Gloss	Semi-Gloss

DRY / FLASH TIMES

Air Dry at 77° F

Flash between coats	10-15 minutes
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Tape Time	8 hours
Dust free	20 minutes
Tack free	45 minutes

Force Dry

Flash before force dry	15 minutes flash
Force dry time	30-40 minutes at 140° F

GUN SETUPS

Conventional

Gravity Feed	1.3 mm – 1.5 mm
Siphon Feed	1.3 mm – 1.5 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed	30 – 40 psi
Siphon Feed	35 – 45 psi
HVLP at cap	8 – 10 psi

SURFACE PREPARATION

Use **NORTHSTAR** Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.

APPLICATION

- Apply 2 medium wet coats over substrate
- Allow 10-15 minutes between coats
- Scuff after 24 hours before recoating
- Clean gun after spraying is completed

SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.