

FLAT BLACK CHASSIS PAINT



TECHNICAL DATA SHEET

Flat Black Chassis Paint is a 0-5% gloss finish enamel paint that is easy to apply by brush, roller or spray. It is an economical way to quickly refurbish frames, suspension components and other underbody parts.

- National Rule Compliant
- Excellent economic value
- Easy to apply
- Finish resists stone chips and road wear

COATING TYPE:

Synthetic Enamel Paint (Single-stage)

Appearance:

Black Paint / Flat Finish

PRODUCT CODE:

2-75

Weight per Gallon:

8.72 lbs

HARDENER:

K-1605 Synthetic Enamel Hardener (optional)

Package Measure:

1 U.S. gallon / 128 fl. oz. (3.785 liters)

REDUCERS:

R-8250 – Fast (Less than 65° F)

R-8253 – Medium (Between 65° - 80° F)

R-8256 – Slow (Above 85° F)

UE-8000 – Universal VOC-Exempt Reducer

RTS VOC:

Maximum VOC of 5.0 lbs/gallon

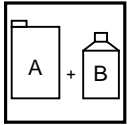


SURFACE PREP:

Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Abrade substrate with 600-800 grit to ensure sufficient adhesion. Re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

2-75 may also be applied over Super Rust Stop non-sanding primer after 30-minute flash, or ENDURO-PRIME epoxy primer, after 30-45 minute flash.

Be sure to mask all adjacent panels to prevent dry overspray.



MIXING:

If rolling or brushing Flat Black Chassis Paint, apply coating unreduced. If applying by spray, mix ratio is 4:1 by volume. Thoroughly mix four (4) parts 2-75 with at least one (1) part of the appropriate Synthetic Enamel Reducer (R-8250, R-8253 or R-8256), depending on air flow and shop temperatures.

Temperature range	Less than 65° F	Between 65° F - 80° F	More than 80° F
Reducer	R-8250 (fast)	R-8253 (medium)	R-8256 (slow)

Additional reduction may be required to improve flow and leveling. Use one of Kirker's Synthetic Enamel Reducers (R-8250, R-8253 or R-8256), depending on shop temperature, or Universal Zero-V.O.C. Reducer, UE-8000. **WARNING:** With further reduction beyond the recommended 4:1 mix ratio, 2-75 may no longer be VOC compliant for your area. Using UE-8000 will not increase the VOC.

Caution: Mix only as much material as you will need to complete the immediate job.

WITHOUT HARDENER:

4:1

2-75	4oz	12 oz.	20 oz.	28 oz.
Synthetic Enamel Reducer	1 oz.	3 oz.	5 oz.	7 oz.
TOTAL MIXTURE	5 oz.	15 oz.	25 oz.	35 oz.

Though not required, a Synthetic Enamel Hardener (K-1605) may be used. The use of a hardener will speed the dry time, while also increasing gloss in the finished film. A hardener also will make the 2-75 somewhat less pliable, which may or may not be desirable depending upon situation. Up to one (1) pint (16 oz.) of hardener can be mixed with each gallon of 2-75 and quart of synthetic enamel reducer, resulting in an 8:2:1 mix ratio (8 parts paint: 2 parts reducer: 1 part hardener).

Caution: Mix only as much material as you will need to complete the immediate job.

WITH HARDENER:

8:2:1

2-75	4oz	8 oz.	16 oz.	24 oz.
Synthetic Enamel Reducer	1 oz.	2 oz.	4 oz.	6 oz.
Synthetic Enamel Hardener	½ oz.	1 oz.	2 oz.	3 oz.
TOTAL MIXTURE	5.5 oz.	11 oz.	22 oz.	33 oz.



POT LIFE:

Approximately 3 hours at 70°F

Caution: Pot life is significantly shorter at elevated temperatures and in humid conditions. These environmental factors also may affect flow and leveling during the application process.



GUN SETTINGS:

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon Feed:	1.4 mm – 1.8mm	50-60 psi at the gun
Conventional Gravity Feed:	1.4 mm – 1.6 mm	50-60 psi at the gun
HVLP	1.2 mm – 1.4 mm	8-10 psi at the tip

Always refer to gun manufacturer's recommendations for additional details on suggested tip size, air pressure and other adjustments.



APPLICATION:

Spray 2-75 in two medium wet coats, allowing chassis paint to fully flash between coats. Too much time passed between coats could result in poor flow, which may lead to orange peel. Two coats should be sufficient to achieve a dry film thickness of 2 mils. Additional coats may induce runs, sags, soft paint film and / or wrinkling. 2-75 may also be applied by brush or roller, with no reduction.



DRY TIMES:

	<u>WITH HARDENER</u>	<u>WITHOUT HARDENER</u>
Dust free:	1 hour	2 hours
Tack free:	2 hours	3 hours
Tape:	24 hours	1 week +
Polish:	36 hours	1 month
Deliver:	24 hours	1 week

Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70° - 75°F



CLEANUP:

Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

Shelf life of K-1605 Synthetic Enamel Hardener is limited once can has been opened. This product is extremely susceptible to oxygenation and exposure to moisture. Therefore, containers should be closed tightly after each use, with a clean seal, as quickly as possible. Also, activators should be stored at a consistent temperature to prevent the formation of potentially damaging condensation inside of the can.



HEALTH / SAFETY PRECAUTIONS:

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted fresh-air-supplied NIOSH/MSHA-approved respirator (TC-19C or equivalent) as directed by the manufacturer. Protect hands with impervious nitrile gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. READ ALL WARNINGS ON ALL LABELS BEFORE USING.

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Material Safety Data Sheet for additional health and safety information.

WARRANTY:

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

FOR ADDITIONAL INFORMATION:



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