

Matte Black Urethane

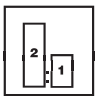
A high-solids, low-gloss 2K polyurethane coating. Produces is a highly durable matte black finish with a 10% gloss level. 4:1:1 mix ratio.

Part #	Description	Size
8544	Matte Black Urethane	1 Qt..
8548	Catalyst	1/2 Pt.



Substrates

Apply over primed steel, aluminum or fiberglass. Final sand primer with 400- 600 grit sandpaper



Mixing

4 parts Matte Black
1 part Catalyst
1 part urethane reducer



Set Up Tech Info

Tip/Needle:	1.3mm to 1.5mm
Air Pressure:	40 - 50 psi / HVLP 6 to 10 psi at cap
Viscosity: #2 Zahn	18-28 seconds
Film Build:	1.0-2.0 mils per full wet coat
Coverage	850 sq. ft / gallon @ 1 mil
Pot Life	3-5 hours @ 77°



Application

Apply 2-3 medium coats allowing a 5-15 minute flash time between coats. Note: Wet coats will produce more gloss. Drier coats will produce a flat finish. Uneven coating will produce varied gloss levels in the finish.



Drying

Air Dry @ 77°F	
Dust Free	30 minutes
Tack Free	60 minutes
Sand/Buf Time	Not applicable
Deliver	16-24 hours
Recoat	16-24 hours
Force Dry - Purge for 15 minutes @ 77°F, bake 40 minutes at 140° F.	
Recoat	1 hour cool down



Physical Data

Volume Solids RTS	52-70%
VOC RTS:	2.1 lb./gallon
Humidity Resistance:	Excellent
Salt Spray Test:	Excellent



Master Tips

The use of accelerators is not recommended. Do not use product if shop temperature is below 65°F. If recoating after the 16-24 hour recoat window, lightly sand or scuff before recoating.