



TAMCO PAINT

AUTOMOTIVE

DIRECT TO RUST HB CHASSIS

A 4:1 2K direct to metal and direct to rust Urethane Chassis Paint. Excellent adhesion to metals, plastics and painted surfaces. Easy sand. Mix 4 parts primer to 1 part HH193 Hardener. This is not a semi-gloss or a satin chassis system. It's a 90% gloss black. Gloss is slightly lessened only due to the rust converting additive used. **Chassis Black** is a durable Direct to Metal(Rust) self-priming 2K Polyurethane for long lasting economical finishes for an easy-to-apply use. Fills minor scratches. This product will blow away the competition which in our testing failed in only 500 hours salt spray testing. It's not moisture cured - It's ISO cured. Great for new and older chassis with surface rust in hard to reach places. 3 full coats will covert and encapsulate all surface rust



FEATURES & BENEFITS

- No Primer Needed
- Direct to rust and most metals
- Very Fast dry
- 90 % gloss rating
- Durable acrylic urethane resin system
- Much less expensive than that "15" without the hassle of 1K moisture urethanes (that go bad once the top is lifted off!)

COMPATIBLE SURFACES

- Metal chassis
- Under hood areas
- Under wheel openings

REQUIRED PRODUCTS

- HH-193 Activator

OPTIONAL

- HR1360
- HR1370
- HR1380
- HR1390
- HP1010 fisheye eliminator
- HR900 retarder
- HP1001 accelerator
- Pot Life extender
- HP Flat

(See our "What Temperature should I choose PDF" for a guideline on which suits your current job)

DIRECT TO RUST HB CHASSIS

Surface Preparation:

Best Chassis system:

- Blast chassis to bare white steel
 - Wash with HR397
 - Apply either Tamco's® unique direct to anything 2K Epoxy Primer or our DTM and DTR (direct to rust) 2K Primer systems for optimum results and extra fill capabilities.
 - Apply 3 coats of chassis black with 10-15 minute flash time at 78°F.
 - Allow final coats to cure for 4 hours. Product is deliverable.
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Mix Ratio:



Component

Volume

HP Chassis Black

4

HH193

Activator

1

HR1360/1370/1380/1390

Reducer

As needed up to 5-10%

Note: Use only Tamco® Reducers. Our reducers are completely moisture free.

Additives:



None needed.

Air Pressure & Gun Setups:



Gun Setups:

HVLP

Siphon Feed: 1.4 mm – 1.8 mm

Gravity Feed: 1.4 mm – 1.5 mm

Conventional

Siphon Feed: 1.4 mm – 1.8 mm

Gravity Feed: 1.4 mm – 1.8 mm

Air Pressures Conventional: Always refer to your gun manual for their advice in using our products.



DIRECT TO RUST HB CHASSIS

Application:



- Wash first with soap and water.
- Blast Chassis to bare metal
- Then use Tamco® HR397 (or HR397W) Wax and Grease remover. Our high strength HR397 solvent is an excellent choice for the initial cleaning of cured paint surfaces before sanding and for cleaning bare metal. We also have a waterborne version in the HR397W (water).

Best Choice:

- Apply 1-2 Coats of HP53XX 2K urethane primer or HP770 Series High Build
- Epoxy primer—OR 1 coat of HGP66X Series Epoxy Sealer (The HP66X sealer does not have to be sanded before top coating with Chassis Black.
- Apply 3 coats of chassis black with 10-15 minute flash time at 78°F.
- Allow final coats to cure for 4 hours. Product is deliverable.

Good Choice:

- Wash first with soap and water. Then use Tamco® HR397 (or HR397W) Wax and Grease remover. Our high strength HR397 solvent is an excellent choice for the initial cleaning of cured paint surfaces before sanding and for cleaning bare metal. We also have a waterborne version in the HR397W (water).
- Sand chassis with 180 Grit Sandpaper then apply two coats of HP-66X Series epoxy Sealer.
- Apply 3 coats of chassis black with 10-15 minute flash time at 78°F.

Quick Refinish:

- Finish sand chassis with 220 grit sandpaper after cleaning, then Apply 3 coats of chassis black with 10-15 minute flash time at 78°F.

Drying Times:



4 hours at 78°F.

Polishing:



N/A.



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Tamco® Tips:



- Best used over properly primed chassis.
- Apply heavy wet coats to help cover scratches.
- When chassis is in very poor condition, it is best to lock down the chassis with Tamco® MonoCoat moisture cure urethane by roller or brush. This is a very thick product.

Wet Sanding:



Bare metal: 80-220 grit



DIRECT TO RUST HB CHASSIS

Equipment Cleaning:

Lacquer Thinner

Cold Shop Conditions:

Do not spray below 55°F.

TECHNICAL DATA & PHYSICAL PROPERTIES

Colors: Black

Viscosity: (RTS) 20-24 EZ Zahn #2

Pot Life: 1 hour @78°F or depending on temperature

Mix Ratio: 4:1

Theoretical Dry: 400 ft2 @ 1 Mil Weight Solids (RTSXXXXX%)

Color & Gloss holdout : Good

Volume Solids (RTS): 37%

Humidity Resistance :Great

Weight Per Gallon: 8.2 #s/gallon

Solvent Resistance Good

Topcoat times : 10-15 mins. 1 mils or less

Repair ability: Excellent

Florida Exposure Good

Package VOC: 3.8

Chip resistance Excellent

RTS VOC: 3.5

See Safety Data Sheet/Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Important: The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Tamco Paint Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Tamco Paint warrant freedom from patent infringement in the use of any formula or process set forth herein.

Tamco Paint
Barney Family Enterprises
PO BOX 711
Wakefield, Va 23888
(757-627-9551)

www.TamcoPaint.com

Follow us online: @TamcoPaint

