



TDS Sheets

Chassis Black Single Stage

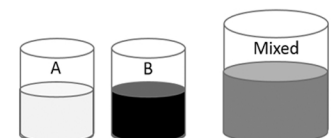
Chassis Black Single Stage is a 4:1 2K direct to metal and direct to rust Urethane Chassis Paint. Catalyst Included! Excellent adhesion to metals, plastics and painted surfaces. Easy sand. MIX 4 parts Primer to 1 part HH193 Hardener. This is not a semi gloss or a satin chassis system. Its a 90% gloss. Its only lessened due to the rust converting additive. A Durable Direct to Metal self-priming 2K Polyurethane for long lasting economical finishes for an easy-to-apply use. Fills minor scratches. This product will blow POR 15 away. This uses HALOX 630 antirust inhibitor/ converter. Its not moisture cured. Its ISO cured. Great for new and older chassis with surface rust in hard to reach places. Much less expensive than POR 15 without the hassle of 1K moisture urethanes (that go bad once the top is lifted off!) Also for Industrial applications needing direct to metal finishes. Mix ratio 4:1 long pot-life. Quick Dry! Comes in gallons and quarts Low Cost, the best bang for the buck! Durable 5-10 year system, depending on conditions. Use over Tamcos 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. 3 full coats will cover and encapsulate all surface rust



Component

Volume

Chassis Black	Single Stage	4
HH-7603/7605/7607	Activator	1
HR-1360/1370/1380/1390	Reducer	As needed up to 5%



USE ONLY TAMCO REDUCERS. Our reducers are completely moisture free. Moisture in reducer will kill the shine of our clears. 45% solid content RTS

H-7603-Fast
60-75°F / Large areas 65-70°F

HH-7605- Standard
75-80°F / Large areas 70-80°F

HH-7607- Slow
85-100°F / Large areas 80-90°F

HH7607 will be 87-100°F you may need to add 5% HR900 retarder in hot humid conditions

Gun Setups

See manufacturers suggestions

Common User Suggestions

Iwata Supernova: 1.3 or 1.4, fluid open, trigger pull full, 1 turn in on fan, 26 psi

Iwata WS400 evo: 1.3hd fluid open, trigger pull full, 1 turn in on fan, 30 psi

Iwata LPH 400: 1.3 or 1.4 fluid open, trigger pull full, 1 turn in on fan, 20 psi (this is an hvlp gun recommended by the manufacturer to be no higher than 19 psi but the extra pressure helps atomize the clear for a smoother finish)

Sata RP 4000/5000: 1.3 or 1.4 fluid open, trigger pull full, fan open, 28-30 psi

Sata 4000/5000 hvlp: 1.3 or 1.4 fluid open, trigger pull full, fan open, 29-32 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE10 fluid open, trigger pull full 28 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE20 24-26 psi





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Application

See manufacturers suggestions

Common User Suggestions

After basecoat has dried for 30 minutes apply 1 medium/wet coat and allow to flash for 15-20 minutes before applying next coat. We recommend no longer than 1 hour application time between base and clear for maximum adhesion. Apply only 3 coats of clear for each session. Shop conditions temperature and air flow will determine flash times. The “string” test method can be used to determine proper flash time for your conditions. Monitor an area by lightly touching. If the clear is still wet or stringing do not apply additional coats. Wait until finish becomes sticky but doesn’t string. Do not apply .more clear after 1 hour of dry time



Dry Times

Air Dry at 70° 12 hours

Force Dry at 140°= Allow to flash for 20-30 min then bake 30 minutes and allow a 30 minute cooldown

Finish Sanding

After the clear has cured for at least 12 hours dry or wet sanding is acceptable. Adding a small amount of dish soap to the water and soaking the paper will provide best results. If sanding with a DA sander we recommend denibbing first and taking it slow as “pigtailed” can .be introduced and become difficult to remove in the polishing process



Recoat

If you choose to apply additional coats of clear after sanding you can add 5% reducer and apply 1 medium coat followed by 2 more medium wet coats with 20-30 minute flash .between. As above shop conditions will vary flash times so “string” test is recommended

Polishing

Allow clear to dry for at least 12 hours before polishing

We recommend going all the way up to 3000 grit for best results and ease of polishing. Follow recommended procedures from the manufacturer of the products you are using. For show car polishing we recommend allowing the car to sit for a few days to outgas before finishsanding and polishing. After finish sanding allow the car to sit in the sun for a day before buffing. This allows more solvents to evaporate and the surface to be easier to polish and won’t show sand scratches