

## Chassis Black (Satin)

### FOR PROFESSIONAL USE ONLY

Description
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Fast drying acrylic enamel designed for both interior and exterior use. Chassis Black is ideal for industrial maintenance and can be used over unprimed steel. Superior color retention allows this jet-black enamel to maintain its decorative beauty while providing lasting protection



### Chassis Black (Satin 20-30 GU)



Ready For Use

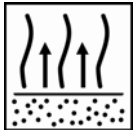


Spray gun set-up:  
1.8–2.2 mm  
HVLP max. 10 psi at air cap

Application pressure:  
40-50 psi ( 3-4 bar )  
o Check gun manufacturer specification



2-3 x 1 coat  
Apply single coats



Between coats  
5-10 minutes at 70°F (20°C)



Dry Times  
Dry

70°F (20°C)  
60 Minutes

140°F (60°C)  
N.A.



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information



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#### Product and additives

<b>Product</b>	Chassis Black (Satin 20-30 GU)
<b>Hardener</b>	N/A
<b>Reducers</b>	N/A
<b>Additives</b>	N/A

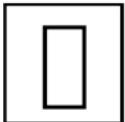
#### Basic raw materials

Chassis Black (Satin): Acrylic Resin

#### Suitable substrates

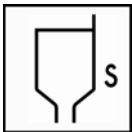
- Existing finishes, with the exception of thermoplastic acrylic lacquers, degreased and sanded with #P240 to #P320 grit paper dry or #P400 to #P500 grit wet.
- Steel, degreased and sanded. Remove any millscale by blasting if necessary.
- Galvanized steel, degreased, and prepped with Scotch-Brite red pad.
- Aluminum, degreased, and sanded with #P150 to #P180 grit dry or Scotch-Brite red pad, followed by an Akzo Nobel approved metal pretreatment.
- Fiberglass, (unbroken gelcoat) degreased and sanded with #P180 to #P220 grit dry.
- Any premium polyester body filler final sanded with #P220 grit dry

#### Mixing Ratio



Ready for use

#### Viscosity



19-21 sec. Ford cup #4 at 70°F (20°C)

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### Spray gun set-up / application pressure



	Fluid Tip	Spraying Pressure	Fluid Pressure
Siphon Feed	0.055" - 0.067" (1.4-1.7 mm)	50-60 psi (3.5 – 4.5 bar)	
Gravity Feed	0.051" - 0.059" (1.3-1.5 mm)	50-60 psi (3.5 – 4.5 bar)	
HVLP Siphon	0.071" - 0.087" (1.8-2.2 mm)	max 10 psi (air cap)	
HVLP Gravity	0.059" - 0.067" (1.5-1.7mm)	max 10 psi (air cap)	
Pressure Feed	0.039" - 0.047" (1.0 – 1.2 mm)	50 – 60 psi (3.5 – 4.5 bar)	10 – 14 oz per min. (10 – 14 psi)
HVLP - Pressure Feed	0.031" - 0.039" (0.8 – 1.0 mm)	max 10 psi (air cap)	10 – 14 oz per min. (10 – 14 psi)
Airless Spray	0.011" – 0.015"		2000 – 4000 psi (140 – 160 bar)
Air Assisted Airless	0.011" – 0.015"	700 – 900 psi (48 – 62 bar)	
Electrostatic	0.059" - 0.067" (1.5 – 1.7 mm)	60 – 70 psi (4.5 – 5.0 bar)	25 –35 psi (1.7 – 2.4 bar)

### Application process



As a stand alone chassis coating, apply a medium wet coat for a minimum dry film thickness of 1.0-1.5 mils or to opacity

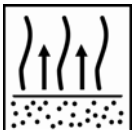
### Pot-life

N/A

### Film thickness

Per coat: 1.0-1.5 mils. (25 -40 µm)  
The minimum dry layer thickness: 1.5 mils. (40 µm)

### Flash off



5-10 minutes between coats



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#### Drying times



	70°F (20°C)	140°F (60°C)
Dry	1 hour	45 minutes

#### Recoatable with

Optional Topcoat with urethane after 60 minutes at 70°F (20°C).

#### Material usage

With recommended application, the theoretical material usage is  $\pm 497$  sq.ft./gl (m<sup>2</sup>/liter) per coat.

- *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances.*

#### Cleaning of equipment

Clean equipment with extra strong cleaning solvents or lacquer thinner

#### VOC

Chassis Black 2.92 lb/gal 351 g/l

#### Product storage

Store products unopened, and used products with closed lids preferably between 60°F-95°F (10°C-35°C)  
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

- Chassis Black: 2 years

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**IMPORTANT NOTE:** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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#### Head Office

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