



SCH-1
COLOR HORIZONS
USERS MANUAL



TECHNICAL INSTRUCTIONS FOR COLOR HORIZONS

Read all instructions before you begin your project. All **COLOR HORIZONS** products are for trained professionals and are not intended for use by the general public.

CHECKLIST:

Equipment needed for proper use of **COLOR HORIZONS** products include:

- Proper safety equipment (respirator, gloves, safety glasses, etc.)
- Please read the appropriate MSDS before using products.
- Proper ventilation and lighting.
- Air system (with dryer preferred).

NOTE: It is not recommended to apply paint in temperatures below 70°F (21°C).

For best results, use SEM as a complete system from start to finish on your custom paint job. Do not intermix products from other paint lines, as mixing different chemistries can cause problems. Follow the guidelines provided in this booklet, such as mix ratios, reducers, dry times and clearcoat times.

WARNING LABELS:

Read all label cautions and warnings on all products.

MSDS:

Material Safety Data Sheets are available online at www.semproducts.com.

VOC INFORMATION:

Coatings: Meets all California air quality district regulations using SRX EXEMPT REDUCERS and EXEMPT CATALYSTS where applicable.

PREPARATION:

Read all instructions before you begin! Poor preparation can cause serious problems with the finished product. **SPEND MORE TIME NOW, RATHER THAN A LOT MORE LATER.**

Aerosol versions of the prep and cleaning products in this document are compliant in most air quality districts. Aerosol versions are denoted by a (3) as the last digit of the part number.

Non-aerosol versions of the prep and cleaning products listed in this document, except **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER** and **3833() SCUFF & CLEAN** are not compliant in most VOC regulated areas. In some VOC regulated areas, these higher VOC solvent-based prep products can be dispensed legally from pump sprayers. Non-aerosol versions are denoted by a (1) for gallon and (4) for quart as the last digit of the part number. **CONSULT YOUR LOCAL REGULATIONS** before using any product involved in your coating operation.

38381 WORLD CLASS LOW VOC SURFACE CLEANER is compliant in most districts, but must be reduced with water for compliance in more stringent VOC regulated areas.

- All areas that require body filler, putties or fiberglass resins must be topcoated with **MLO1() METALOCK DTM HIGH BUILD PRIMER**, **TPOO() TRU PRIME TINTABLE** or **TPO1() TRU PRIME GRAY**. All finish sanding should be completed with 400-500 grit sand paper (preferably wet).
- Some base/candy colors are susceptible to bleed through or staining. Before applying any base/candy combination, a tinted sealer should be applied to seal the area and to assist in the coverage of base colors. See Sealer Tint Guide on page 2 for assistance on transparent colors.
- Any existing paint job over 6-8 mils should be sanded or stripped. Paint failure can occur from excessive film build.

CLEANUP:

Use appropriate cleaning materials compliant with the VOC regulations in your area.

TECHNICAL ASSISTANCE:

For any additional questions, please contact **SEM Products, Inc.**, at (800) 831-1122. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

COLOR HORIZONS MIX CLEAR

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



MCO1() MIX CLEAR is designed for intermixing all **COLOR HORIZONS CANDY CONCENTRATES, FLUORESCENT CONCENTRATES, PASTE PEARL CONCENTRATES, HYPER FX, LIGHTNING FX** and **FLAKES**. **MCO1()** is the perfect carrier for **COLOR HORIZONS** products offering excellent spray-ability, superior color holdout and minimal tape tracking on multiple tape outs.

DUE TO VOC REGULATIONS MCO1() MAY NOT BE USED AS AN INTER-COAT CLEAR IN CALIFORNIA.

PREPARATION:



Consult page 1 guidelines for prep and cleaning product VOC limitations.

Finish sand with 400 - 500 grit paper. Wipe down surface with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER** after sanding. When using over tinted sealer, allow sealer to flash for 5-10 minutes before applying.

MIXING:



See appropriate mixing ratios for **CANDY CONCENTRATES, FLUORESCENT CONCENTRATES, PASTE PEARL CONCENTRATES, HYPER FX, LIGHTNING FX** and **FLAKES**.

As an inter-coat clear, mix by volume:

| | | |
|---------|---|------------------------|
| 1 | : | 1 |
| MCO1() | : | SR/SRX SERIES REDUCER* |

Then add:

1 capful of **RCO2() REAL CATALYST** or **RCX2() REAL EXEMPT CATALYST***
per sprayable pint or 2 capfuls per sprayable quart.

*Due to VOC regulations, **RCX2() REAL EXEMPT CATALYST** and **SRX EXEMPT REDUCERS** must be used in California.

Adding **RCO2()** or **RCX2()** yields excellent early adhesion, superior chip resistance and is especially important in multi-layered designs which result in excessive film build.

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

APPLICATION:



Strain mixture into gun.

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|---|----------|------------|--------------------------|
| 1.3-1.4 | HVLP: 6-9 psi at the cap Non-HVLP: 25-45 psi | 6-8" | 2-3 Medium | 5-10 Minutes |

Generally, if appropriate reducer is used, **MCO1()** may be sanded in approximately 1 hour with 600 grit sand paper or a red/gray scuff pad. Artwork/stripping can be done before clearing. Allow to dry for at least 30 minutes before taping or doing artwork.

Pot life is 1 hour when **RCO2()** or **RCX2()** is used.

If more than 5 coats are applied, allow 30 minutes before clear coating.

Do not use **MCO1()** as a topcoat clear.

Dry times may vary depending on film build, shop conditions and reducer used.

COLOR HORIZONS BASE COLORS

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS BASE COLORS are vibrant, ready to reduce colors that may be clearcoated or used as basecoats under **COLOR HORIZONS CANDY CONCENTRATES**.

PREPARATION:



Read technical preparation; **BASE COLORS** are susceptible to staining or bleed through of body filler, putties and some primers. The project should be sealed with **MLO1() METALOCK DTM HIGH BUILD PRIMER** or **TPOO() TRU PRIME TINTABLE** close to the color of the basecoat before spraying basecoat. Remember, the sealer is not a “preventative coating for poor prep work.” It is only an adhesion promoter and will help in coverage of the basecoat. Using tinted sealer will improve hiding. “The top is only as good as the bottom!” See Sealer Tint Guide on page 2 for best results.

MIXING:



Shake all **BASE COLORS** at least 5 minutes before opening. All **BASE COLORS** are ready to reduce. **BASE COLORS** should be mixed 1:1 with appropriate **COLOR HORIZONS REDUCERS**.

Mix by volume:

| | | |
|----------------------------|---|--|
| 1 BASE COLOR | : | 1 SR/SRX SERIES REDUCER* |
|----------------------------|---|--|

Then add:

1 capful of **RCO2() REAL CATALYST** or **RCX2() REAL EXEMPT CATALYST***
per sprayable pint or 2 capfuls per sprayable quart.

*Due to VOC regulations, **RCX2() REAL EXEMPT CATALYST** and **SRX EXEMPT REDUCERS** must be used in California.

Adding **RCO2()** or **RCX2()** yields excellent early adhesion, superior chip resistance and is especially important in multi-layered designs which result in excessive film build.

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

APPLICATION:



Strain mixture into gun.

LARGE PROJECTS

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|----------------|--------------------------|
| 1.3-1.4 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 5-6" | 2-4 Medium Wet | 5-10 Minutes |

SMALL PROJECTS

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|----------------|--------------------------|
| 1.2-1.3 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 4-5" | 2-4 Medium Wet | 5-10 Minutes |

INCORRECT

Surface to be sprayed

- Wrist Not Flexible
- Arching Gun
- Uneven Coats

CORRECT

Surface to be sprayed

- Wrist Flexible
- Gun Travels Straight
- Even Coats

- Pot life is 1 hour when **RCO2()** or **RCX2()** is used.
- Always spray a test panel to confirm color and check for coverage.
- Overlap coats 50-75%.
- On large vehicles, use “full passes” when applying basecoat and candy colors. This will prevent dark or heavy edges on the ends of the panels.
- Do not apply heavy coats. Doing so will trap solvents and could cause splitting, cracking or solvent popping.
- Always allow plenty of flash time between coats.
- Allow 12-15 minutes before topcoating.
- Dry times may vary depending on film build, shop conditions and reducer used.
- Do not rush! The time you spend now will triple if you have to redo it.

COLOR HORIZONS CANDY CONCENTRATES

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS CANDY CONCENTRATES offer incredible depth and clarity when applied over any **COLOR HORIZONS** product and help achieve the “custom look” for any project.

PREPARATION:



Read technical preparation; **CANDY CONCENTRATES** are susceptible to staining or bleed through of body filler, putties and some primers.

NOTE: At this time, check your base color to insure it has flashed off properly and coverage is obtained. Make sure all prep work looks good and the base color is smooth. Any imperfections in the base will be intensified by the application of candy. This is the moment where you can “make or break” your custom paint job. If extra attention is needed, now is the time!

NOTE: Automotive candy finishes are vulnerable to UV exposure and may fade with time. To minimize the effects of UV exposure, **CANDY CONCENTRATES** may be mixed with **RC01() REAL CLEAR** rather than **MC01() MIX CLEAR**. The resulting finish may actually be richer and more vibrant than what is depicted on the **01003 COLOR HORIZONS CHIP CARD**. Additionally, **CANDY CONCENTRATES** should always be clear coated with **RC01() REAL CLEAR**. **RC01()** provides more UV protection than most clears designed for the collision repair industry. As a general rule, the more candy and clearcoat applied, the more UV protection you will have. Always spray a test panel to ensure the desired results.

MIXING:



Shake all **CANDY CONCENTRATES** thoroughly before use. All **CANDY CONCENTRATES** should be mixed with **MC01() MIX CLEAR** or **RC01() REAL CLEAR**.

To mix with **MC01() MIX CLEAR**:

First, mix by volume:

| | | |
|------------------|----------|--------------------|
| 8 | | 1 |
| MC01() | = | CANDY |
| MIX CLEAR | | CONCENTRATE |

Then, mix by volume:

| | | |
|----------------------|----------|----------------------|
| 1 | | 1 |
| CANDY/MC01() | = | SR/SRX SERIES |
| MIXTURE | | REDUCER* |

Then add:

1 capful of **RC02() REAL CATALYST** or **RCX2() REAL EXEMPT CATALYST***
per sprayable pint or 2 capfuls per sprayable quart.

Adding **RC02()** or **RCX2()** yields excellent early adhesion, superior chip resistance and is especially important in multi-layered designs which result in excessive film build.

To mix with **RC01() REAL CLEAR**:

First, mix:

| | | | | |
|-------------------|----------|---------------------|----------|----------------------|
| 4 | | 1 | | 1 |
| RC01() | = | RC02/RCX2() | = | SR/SRX SERIES |
| REAL CLEAR | | CATALYST* | | REDUCER* |

Then, mix by volume:

| | | |
|-------------------|----------|--------------------|
| 8 | | 1 |
| RC01() | = | CANDY |
| REAL CLEAR | | CONCENTRATE |
| ready to spray | | |

*Due to VOC regulations, **RCX2() REAL EXEMPT CATALYST** and **SRX EXEMPT REDUCERS** must be used in California.

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results..

COLOR HORIZONS CANDY CONCENTRATES

APPLICATION:



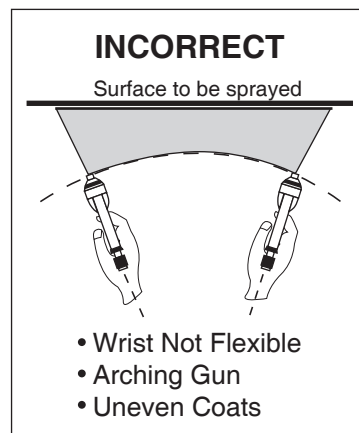
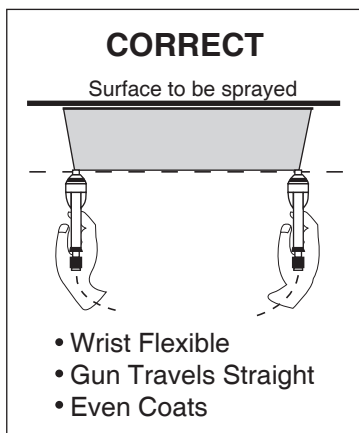
Strain mixture into gun.

LARGE PROJECTS

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|----------------|---|
| 1.3-1.4 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 5-6" | 4-7 Medium Wet | 5-10 Minutes using MC01() 10-15 Minutes using RC01() |

SMALL PROJECTS

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|----------------|---|
| 1.2-1.3 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 4-5" | 4-7 Medium Wet | 5-10 Minutes using MC01() 10-15 Minutes using RC01() |



PATTERN TEST:

Gun setup is critical to ensure a quality candy application.

Using a piece of masking paper, turn the air cap 90°, then spray material at 4-5" to check pattern.

The width of the pattern should be the same, i.e. 4" distance = 4" pattern width.

Your pattern should look like this  and not this  or 

Then return the air cap to the horizontal position.

- Pot life is 1 hour when **RC02()** or **RCX2()** is used.
- Always spray a test panel to confirm color and check for coverage.
- Always spray full passes when applying **CANDY CONCENTRATES**.
- Overlap coats 50-75%.
- Always allow plenty of flash time between coats.
- Dry times may vary depending on film build, shop conditions and reducer used.

NOTE: Take your time when applying **CANDY CONCENTRATES**. Try to cover all edges when spraying panels. Failure to do so may leave thin spots in the paint job. Moreover, try not to go back over the edges, as it could leave dark or heavy areas. Pay close attention to how many coats you are applying. Your test panels will be very beneficial in determining the appropriate number of coats to achieve your custom look.

IMPORTANT: Some **CANDY CONCENTRATES** will bleed. To avoid bleed-through onto artwork or graphics, use **RC01() REAL CLEAR** between **CANDY CONCENTRATES** and artwork.

COLOR HORIZONS FLUORESCENT CONCENTRATES

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS FLUORESCENT CONCENTRATES are intense, eye-catching colors that are great for flame jobs, graphics on motorcycles, race cars or as a base for candy colors and pearls. All **FLUORESCENT CONCENTRATES** should be applied over **02044 BRIGHT WHITE** for maximum brightness.

NOTE: FLUORESCENT CONCENTRATES have a short lifetime because of their limited "light-fastness" in the sun and are not recommended for overall refinishing or when long life of the color application is required.

PREPARATION:



Read technical preparation; **FLUORESCENT CONCENTRATES** are susceptible to staining or bleed through of body filler, putties and some primers. The project must be sealed with **MLO1() METALOCK DTM HIGH BUILD PRIMER** or **TPO0() TRU PRIME TINTABLE** close to the color of the basecoat before spraying basecoat. See Sealer Tint Guide on page 2 for best results.

MIXING:



Shake all **FLUORESCENT CONCENTRATES** thoroughly before use. All **FLUORESCENT CONCENTRATES** should be mixed 4:1 with **MCO1() MIX CLEAR** before reducing. To improve fluorescent coverage, you may tint **02044 BRIGHT WHITE** with desired **FLUORESCENT CONCENTRATE**, usually 10% before reducing.

First, mix by volume:

| | | |
|------------------|---|--------------------|
| 4 | = | 1 |
| MCO1() | | FLUORESCENT |
| MIX CLEAR | | CONCENTRATE |

Then, mix by volume:

| | | |
|----------------------------|---|----------------------|
| 1 | = | 1 |
| FLUORESCENT/MCO1() | | SR/SRX SERIES |
| MIXTURE | | REDUCER* |

Then add:

1 capful of **RCO2() REAL CATALYST** or **RCX2() REAL EXEMPT CATALYST***
per sprayable pint or 2 capfuls per sprayable quart.

*Due to VOC regulations, **RCX2() REAL EXEMPT CATALYST** and **SRX EXEMPT REDUCERS** must be used in California.

Adding **RCO2()** or **RCX2()** yields excellent early adhesion, superior chip resistance and is especially important in multi-layered designs which result in excessive film build.

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

APPLICATION:



Strain mixture into gun.

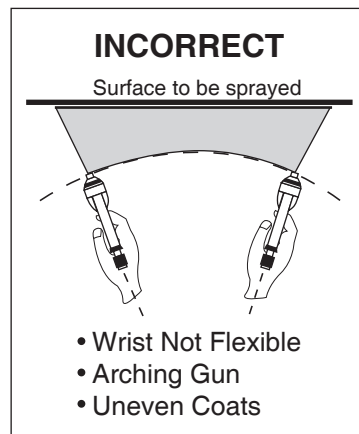
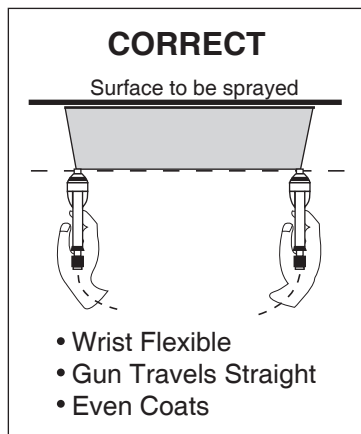
LARGE PROJECTS

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|----------------|--------------------------|
| 1.3-1.4 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 5-6" | 4-5 Medium Wet | 5-10 Minutes |

SMALL PROJECTS

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|----------------|--------------------------|
| 1.2-1.3 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 4-5" | 4-5 Medium Wet | 5-10 Minutes |

COLOR HORIZONS FLUORESCENT CONCENTRATES



PATTERN TEST:

Gun setup is critical to ensure a quality application and to prevent striping or streaking of the color. Using a piece of masking paper, turn the air cap 90°, then spray material at 4-5" to check pattern. The width of the pattern should be the same, i.e. 4" distance = 4" pattern width.

Your pattern should look like this



and not this



or



Then return the air cap to the horizontal position.

- Pot life is 1 hour when **RC02()** or **RCX2()** is used.
- Always spray a test panel to confirm color and check for coverage.
- Overlap coats 50-75%.
- Do not apply more than 6 coats of **FLUORESCENT CONCENTRATES**.
- All **FLUORESCENT CONCENTRATES** must be topcoated with clear coat or candy followed by clear coat.
- Always allow plenty of flash time between coats.
- Dry times may vary depending on film build, shop conditions and reducer used.

NOTE: DO NOT DRY IN THE SUNLIGHT! The first 4-5 hours of dry time is the most critical. Special care is needed to prevent fading or discoloration in these early stages.

COLOR HORIZONS LIGHTNING FX, HYPER FX AND FLAKES

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS LIGHTNING FX, HYPER FX and **FLAKES** will give your custom paint job a “pop!” **LIGHTNING FX** are glass pearl pigments with exceptional brilliance, transparency and reflectivity.

HYPER FX contain Xirallic® pigments which intensify the level of color and add more glitter than traditional dry pearls.

COLOR HORIZONS FLAKES are precision cut chips; resin coated with light-fast color pigments. **06014 MINI GOLD** and **06024 MINI SILVER** are 100 microns while all other flakes are 1/64” in size. **FLAKES** are fade and solvent resistant to provide the maximum in lasting brilliance.

LIGHTNING FX, HYPER FX and **FLAKES** can be mixed with **MC01() MIX CLEAR, BASE COLORS, HYPERBASE COLORS, CANDY CONCENTRATES** or **RC01() REAL CLEAR**.

PREPARATION:



Read technical preparation; **COLOR HORIZONS LIGHTNING FX, HYPER FX** and **FLAKES** are susceptible to staining or bleed through of body filler, putties and some primers.

MIXING:



The mix ratio for **LIGHTNING FX** and **HYPER FX** is based on the painter’s preferences.

Recommended starting points:

LIGHTNING FX: 10 grams (roughly two tablespoons) per ready to spray quart

HYPER FX: 5 grams (roughly one tablespoon) per ready to spray quart

FLAKES: 10 grams (roughly one tablespoon) per ready to spray quart
Up to 100 grams for a heavy flake appearance.

Then add:

1 capful of **RC02() REAL CATALYST** or **RCX2() REAL EXEMPT CATALYST***
per sprayable pint or 2 capfuls per sprayable quart.

*Due to VOC regulations, **RCX2() REAL EXEMPT CATALYST** and **SRX EXEMPT REDUCERS** must be used in California.

Adding **RC02()** or **RCX2()** yields excellent early adhesion, superior chip resistance and is especially important in multi-layered designs which result in excessive film build.

APPLICATION:



Strain mixture into gun.

| <u>PRODUCT</u> | <u>FLUID TIP</u> |
|-----------------------------|------------------|
| LIGHTNING FX | 1.4 |
| HYPER FX | 1.4 |
| 06014 - 06024 FLAKES | 1.5 - 2.2 |
| 06034 - 06154 FLAKES | 2.2 - 3.0 |

- Always spray a test panel to insure the desired look.
- Lighter bases will require more material.
- For best results, use a siphon type gun with an agitator cup. **LIGHTNING FX, HYPER FX** and **FLAKES** will settle quickly and will build up in the gun tip when using gravity type guns. When using gravity type guns, be sure to shake product in gun periodically to reduce settling and ensure even product distribution.
- Pot life is 1 hour when **RC02()** or **RCX2()** is used.

COLOR HORIZONS PASTE PEARL CONCENTRATES

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS PASTE PEARL CONCENTRATES are formulated in paste form for easy mixing with **MC01() MIX CLEAR**. For the ultimate custom look, mix **PASTE PEARL CONCENTRATES** with **BASE COLORS, HYPERBASE COLORS, CANDY CONCENTRATES** or **RC01() REAL CLEAR**.

PREPARATION:



Read technical preparation; **PASTE PEARL CONCENTRATES** are susceptible to staining or bleed through of body filler, putties and some primers.

MIXING:



Mix **PASTE PEARL CONCENTRATES** thoroughly before use.

Recommended starting points:

When applying **PASTE PEARL CONCENTRATES** over a dark base, add ¼ to ½ tablespoon of **PASTE PEARL CONCENTRATES** to one quart of ready to spray **MC01() MIX CLEAR**.

When applying **PASTE PEARL CONCENTRATES** over a light base or candy, add 1 to 2 tablespoons of **PASTE PEARL CONCENTRATES** to one quart of ready to spray **MC01() MIX CLEAR**.

Then add:

1 capful of **RC02() REAL CATALYST** or **RCX2() REAL EXEMPT CATALYST***
per sprayable pint or 2 capfuls per sprayable quart.

*Due to VOC regulations, **RCX2() REAL EXEMPT CATALYST** and **SRX EXEMPT REDUCERS** must be used in California.

Adding **RC02()** or **RCX2()** yields excellent early adhesion, superior chip resistance and is especially important in multi-layered designs which result in excessive film build.

APPLICATION:



Strain mixture into gun.

LARGE PROJECTS

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|----------------|--------------------------|
| 1.3-1.4 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 5-6" | 2-3 Medium Wet | 5-10 Minutes |

SMALL PROJECTS

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|----------------|--------------------------|
| 1.3-1.4 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 4-5" | 2-3 Medium Wet | 5-10 Minutes |

- Pot life is 1 hour when **RC02()** or **RCX2()** is used.
- Always spray a test panel to confirm color and check for coverage.
- Always spray full passes when applying **PASTE PEARL CONCENTRATES**.
- Overlap coats 50-75%.
- Do not apply heavy coats, as overcrowding of platelets will reduce the iridescent effect.
- Always allow plenty of flash time between coats.
- Dry times may vary depending on film build, shop conditions and reducer used.
- Apply a candy color or clearcoat over **PASTE PEARL CONCENTRATES**.

COLOR HORIZONS HOT ROD BLACK

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



HRO10 HOT ROD BLACK KIT is a matte finish 2K single stage topcoat system that provides outstanding color retention, excellent sprayability and superior mar resistance to create the ultimate custom look when painting accent stripes, hoods or entire vehicles.

PREPARATION:



Consult page 1 guidelines for prep and cleaning product VOC limitations.

Prime surface with **MLO1() METALOCK DTM HIGH BUILD PRIMER**, **TPO0() TRU PRIME** or **TPO1() TRU PRIME TINTABLE**. Apply according to directions. Clean with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**.

MIXING:



Mix by volume:

| | | |
|--------------|--------------|--------------|
| 4 | 1 | 1 |
| HRO14 | HRC06 | HRR06 |

NOTE: Use of additives other than **HRC06 HOT ROD CATALYST** and **HRR06 HOT ROD REDUCER** are not recommended and will affect both the appearance and performance of **HOT ROD BLACK**.

APPLICATION:



Strain mixture into gun.

| Fluid Tip | Air Pressure | Distance | Coats | Flash Time between Coats |
|-----------|--|----------|--------------|--------------------------|
| 1.3-1.4 | HVLP: 8-10 psi at the cap Non-HVLP: 45-60 psi | 5-7" | 2 Medium Wet | 10-15 Minutes |

Allow final coat of **HRO10** to flash for 10-15 minutes before baking for 30 minutes at 120°F (49°C), or air dry overnight.

NOTE: It is normal for the second coat of **HRO10** to remain glossy as it cures. The gloss will subside to a matte finish within 16 hours.

Dry times may vary depending on film build and shop conditions.

NOTE: Always spray a test panel to ensure desired gloss level. Variations in temperature and gun set up can affect the final gloss of **HOT ROD BLACK**.

Do not re-coat after panel has been baked or air-dried without first sanding with 320 grit paper.

Do not buff or polish.