

Autocryl Rally Black™

Autocryl Rally Black is a low gloss black topcoat for use whenever a black eggshell finish is required. Rally Black's low gloss finish makes it an ideal choice for use in a non-glare finish. Autocryl Rally Black is supplied both as an aerosol ready to use product as well as separate components for mixing.



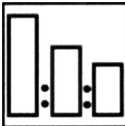
Safety Considerations

Use suitable personal protection.
AkzoNobel recommends the use of a fresh air supply respirator.
Refer to the product Safety Data Sheet (SDS) for more complete safety information.



Surface Preparation

- Existing Finishes
 - #P500 - #P600, dry
 - #P600 - #P800, wet



#25 Stick

Mix	By Volume
100	Parts Autocryl Rally Black
33	Parts XP Hardener
50	Parts HP Reducer



Spray-Gun Set-Up

- 1.3 – 1.5mm HVLP Gravity
- 1.3 – 1.5mm Compliant

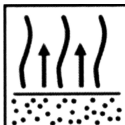
Application Air Pressure

- HVLP – 10 psi (<0.7 bar) at cap maximum.
- Consult manufacturer specifications.



Application

2 x 1 coats



Flash Between Coats at 70°F (21°C)

- 5-10 minutes

Flash Before Force Drying at 70°F (21°C)

- 5-10 minutes



Air Drying at 70°F (21°C)

- Dry to Handle in 8 hours

Dependent on film weight and air flow.

Force Drying at 140°F (60°C)

- Dry to Handle in 30 minutes

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information.

Description

Autocryl Rally Black is a low gloss black topcoat for use whenever a black eggshell finish is required. Rally Black's low gloss finish makes it an ideal choice for use in a non-glare finish. Autocryl Rally Black is supplied both as an aerosol ready to use product as well as separate components for mixing.

Suitable Substrates

- All existing finishes sanded with #P500 to #P600 grit paper dry or #P600 to #P800 grit paper wet
- All Sikkens preparatory products

Products and Additives

Products	<ul style="list-style-type: none"> • Autocryl Rally Black • Autocryl Rally Black Aerosol 	<ul style="list-style-type: none"> - Item #319978 - Item #390991
Hardeners	<ul style="list-style-type: none"> • Sikkens XP Hardener 	<ul style="list-style-type: none"> - Item #398766
Reducers	<p>Sikkens High Performance Reducers</p> <ul style="list-style-type: none"> • Extra Slow • Slow • Medium • Fast 	<ul style="list-style-type: none"> - Item #391066 - Item #391064 - Item #391062 - Item #391059

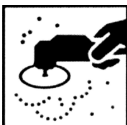
✓ Gallon fill size listed; other sizes available.

Basic Raw Materials



- Autocryl Rally Black
 - Hardeners
- Hydroxyl acrylic resins
 - Polyisocyanate resin

Substrate Preparation



Sanding Preparation

Existing Finishes

Dry Sanding

#P500 – #P600

Wet Sanding

#P600 – #P800



Surface Cleaning – Prior to Paint Application

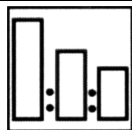
- Clean with Sikkens M600, Autoprep UltraPrep Surface Cleaner.

Product Agitation



Autocryl Rally Black should be thoroughly agitated before use.

Mixing – General



#25 Stick

Mix	By Volume
100	Parts Autocryl Rally Black
33	Parts XP Hardener
50	Parts HP Reducer

Viscosity When Mixed

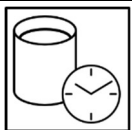


DIN #4

16-17
seconds

Measured with a DIN #4 viscosity cup at 70°F (20°C).

Pot-Life When Mixed



Product Mix

Autocryl Rally Black

70°F (20°C)

2 hours

Spray Gun Set-Up



✓ Consult spray gun manufacturer instructions for spray gun pressure specifications.

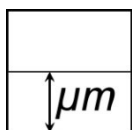
Spray Gun	Fluid Tip	Application Pressure
• HVLP Gravity Feed	1.3-1.5 mm	HVLP – 10 psi (<0.7 bar) at cap, maximum.
• Compliant Gravity Feed	1.3-1.5 mm	Consult manufacturer specifications.

Application



- Apply 2 wet coats or 1 single and 1 double coat.
- Allow a flash off time between coats of 5-10 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available airflow.

Film Thickness – Using Suitable Application



- 1 Coat will achieve a thickness 1.2-1.5 mils (30-38µm) dry.

Drying / Curing Time



Dry to Handle

70°F (21°C)

140°F (60°C)

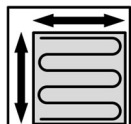
8 hours

30 min.

✓ Drying times are stated a recommended application method, film thickness and object temperature.

Cleaning of Equipment

Clean equipment following local and federal regulations. In compliant localities, use Sikkens LV Cleaning Solvent or high quality solvent borne gun cleaner. For national rule regions, use Sikkens Cleaning Solvent.

Theoretical Coverage

Actual coverage is dependent on many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others.

- Theoretical Coverage: 140 square feet per liter of unmixed paint per single coat.

VOC / Regulatory Information

Ready to spray VOC:

- 100:33:50 ratio with XP Hardener and HP Reducer 4.1 lbs/gal (484 g/L)

Product Storage

Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).

Autocryl Rally Black (Liter) – 4 years

AkzoNobel Inc., North America

Address: 1845 Maxwell Street – Troy, MI USA

Telephone: 800.618.1010

FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT

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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