

DESCRIPTION

Smooth Coat- Black matches smooth, satin black finishes on automotive plastic parts.

FEATURES

- Consistent, satin finish
- Mar resistant
- Resistant to chalking and fading
- 2.8 voc compliant
- Excellent UV stability and durability
- Easy to apply

SUITABLE SUBSTRATES

PROPERLY PREPPED (SEE PREPARATION SECTION)

- Properly prepped, primed or painted surfaces

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
4P-15-024	Smooth Coat – Black	Black	Flat Top Qt.
4P-15-074	Smooth Coat – White Tint	White	Flat Top Qt.
4P-15-086	Smooth Coat Activator	Clear	½ Pint
4P-15-096	Smooth Coat Reducer	Clear	½ Pint



Check local VOC regulations to ensure compliance of all products in your area.

PRODUCT SPECIFICATIONS

RTS VOC:	Max 2.72 #/gal (326 g/l)
Pot life:	60 minutes @ 70°F (21°C) and 50% RH
Coverage:	248 sq.ft./gal @ 2 mils
Flash time:	10 – 15 minutes
Purge before baking:	30 minutes
Bake time:	30 minutes @ 160°F (71°C)
Air dry time:	16 hours
Tape time:	24 hours @ 70°F (21°C)

If applying to a non-automotive substrate, consult local VOC regulations.

Always wear OSHA required (PPE) Personal Protection Equipment as outlined on the SDS and product label to ensure your safety.



PREPARATION

FLEXIBLE, OLEFIN-BASED PLASTIC

1. For best results, prime surface with **Plastic Primer** according to directions.

MIXING:

Shake or stir thoroughly. Mix by volume:

4 Parts	1 Part	1 Part
Smooth Coat - Black	Smooth Coat Activator	Smooth Coat Reducer

Note: Use of additives other than **Smooth Coat Activator** and **Smooth Coat Reducer** are not recommended and will affect the appearance and performance of **Smooth Coat - Black**.

Note: **Smooth Coat – Black** may be tinted with **Smooth Coat – White Tint** in 5% increments to achieve varying shades of gray. Mix products together prior to the addition of **Smooth Coat Activator** and **Smooth Coat Reducer**.



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APPLICATION

Set air pressure to:	40 – 45 psi for non-HVLP
	8 – 10 psi at the cap for HVLP equipment

1. Use spray applicator equipped with a 1.4 nozzle. Spray one medium-wet coat keeping the applicator 5 7" from the surface and minimum overlap of 75%. Allow to flash dry, approximately 10 – 15 minutes.
2. Spray a second identical medium-wet coat and allow an additional 30 minutes before baking for 30 minutes @ 140°F (60°C), or air dry for 16 hours.

Note: Always spray a test panel to ensure desired gloss level. Variations in temperature and applicator set up can affect the final gloss of **Smooth Coat - Black**.

Do not recoat after part has been baked or air-dried without first sanding with P400 - P600 grit.



CLEAN UP

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



STORAGE

Products should be stored between 60 – 80°F (16 – 27°C). The shelf life for **Smooth Coat - Black**, **Smooth Coat – White Tint**, **Smooth Coat Catalyst** and **Smooth Coat Reducer** is 3 years when stored under ideal conditions.

RELATED PRODUCTS

Part:	Product:	Size:
4P-15-034	Plastic Primer	Flat Top Quart



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products in your area.

Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. 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.

Disclaimer:

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