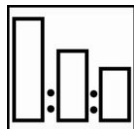


Rally Black

FOR PROFESSIONAL USE ONLY

Description

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 as a non-glare finish.



3 Rally Black
1 Autocryl Plus LV Hardener
2 Autocryl Plus LV Thinner



Use Sikkens measuring stick
Nr. 15 Green

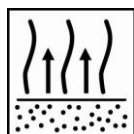


Spray gun set-up:
1.2-1.5 mm

Application pressure:
1.7-2.2 bar at the air inlet.
HVLP max 0.6-0.7 bar at the air cap.



2 x 1 coat



Between coats:
6-10 minutes at 20°C

Before curing:
6-10 minutes at 20°C



| Product: | 20°C | 60°C |
|------------------------------|---------|------------|
| Autocryl Plus LV Thinner | 8 hours | 35 minutes |
| Autocryl Plus LV Accelerator | 2 hours | 15 minutes |



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

Read complete TDS for detailed product information



Rally Black

FOR PROFESSIONAL USE ONLY

Description

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 as a non-glare finish.

Suitable substrates

Existing finishes
Glass Reinforced Polyester laminates (GRP)
All Sikkens preparatory products

Product and additives

Rally Black

Hardeners Autocryl Plus LV Hardener
P Hardeners (P25/P35)

Thinners Autocryl Plus LV Thinner

Plus Reducer Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.
Plus Reducer Medium; spot and panel repairs and large areas, temperature range: 20°C-30°C.
Plus Reducer Slow; larger areas and complete paint jobs, temperature range: 25°C-35°C.
Plus Reducer Extra Slow; to use in extremely hot temperatures, temperature range: above 35°C.

Accelerators Autocryl Plus LV Accelerator; spot and panel repairs at 15°C-25°C.

Additives Autocryl Structure Paste: additive to create different surface textures.

Basic raw materials

Rally Black: polyester and acrylic resin combination



Rally Black

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Surface preparation



Surface cleaning, remove any surface contamination prior to sanding using an appropriate surface cleaner.
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



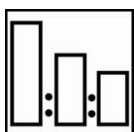
Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Surface cleaning, remove any surface contamination prior to the application of Rally Black using an appropriate surface cleaner.

Mixing



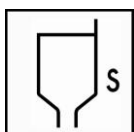
- 3 Rally Black
- 1 Autocryl Plus LV Hardener
- 2 Autocryl Plus LV Thinner

Stir the Rally Black thoroughly before mixing by volume with measuring stick nr. 15

- 100 Rally Black
- 50 Hardener P25-P35
- 100 Plus Reducers

Stir the Rally Black thoroughly before mixing by volume

Viscosity



Rally Black - Autocryl Plus LV Hardener;
Rally Black - Hardener P25-P35;

16.6 seconds - DIN Cup 4 at 20°C.
13.3 seconds - DIN Cup 4 at 20°C.

Spray gun set-up / application



Spray gun

Gravity feed

Fluid tip – set-up

1.2-1.5 mm

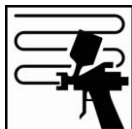
Application pressure

1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

Rally Black

FOR PROFESSIONAL USE ONLY

Application process & blending



- Apply a medium closed coat, allowing for a 6-10 minutes flash-off time at 20°C.
Next, apply a full coat, allowing for a 6-10 minutes flash-off time before baking at 20°C.
- *In case of application to larger areas a minimal flash-off time between coats is required.*
 - *Recoat with itself after full drying cycle, sanding becomes necessary after 24 hours*

Pot-life

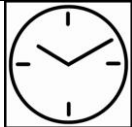
| | |
|--|--------------------|
| Autocryl Plus LV Hardener / Autocryl Plus LV Thinner | 3 hours at 20°C. |
| Autocryl Plus LV Hardener / Autocryl Plus LV Accelerator | 1 ½ hours at 20°C. |
| Plus Hardeners P25 | 1 ½ hours at 20°C. |

Film thickness

By using the recommended application; 40 µm

Drying times

Allow a 5 minute flash-off time at 20°C. before moving the car into a pre-heated drying oven (booth) at 60°C.
All drying times relate to standard application and object temperature.
Consider the time required for the spraybooth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.


|  | | Autocryl Plus LV Thinner | Autocryl Plus LV Accelerator |
|---|---------------|--------------------------|------------------------------|
| | | | |
| 20°C | Dust free | 15 minutes | 15 minutes |
| | Dry to handle | 8 hour | 2 hours |
| 60°C | Dust free | 5 minutes | 5 minutes |
| | Dry to handle | 35 minutes | 15 minutes |



Rally Black

FOR PROFESSIONAL USE ONLY

Drying times (continued)

| | | | |
|---|--|--------------------------------------|--|
|  | | P25 Hardener Plus Reducer | P25 Hardener Plus Accelerator |
|---|--|--------------------------------------|--|

| | | | |
|-------------|---------------|------------|------------|
| 20°C | Dust free | 20 minutes | 15 minutes |
| | Dry to handle | 5 ½ hour | 1½ hours |

| | | | |
|-------------|---------------|------------|------------|
| 60°C | Dust free | 5 minutes | 5 minutes |
| | Dry to handle | 25 minutes | 15 minutes |

| | | | |
|--|--|--|--|
|  | | Plus 35 Hardener Plus Reducer | |
|--|--|--|--|

| | | | |
|-------------|---------------|------------|--|
| 20°C | Dust free | 20 minutes | |
| | Dry to handle | 8 hours | |

| | | | |
|-------------|---------------|------------|--|
| 60°C | Dust free | 7 minutes | |
| | Dry to handle | 35 minutes | |



Dry to handle after approximately 10 minutes.
Allow 5 minutes flash-off prior to infra red curing
The panel must not reach a temperature above 100°C while curing.
For additional infra red drying information; see TDS S9.01.01

Material usage

By using the recommended application the theoretical material usage is ± 9m²/liter RTS mixture.

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

Cleaning of equipment

Sikkens Solvents or Guncleaners



Rally Black

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VOC

The EU limit value for this product (product category: IIB. e) in ready to use form is max. 840 g/liter of VOC.
The VOC content of this product in ready to use form is max. 676 g/liter.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

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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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