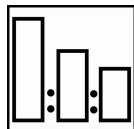


Rally Black

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



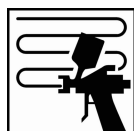
Use Sikkens measuring stick

15 Green

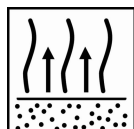


Spray gun set-up:
1.2-1.5 mm

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

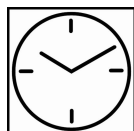


2 x 1 coat



Between coats:
6-10 minutes at 20°C

Before curing:
6-10 minutes at 20°C



Autocryl Plus LV Thinner
Autocryl Plus LV Accelerator

20°C
8 hours
2 hours

60°C
35 minutes
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
P25 Hardener
P35 Hardener

spot and panel repairs at 20°C-30°C
larger areas and overall refinishing at 20°C-40°C

Thinners

Autocryl Plus LV Thinner

Plus Reducer

Plus Reducer Fast:
Plus Reducer Medium:
Plus Reducer Slow:
Plus Reducer Extra Slow:

spot and panel repairs, temperature range: 15°C-25°C.
spot and panel repairs and large areas, temperature range: 20°C-30°C.
larger areas and complete paint jobs, temperature range: 25°C-35°C.
temperature range: above 35°C.

Accelerators

Autocryl Plus LV Accelerator:

spot and panel repairs at 15°C-25°C.

Additives

Autocryl Structure Paste Fine:

See TDS 6.57

Basic raw materials

Rally Black: polyester and acrylic resin combination

Surface preparation



Remove contamination using an appropriate cleaner



Final sanding step P500
For detailed surface preparation see TDS S8.06.02



Final sanding step P1000
For detailed surface preparation see TDS S8.06.02

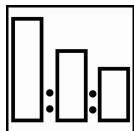


Remove contamination using an appropriate cleaner

Rally Black

FOR PROFESSIONAL USE ONLY

Mixing



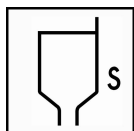
- 3 Rally Black
- 1 Autocryl Plus LV Hardener
- 2 Autocryl Plus LV Thinner

Use measuring stick nr. 15

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

Use measuring stick nr. 1

Viscosity



Autocryl Plus LV Hardener:
Hardener P25-P35:

16-17 seconds DIN Cup 4 at 20°C.
13-14 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

Application process & blending



Apply a medium closed coat, allow for a 6-10 minutes flash-off time and apply a full coat.
Flash off 6-10 minutes before baking.
Recoat with itself within 24 hours
For blending, see TDS S8.01.01.

Pot-life

Autocryl Plus LV Hardener / Autocryl Plus LV Thinner
Autocryl Plus LV Hardener / Autocryl Plus LV Accelerator
Plus Hardeners

3 hours at 20°C.
1 ½ hours at 20°C.
1 ½ hours at 20°C.

Film thickness

40 µm

Rally Black

FOR PROFESSIONAL USE ONLY

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.

	20°C		60°C	
	Dust dry	Dry to handle	Dust dry	Dry to handle
Plus LV Accelerator	15 minutes	2 hours	5 minutes	15 minutes
Plus LV Thinner	15 minutes	8 hours	5 minutes	35 minutes
P25 Hardener	20 minutes	5.5 hours	5 minutes	25 minutes
P35 Hardener	20 minutes	8 hours	7 minutes	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 $\pm 9 \text{ m}^2/\text{liter}$ 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 Solvent or solventborne guncleaners

VOC

2004/42/IIIB(e)(840)640

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. 640 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

Rally Black

FOR PROFESSIONAL USE ONLY

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Tel: +31(0)71308-6944

FOR PROFESSIONAL USE WITH SUITABLE HS&E 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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