Technical Data Sheet
Classic Hot Rod Color (Flat/Satin)

Description:
Classic Hot Rod Colors are a 2 component acrylic urethane coating. For ***FLAT*** colors mix 4 parts flat color with 1 part **501 Activator** or **502 Slow Activator.** For ***Satin*** colors use **401 Activator** or **402 Slow Activator.** **Classic Hot Rod Color** is an excellent coating for restoration, striping, coating frames, engine compartments, or any place a primer like coating is needed. This coating formulated to withstand the same atmospheric conditions as any single-stage urethane system.

Features:
- Even Flat Finish
- Excellent leveling
- Excellent adhesion
- Excellent chemical resistance
- Flexible
- Long-term durability
- Guaranteed performance

Compatible Surfaces:
- Rigid plastics
- Self-etch and epoxy primers
- Polyester and urethane primers
- OEM finishes

Instructions:
Make sure product is at room temperature 72˚F (22.2˚C) before mixing

Gun Setup:

Conventional Gravity	1.3mm -1.4mm	40-45 psi @ gun
Siphon	1.3mm -1.4mm	40-45 psi @ gun
HVLP Gravity	1.3mm -1.4mm	8-10 psi @ gun

**Fluid Adjustment for 1.3 mm nozzle—turn out 3 full turns*
**Fluid Adjustment for 1.4 mm nozzle—turn out 2 ½ turns*

Preparation:
Surface should be cleaned of all grease, oil, dirt, rust, etc before applying **Classic Hot Rod Color.** If necessary clean surface with an engine cleaner to remove heavy deposits of grease and oil. Wash area with soap and warm water. Thoroughly clean area with **Excel 900 Solvent Final Clean or Excel 905 Waterborne Cleaner. Waterborne Cleaner** must be used where VOC restrictions apply.

Cold Rolled Steel, Galvanized Steel & Galvaneal:
Sand area with 180-220 grit sandpaper. Clean again with **Excel 900 Solvent Final Clean** or **Excel 905 Waterborne Cleaner.**

Aluminum: ***Do not use coarse grit sandpaper.***
Scuff surface with a red scuff pad or equivalent. Clean again with **Excel 900 Solvent Final Clean** or **Excel 905 Waterborne Cleaner.**

Apply Pre-treatment primer and allow to cure. Apply primer surfacer and allow to cure. Sand primer surfacer with 180-220 grit sandpaper. If applying a sealer over the primer surfacer, finish sand with 320-400 grit sandpaper. If applying **Classic Hot Rod Color** directly over the primer surfacer, finish sand with 400-500 grit sandpaper. **Classic Hot Rod Color** can also be applied directly over a pre-treatment primer (Self-Etch primer and Epoxy Primer).

#40004 Classic 2.8 VOC Hot Rod Black Satin (Quart)	#41004 Classic Hot Rod Black Flat (Quart)
#40001 Classic 2.8 VOC Hot Rod Black Satin (Gallon)	#41001 Classic Hot Rod Black Flat (Gallon)
#40116 Classic 2.8 VOC Hot Rod Black Activator - Regular (1/2 Pt.)	#41116 Classic Hot Rod Black Activator - Regular (1/2 Pt.)
#40104 Classic 2.8 VOC Hot Rod Black Activator - Regular (Quart)	#41104 Classic Hot Rod Black Activator - Regular (Quart)
#40216 Classic 2.8 VOC Hot Rod Black Activator - Slow (1/2 Pt.)	#41216 Classic Hot Rod Black Activator - Slow (1/2 Pt.)
#40204 Classic 2.8 VOC Hot Rod Black Activator - Slow (Quart)	#41204 Classic Hot Rod Black Activator - Slow (Quart)

Mixing:

Shake well before mixing. Mix 4 parts **Classic Hot Rod Color** to 1 part Activator according to temperature and area.

5.0 V.O.C. Compliant		**2.8 V.O.C. Compliant**	
501	Hot Rod Activator	401	Hot Rod Activator
502	Hot Rod Slow Activator	402	Hot Rod Slow Activator

Special Hot Weather Note:

For spray temperatures over 100˚F (37.8˚C) add 1 oz. of ***Urethane Retarder*** per sprayable quart of ***Classic Hot Rod Color*** to improve flow, leveling and through cure.

APPLICATION:

1. Apply 1 full wet coat followed by 1 medium coat. Allow 5-10 minutes flash time between coats.

Dry Times:	
Dust Free:	10-15 minutes depending on temperature and activator selection
Tack Free:	10-15 minutes
Force Dry:	10 minutes @ 120˚F (49˚C)
Delivery:	Air Dry 6-8 hours
Bake:	After cool down
Time to stripe:	
Air Dry	6-8 hours (special care should be taken for first 24 hours)
Bake	1 hour after cool down
Time to decal:	
Air Dry	24 hours
Bake	24 hours
Time to recoat	
Air Dry	3-4 hours @ 70˚F
Bake	After cool down

If recoating after 24 hours, scuff sand with 1200-1500 grit sandpaper before recoating.

TIPS FOR SUCCESS:

For higher gloss apply 2 full wet coats instead of 1 full wet coat followed by 1 medium coat.

TECHNICAL DATA

Color	
Activator/Hardener	5.0 V.O.C. / 2.8 V.O.C. 501/402 502 Slow / 401 Slow
Reducer	If needed, 5 – 10% Urethane Grade Reducer for Temp and size of job
Mix Ratio	4 : 1
Pot Life	1 hr. @ 72ºF (22.2°C) 50% RH
Number of Coats	1 Fill Wet Coat followed by 1 medium wet coat
Flash Time—Air Dry	5 – 10 minutes
Force Dry	5 – 10 minutes
Dust Free	10 – 15 minutes
Dry to Sand 70˚F (21˚C) 50% RH	N/A
Delivery–Air Dry	6 – 8 hours @ 72°F (22.2°C)
Force Dry	10 minutes @ 120°F (49°C)
Force Dry (metal temperature)	10 minutes @ 120°F (49°C)
Gun Set-Up Gravity Feed (HVLP)	1.3mm – Turn out 3 full turns 1.4mm – Turn out 2 1/2 full turns
Air Pressure @ Gun, HVLP	8 – 10 psi
Air Pressure @ Applicator Gun	40 -45 psi
Dry Film Thickness / coat (DFT)	N/A
Regulatory Limits	
Regulatory V.O.C. Actual V.O.C. Sprayable V.O.C	Refer to product MSDS
%Solids Sprayable by Weight	Refer to product MSDS
Coverage Sq. Ft. / gal @ 1 mil*	Refer to product MSDS
Package	
Hot Rod Colors	Gallons / Quarts
Activators	Quarts / ½ pints
Number per case	2 – Gallons / 6 - Quarts 6 32 oz. activators / 6 – ½ pint activators
Shelf Life	12 months