



Matte Black and Matte Clear

(IMP 2500/2501/2502) & (IMP3820/3821)

DESCRIPTION:

Matte Black is a 2 component acrylic urethane coating. For 5.0 areas mix 4 parts flat color with 1 part **2501 Activator** or **2502 Slow Activator**.

Mix 6 parts 3820 Clearcoat to 1 part 3821 Activator to achieve a flat finish.
Mix 5 parts 3820 Clearcoat to 1 part 3821 Activator to achieve an eggshell finish. Mix 4 parts 3820 Clearcoat to 1 part 3821 Activator to achieve a semi-gloss finish.

Matte Black and Matte Clear are 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 **Matte Black or Matt Clear**. 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 Wax and Grease remover.

Cold Rolled Steel, Galvanized Steel & Galvaneal:

Sand area with 180-220 grit sandpaper. Clean again with **Wax and grease remover**

Aluminum: Do not use coarse grit sandpaper.

Scuff surface with a red scuff pad or equivalent. Clean again with Wax and grease remover.

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 **Matte Black** directly over the primer surfacer, finish sand with 400-500 grit sandpaper. **Hot Rod Color** can also be applied directly over a pre-treatment primer (Self-Etch primer and Epoxy Primer).

MIXING:

Shake well before mixing. Mix 4 parts **Matte Black** to 1 part Activator according to temperature and area.

Technical Data Sheet

5.0 V.O.C. Compliant

2501 Hot Rod Activator **2502**
Hot Rod Slow Activator

3820 6 parts 3820 to 1 part 3821 for flat
5 parts 3820 to 1 part 3821 for eggshell
4 parts 3820 to 1 part 3821 for semi-gloss

Special Hot Weather Note:

For spray temperatures over 100°F (37.8°C) add 1 oz. of **Urethane Retarder** per sprayable quart of **Matte Black** 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	Various
Activator/Hardener	5.0 V.O.C. / 2501 / 2502 Slow / 3820 6 parts 3820 to 1 part 3821 for flat 5 parts 3820 to 1 part 3821 for eggshell 4 parts 3820 to 1 part 3821 for semi-gloss
Reducer	Reducers will Increase VOC
Mix Ratio	4 : 1
Pot Life	1 hr. @ 72°F (22.2°C) 50% RH
Number of Coats	1 Fill Wet Coat followed by 1 medium wet coat
Flash Time--Air Dry Force Dry	5 – 10 minutes 5 – 10 minutes
Dust Free	10 – 15 minutes
Dry to Sand 70°F (21°C) 50% RH	N/A
Delivery--Air Dry Force Dry	6 – 8 hours @ 72°F (22.2°C) 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.	Refer to product SDS

Technical Data Sheet

Actual V.O.C. Sprayable V.O.C	
%Solids Sprayable by Weight	Refer to product SDS
Coverage Sq. Ft. / gal @ 1 mil*	Refer to product SDS
Package Matte Black Activators	Gallons / Quarts Quarts / ½ pints
Number per case	2 - Gallons / 6 - Quarts 6 32 oz. activators / 6 - ½ pint activators
Shelf Life	12 months