



Technical Data Sheet

Date of issue	Revision Date	Version
13/01/05	17/05/2022	2.2
Product Code	Product Name	

BC- Black Chrome™

DNA® Black Chrome™ represents the ultimate in metalized chrome effect paints. DNA® Black Chrome™ has a unique rich black 'mother of pearl' look has no equal. When applied as detailed in this TDS, you will achieve a uniquely DNA® Black Chrome™. DNA® Black Chrome™ offers an exciting chrome-like finish that can be applied to vehicles, wheels, trim components, artwork, plastics, wood, tiles, glass or almost anything

Always check the [DNA® website](#) that you have the latest TDS ([Technical Data Sheet](#)) and SDS ([Safety Data Sheet](#))

APPLICATION GUIDE:



SDS: Observe all safety precautions in relation to this product. Always wear appropriate PPE such as gloves, spray suit, breathing mask etc.



SUBSTRATE BLACK: For a true black chrome-like finish, DNA® Black Chrome™ must be applied over DNA® Pure Black II BaZecoat™ that must be clear coated with DNA® Diamond Clear™.



SUBSTRATE 2K CLEAR COAT: DNA® Diamond Clear™ 2K Clear coat over your DNA® Pure Black II BaZecoat™. It is most important that your final coat of DNA® 2K clear is laid down correctly so as to ensure maximum flow and high gloss. This finish determines the chrome effect you will achieve. This finish is the reflective surface, and any imperfections will show through. If you have not achieved a high gloss level off your gun it is best to rub back and re-apply the DNA® Diamond Clear™ which must be used with DNA® Black Chrome™. Note: Do not to handle the clear coat after it has been applied, any dust, marks, scuffs or scratches will show through when the DNA® Black Chrome™ is applied. A clear coat with orange peel or a rough and dull surface will produce a dull or frosted finish. Refer *Diamond Clear™ TDS for full Technical Data Specifications*.



SUBSTRATE 2K CLEAR COAT CURING: For maximum chrome-like effect it is important that the DNA® Diamond Clear™ is "fully cured". Wait a minimum of 1 to 2 days or bake for 2 hours at 60°C and rest overnight before applying the DNA® Black Chrome™. If you apply the DNA® Black Chrome™ before the clear coat is "fully cured" the chrome effect will be dull, milky or frosted in appearance.



CLEANING 2K CLEAR COAT: If the previously clear coated surface has been handled or contaminated in any way gently clean the surface with DNA® Anti-Static Cleaner and dry thoroughly before applying DNA® Black Chrome™. Always apply DNA® Black Chrome to a clean surface free of all dust, wax or residue contaminants.

BLACK CHROME™: DNA® Black Chrome™ adheres to substrates differently to other paints. To create a mirror like finish the surface should be as smooth as possible and not scuffed. Note: This product requires careful application to ensure you do not apply material too heavily or unevenly resulting in tram tracks, blotchiness or an uneven

finish. Applying less DNA® Black Chrome™ often achieves the best results.



DNA® CHROME GUN Part # G08 SET UP:

Fluid Tip 0.8mm
Spray Distance 10-15cm
Air Pressure 15-20psi
Material volume 1/4 -1/2 turn
Fan Size 5-8cm @ 15-20cm Spray Distance

HTE GUN SET UP:

Fluid Tip 0.7 – 1.2mm
Spray Distance 10-15cm
Air Pressure 15-20psi
Material volume 1/4 -1/2 turn
Fan Size 5-8cm @ 15-20cm Spray Distance



THEORETICAL COVERAGE: 6-8 sq m per litre approximate.



SPRAYING VISCOSITY: Ford 4 Cup: 9.5sec



MIXING: DNA® Black Chrome™ is ready-to-use no thinning or mixing is required. Shake contents vigorously for 5 minutes before use.



FILTER: Strain mixed clearcoat into spray gun, use 190-micron filter.



BLOW OFF: Blow off any dust that may have settled on the substrate with compressed air. Do not use tack rags before, in between or after application of DNA® Black Chrome™. Apply DNA® Black Chrome at 20° - 30°C and humidity below 70%.



FIRST COAT: To overcome possible static problems it is recommended the first coat be applied at a reduced air pressure of 7-10psi with material volume decreased by about 30%. Apply DNA® Black Chrome™ as a very light wet mist or light wet dusting effect, (very small volume of material with a reasonable amount of air) this first pass assists in breaking any static on the surface and will allow your next coats to lay down more evenly on the surface. Apply this coat with a 75% spray overlap.



FLASH OFF: Allow 10 seconds to 1 minute between coats. 3-4 light coats are recommended. Do not try and obtain coverage in a single pass.



REMAING COATS: Occasionally agitate the material in the gun cup. At the recommended gun set up, continue applying additional coats of DNA® Black Chrome™ as very light mist coats until the desired effect is achieved using a 75% spray overlap.



CURING TIMES @ 25°C: Wait 30 minutes for DNA® Black Chrome™ to dry. Then using the DNA® Micro Fibre Polishing Cloth Part #MFPC, gently wipe and polish the surface area to remove all loose and dusty particles of Black Chrome™. **WARNING** using other cloths to wipe or polish DNA® Black Chrome™ may scuff or scratch the finish. Allow to sit for a minimum of 2 hours before application of DNA® Key Clear™, however, to obtain the most reflectivity it is recommended that you wait 1-2days to allow all tail solvents to out-gas from then apply DNA® Key Clear™.



KEY CLEAR™ - CLEAR COAT: For maximum adhesion it is important to 'lock' the Black Chrome™ in place using DNA® Key Clear™ which is specifically formulated to promote adhesion and to maximize the chrome like finish. Use of other clears directly over the DNA® Black Chrome™ is likely to cause delamination and /or loss of the chrome like effect. Apply DNA® Key Clear™ at 20°- 30°C with humidity below 70%. Spray 1-2 medium coats of the DNA® Key Clear™ over the DNA® Black Chrome™. Allow 5-10 minutes between coats. Refer Key Clear™ TDS for full Technical Data Specifications.

FINAL DNA® DIAMOND CLEAR COAT: After DNA® Key Clear™ has flashed off; apply DNA® Diamond Clear™ at 20°- 30°C. Apply one to two medium wet coats or until desired coverage has

been achieved. Allow flash off between coats and before baking. Refer Diamond Clear™ TDS for full Technical Data Specifications.



SPECIAL EFFECT "BRUSHED METAL" For a brushed metal effect. Using a grey Scotch-Brite™ carefully apply scuff lines on the surface of the fully cured clear coat in one direction only. When satisfied with the scuffed effect, clean the surface and apply DNA® Black Chrome™ as per TDS. These scuff lines will show through the DNA® Black Chrome™ giving you the brushed metal effect.



SPECIAL EFFECT "GROUND METAL": For a ground metal effect. Using a grey 2" Scotch-Brite™ pad or similar on a mini sander carefully and lightly apply swirl and/or grinding patterns onto the clear coated surface, when satisfied with ground effect clean surface and apply DNA® Black Chrome™ as per TDS. These grinding patterns will show through the DNA® Black Chrome™ giving you the ground metal effect. *Note: To get the effects that you want it is important to practice a few times before proceeding to your project. To maintain a highly metallic effect it is important that the clear coat is not completely dulled off and that some gloss remains visible.*



POT LIFE: Not Applicable



CLEAN UP: Clean equipment with Gun wash, Reducer or Thinners

STORAGE: 1 Year in cool, dry conditions

Important: For Professional Use Only.

Always check you have the latest [Technical Data Sheet](#)

Always buy enough product to complete the entire job.

If using more than one container of the same colour, always mix all container contents together (boxing) to ensure consistency of colour

Warranty: DNA® will replace any faulty or defective goods.

Goods are guaranteed for 12 months if stored in cool dry conditions. All information and data provided is given in good faith and intended as a general guide only. Given the many variables, including but not limited to; conditions of substrates, lack of or unsuitable preparation, application, or use of product, mixing or straining, use of incompatible materials, different surface preparations, previous coatings and repairs, the effects of storage, equipment failure or use of incorrect equipment, air quality, humidity, or any other reason beyond the control of DNA®, DNA® reserves the right to make changes to formulations. On occasion batches may have variations such as colour or tone, these are not warrantable. The user must always test the product(s) prior to commencing any job to determine suitability and check for any adverse reaction. Always do a spray out test panel to check final finish and appearance. DNA® offers no warranties of whatever nature and will not accept liability because of any failure express or implied as to merchantability or fitness for a particular use or purpose and will not accept liability for any specific or consequential damage because of using these products. If any goods are defective, cease work immediately and contact your distributor or DNA®. Any faulty goods must be returned at the customers expense to the place of purchase with a copy of the original invoice or proof of purchase to be eligible for the replacement of the faulty product or at the discretion of DNA® for a refund of the cost of goods only. Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure. The benefits provided to the consumer by the warranty are in addition to other rights and remedies available to the consumer under the law.

DNA® Custom Paints

5-7 Keith Campbell Court Scoresby Victoria 3179 Australia

e: info@vincentrivier.com

p: +61 3 9764 2088

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