



Technical Data Sheet

Date of issue	Revision Date	Version
13/11/05	15/09/09	1.6
Product Code	Product Name	
BC-	Black Chrome™	

DNA® Black Chrome™ represents the ultimate in metalized chrome effect paints. Black Chrome's™ uniquely rich black 'mother of pearl' look has no equal and is easy to apply without the need for specialized equipment. When applied as directed using our Key Clear™ you will achieve a uniquely Black Chrome™ look with great adhesion characteristics. Black Chrome™ offers an exciting chrome-like finish that can be applied to vehicles, wheels, trim components, artwork, plastics, wood, tiles and glass; almost anything that you can paint or imagine can be Black Chromed™!

Black Chrome™ *Always check that you have the latest TDS*



SURFACE PREP

Surface must be clean & dry



MIXING RATIO

Ready to Spray
Shake contents for 5mins



SPRAY GUN

DNA® Chrome Gun
HTE or Fine atomization gun



GUN SET UP

0.7~1.2 Fluid tip
10~15cm Spray distance
10~30psi Air pressure
5~8cm Fan size



NUMBER OF COATS

3~4 very light coats



FLASH TIME @ 25°C

10~60sec between coats
1.5~2hrs before Key Clear™



CURE TIMES @ 25°C

Dust Free: 15 sec
Tack Free: 1 min
Dry to Handle: Handle with extreme care until clear coated



THEORETICAL COVERAGE

7~8 m² per litre



POT LIFE

Not Applicable



SPRAYING VISCOSITY

Ford 4 Cup: 9.5sec



SAFETY

Always wear appropriate safety clothing, gloves, breathing & apparatus



MSDS

Observe all safety precautions in relation to this products Material Safety Data Sheet



CLEAN UP

Clean equipment with Gun Wash, Reducer or Thinners

STORAGE

1 Year in cool, dry conditions

QUICK APPLICATION GUIDE:

1. Apply Black Chrome™ over a Pure Black BaZecoat™ which has been clear coated with Diamond Clear™. The clear coat must have a high gloss finish and must be fully cured.
2. Using a HTE gun, apply very light coats of Black Chrome™ best results are normally achieved with 3-4 light coats.
3. Allow the Black Chrome™ to dry and then polish with microfiber cloth.
4. After 2 hours, apply Key Clear™, to protect and lock the Black Chrome™ in place.
5. Finally apply Diamond Clear™ top coat.

DETAILED APPLICATION GUIDE:

SUBSTRATE BLACK



For a true black chrome-like finish, Black Chrome™ must be applied over a black basecoat that has been clear coated with a high gloss 2K clear. DNA® Pure Black BaZecoat™ #B113 and Diamond Clear™ are recommended by DNA® for use with Black Chrome™.

SUBSTRATE 2K CLEAR COAT

Refer Diamond Clear™ TDS for full Technical Data Specifications.



Apply Diamond Clear™ 2K Clear coat over your black item. It is most important that your final coat of 2K clear has a very high gloss level off the gun. This high gloss finish determines the chrome effect you will achieve. The higher the gloss of your clear coat, the more chrome-like your Black Chrome™ will be. 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 your clear coat ensuring a high gloss finish. Diamond Clear #DC- is specially formulated for a high gloss finish and is highly recommended for use by DNA® when using Black Chrome™.

Note: Do not handle the clear coat after it has been applied. Any dust, marks, scuffs or scratches will show through when the Black Chrome™ is applied. A clear coat with orange peel or a rough and dull surface will produce a dull or frosted silver finish.

SUBSTRATE 2K CLEAR COAT CURING

For maximum chrome-like effect it is important that the 2K clear coat is "fully cured" wait a minimum of 3-4 days before applying the Black Chrome™.

Note: If you apply the Black Chrome™ before the clear coat is "fully cured" the chrome effect will be dull, milky and more 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 Black Chrome™. Anti-Static Cleaner Part #CA02

*Always apply Black Chrome to a clean surface free of all dust, wax or residue contaminants.

*DNA recommends learning to apply Black Chrome™ on small objects like DNA® Aeroshapes and then moving on to larger practice panels and projects.

BLACK CHROME™

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 Black Chrome™ often achieves the best results. Less is best!

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 Black Chrome™ as per TDS. These scuff lines will show through the Black Chrome™ giving you the brushed metal effect.

Note: To get the effect that you want it is very important to practice this effect 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 is still present in the clear coat.

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 Black Chrome™ as per TDS. These grinding patterns will show through the Black Chrome™ giving you the ground metal effect.

Note: To get the effect that you want it is very important to practice this effect 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 is still present in the clear coat.

GUN SET UP**(DNA® CHROME GUN Part # SG08)**

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

STANDARD HTE or FINE ATOMIZATION SPRAY GUN

Fluid Tip 0.7 - 1.2mm	Spray Distance 10 -15cm
Air pressure 10-30psi	Material volume 10-25%
Fan Size 5-8cm @ 15-20cm Spray Distance	

MIXING

Black Chrome™ is ready -to-use, no thinning or mixing is required. Shake contents by hand for 5 minutes before use.

BLACK CHROME™ APPLICATION

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 Black Chrome™!
Apply Black Chrome at 20° - 30°C and humidity below 70%

FIRST COAT

To overcome possible static problems it is recommended that your first coat be applied at a reduced air pressure of 7-10psi with your material volume decreased by about 30%. Apply 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. Do not apply too much material. Less is more!

REMAINING COATS

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

CURING TIME

Wait 30 minutes for 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 Black Chrome™ will scuff and or scratch the Black Chrome™ finish.

Allow to sit for a minimum of 2 hours before application of Key Clear™, however to obtain the most reflectivity it is recommended that you wait 24 hours to allow all tail solvents to out-gas from the Black Chrome™ then apply Key Clear™.

KEY CLEAR™ - CLEAR COAT

Refer Key Clear™ TDS for full Technical Data Specifications.



For maximum adhesion it is important to lock the Black Chrome™ in place using Key Clear™. Key Clear™ is specifically formulated to promote adhesion and to maximize the chrome like finish. Use of other clears directly over the Black Chrome is likely to cause delamination and /or loss of chrome like effect.

Apply Key Clear™ at 20°- 30°C with humidity below 70%

Spray 1-2 medium coats of the Key Clear™ over the Black Chrome™. Allow 5-10 minutes between coats.

DIAMOND CLEAR™ - FINAL CLEAR COAT

Refer Diamond Clear™ TDS for full Technical Data Specifications.



After Key Clear™ has flashed off; apply Diamond Clear™ at 20°- 30°C. Apply one to two medium wet coats or until desired coverage has been achieved. Allow 10 minutes between coats and 15 minutes before baking.

For further information refer to the DNA® Training Manual or contact your DNA® Distributor for Technical Support.

Note: Custom painting can be difficult. All products should be fully tested prior to commencing any job to determine suitability, final finish and overall appearance. All information and data provided by DNA® is given in good faith and intended to be a general guide only. DNA® shall not accept liability as a result of any failure or lack of expertise on the part of the applicator, condition of substrates, lack of, or incorrect preparation, use of incompatible materials, equipment failure or use of incorrect equipment or any other reason beyond the control of DNA® and further offers no warranties of whatever nature express or implied as to merchantability or fitness for a particular use or purpose and shall not accept liability for any specific or consequential damage as a result of using these products unless otherwise agreed to in writing. Should a product be defective, DNA® shall replace the defective product, or, at its sole discretion refund the purchase price.

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