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# PRODUCT DATA

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**8837-01**

## **1K Frame Black Industrial Enamel**

### **DESCRIPTION:**

Transtar's 8837-01 Frame Black is a high performance single component (1k) Direct-To-Metal DTM coating designed for heavy duty chassis systems. Frame Black #8837-01 is formulated with a specially modified polymer, corrosion inhibiting pigments, and a unique *anti-sag* agent. This product provides excellent adhesion, good corrosion resistance, and fast productive dry times. The *anti-sag* agent is a very unique addition that allows for fast, easy 1-coat applications **eliminating runs and sags**. Frame Black #8837-01 can also be converted to a 2K DTM polyurethane system by adding Transtar's Polyurethane Activator #8604 at a 12:1 mix ratio. The added benefits and faster cure times are due to the higher crosslink density of the polyurethane enhancement.

### **TECHNICAL DATA:**

% SOLIDS*:	45% by weight, 38% by volume
COATINGS V.O.C.:	3.50#/gal (420g/l) (packed & applied)
SHELF LIFE:	One Year (unopened)
REDUCERS:	Optional: Use Transtar Urethane Grade Reducer appropriate for your shop temperature. Note: Adding reducer will increase V.O.C.'s.
MIX RATIO:	Ready to Use
THEORETICAL COVERAGE:	609 ft <sup>2</sup> /gal at 1.0 mi (theoretical, no loss)

### **SURFACE PREPARATION:**

1K Frame Black may be applied DTM (Direct-To-Metal) over ferrous and aluminum substrates. Substrate must be clean and free of oil and grease. Frame Black #8837-01 can be applied over existing finishes that have been properly prepared. Recommended preparation is as follows: dry sand (DA) use 320-500 grit paper; if wet sanding, use 500-800 grit paper. The existing finish must be tightly adhered to the substrate.

### **SALES POINTS:**

- Excellent exterior weathering durability
- Superior chemical and corrosion resistance
- Exceptional color retention
- Fast, productive dry times
- Easy to apply
- One coat application
- Lead free and chromate free

### **SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS**

*(Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.)*

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### **PACKAGE SIZES:**

#8837-01 1K Frame Black Industrial Enamel, Gallon, 2/case

#8837-05 1K Frame Black Industrial Enamel, 5 Gallon, 1/case

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Transtar Autobody Technologies experience and research and is believed to be reliable. As Transtar has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.

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## **INSTRUCTIONS-MIX RATIO:**

Stir or shake thoroughly to ensure uniform mixture. 1K Frame Black Industrial Enamel is ready to apply. May be mixed with Polyurethane Activator #8604 at 12 parts by volume 8837-01 to 1 part by volume #8604 for added benefits, although not necessary. **Reduction is not necessary.** However, paint may be reduced up to 10% by volume using Transtar's reducers appropriate for the shop temperature. **For fisheyes or other related surface defects**, add 1oz of Transtar's Fisheye Remover #6737, per ready to spray gallon of topcoat.

## **APPLICATION:**

Apply using 40-55 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max. for HVLP spray guns. Apply medium wet to wet coats until desired coverage and flow is reached. Allow a 5 to 10 minute flash time between coats. May be applied in one coat without runs or sags.

## **PRESSURE POT APPLICATION:**

Set fluid delivery at 18-22 ounces per minute. Follow same atomizing air and application instructions as above.

## **SPRAY GUN SET-UP & PRESSURE:**

<u>Type</u>	<u>Fluid Tip</u>	<u>Spraying Pressure</u>
Siphon Feed	1.4mm – 1.7mm	40-65-PSI
Gravity Feed	1.3mm – 1.4mm	40-65 PSI
HVLP Siphon	1.6mm – 1.8mm	max. 10 PSI @ the air cap
HVLP Gravity	1.3mm – 1.5mm	max. 10 PSI
Airless Spray	.015" - .025"	2500 PSI 100 mesh filter

## **DRY TIMES:**

8837-01 Frame Black Industrial Enamel cures by air oxidation (air drying)  
Dry times @ 70°F (21°C) and 50% RH  
Dry to Touch 1 hour  
Tack Free 3 hours  
Dry to Recoat May be recoated at any time. Scuffing will be necessary after 24 hours

## **CLEAN UP:**

Clean all spray equipment immediately after use.  
Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.