

# Technical Data Sheet

Factory Pack Black is an intense, super jet black basecoat designed to match the OEM appearance on many domestic and foreign vehicles. It does not need mechanical agitation, just shake and pour.

## SUITABLE SUBSTRATES

Substrate	Substrate	Substrate
Bare Steel	Raw Plastic - Rigid (SMC, BMC) +	Primer - Self-Etching ✓
Bare Galvanized	Raw Plastic - Flexible (ABD, PPO) +	Primer - 1K ✓
Bare Aluminum	Raw Plastic - Soft (PUR) +	Primer - 2K ✓
OEM E-Coat**	Plastic Part - Primed ++	OEM Finish & Old Paint Work - Reversible
Fiberglass/SMC Unbroken Gel Coat	Body Filler	OEM Finish & Old Paint Work - Non-Reversible ✓

\*\* Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

## MIXING



By Volume: 1 part Factory Pack Black Premium Basecoat 9501/9504  
1 part 6700 or 6700-F Series Urethane Grade Reducer\*

Pot Life Unactivated - unlimited; Activated - 8 hours

Note: For underhood, matt cladding and interior colors, activate the basecoat by adding ¼ oz. of any 6800 Series Extra Solids Activator, any 7000 Euro Clearcoat Activator or any 9400 Signature Series Activator to the ready to spray quart of color.

\* Select reducer appropriate for shop conditions, job size and regulatory requirements. Using urethane grade reducer will increase VOC's. For the use of additives, please refer to next page.

## FLASH TIMES/DRY TIMES



Flash Between Coats 5-10 minutes  
To Tape 20-25 minutes  
To Clearcoat 10-15 minutes

## SURFACE PREPARATION



Finish sand with 500-600 grit dry or 600-800 grit wet.  
Prepare blend areas using 1200-1500 grit wet or dry.  
Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 1391/1394.

\* For more information on surface prep and application refer to next page.

## SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.2 - 1.4	1.2 - 1.4
Air Pressure	10 PSI @ aircap	30 - 40 PSI @ gun inlet

## LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

Visit [www.tat-co.com](http://www.tat-co.com) to assure you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).

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## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	HVLP/LVLP
Fluid Tip	1.2-1.4 mm	1.2-1.4 mm	1.2-1.4 mm
Air Pressure	25-35 PSI (@gun)	30-40 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	N/A

*Always refer to gun manufacturer's recommendation for proper set up and spray pressure.*

## SURFACE PREPARATION

**Cleaning:** Clean area with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

**Sanding:** Finish sand with 500-600 grit dry or 600-800 grit wet. Prepare blend areas using 1200-1500 grit wet or dry or Scuff & Prep Paste 6338 with a gray scuff pad. Thoroughly degrease.

## ADDITIVES

**Additives:** Appearance Improver (6487): DO NOT USE.  
Fisheye Remover (6737) - DO NOT USE.  
Universal Urethane Flex Additive (9194) - DO NOT USE.  
Kicker (6417): DO NOT USE.

## APPLICATION & FILM BUILD

**Coats:** Apply 2-3 coats or until hiding is achieved. Allow 5-10 minute flash between coats. Note: Flash times may vary due to shop temperature and reducer selection.

For Lifetime Warranty, Factory Pack Black must be activated. Add ¼ oz of any 6800 Series Extra Solids Activator, any 7000 Euro Clearcoat Activator or any 9400 Signature Series Activator to 1 ready-to-spray quart of color.

Note: Recoat time of activated basecoat is 2 hours @ 77°F (25°C).

Note: For under hood, matt cladding and interior colors, activate the basecoat as above.

## PRODUCT SPECIFICATIONS

Color: Super jet black	Shelf Life: 1 year
% Solids by Weight: 23.5%	Coverage: 316 ft <sup>2</sup> /gal
Size: Gallon (9501), Quart (9504)	

## REGULATORY

Category: Color Coating/2 Stage Topcoat	9501, 9504	VOC Actual Ready to Use (Zero VOC Reducer)	0.6#/gal (72 g/l)
VOC Actual	1.2#/gal (144 g/l)	VOC Regulatory Ready to Use (Zero VOC Reducer)	3.42#/gal (410 g/l)
VOC Regulatory (less water, less exempt compounds)	3.42#/gal (410 g/l)	VOC Actual Ready to Use (Urethane Grade Reducer)	4.34#/gal (519 g/l)
Weight % of Volatiles	75.92%	VOC Regulatory Ready to Use (Urethane Grade Reducer)	6.42#/gal (769 g/l)
Weight % of Water	0		
Weight % of Exempt Compounds	60.05%		
Volume % of Exempt Compounds	64.87%		
Density of Material	7.8#/gal		

*Note: If using the 6700 Series Urethane Grade Reducers, to remain compliant under National Rule, 9501/9504 must be used under a clearcoat with a ready to spray VOC of 4.3#/gal (515 g/l) or less.*