

Diamond Cut Clearcoat Stormy Black

Technical Data Sheet

| Item no. | Product description |
|----------|----------------------------------------------------|
| 850 | Diamond Cut Clearcoat Stormy Black Paint – 3 liter |

2K fast-curing non-isocyanate clearcoat system with a **black tint**, specifically developed for **diamond cut alloy wheels for BMW**. The product delivers a deep “Stormy Black” smoked effect while maintaining excellent gloss, durability, and adhesion to bare metal or prepared substrates.

This product is based on the proven 850 Diamond Cut Clearcoat system, with the addition of a black tint for aesthetic enhancement.

Key Features:

- Designed specifically for diamond cut alloy wheels
- Stormy Black tinted clearcoat effect
- Direct-to-metal application
- Excellent adhesion and durability
- Long pot life
- High gloss finish with UV protection
- Non-isocyanate formulation – improved health & safety

Typical Uses

- Diamond cut alloy wheel refinishing
- Direct-to-metal wheel applications
- Smoked or darkened clearcoat finishes on machined wheels

Processing instructions

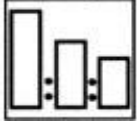
Mixing ratio

Mix ratio is 1:1:1

Color
Activator
Thinner

* by volume.

For example mixes see below.

| *Total mixed paint required | | 90ml | 180ml | 300ml |
|-------------------------------------------------------------------------------------|-----------|------|-------|-------|
|  | COLOR | 30ml | 60ml | 100ml |
| | ACTIVATOR | 30ml | 60ml | 100ml |
| | THINNER | 30ml | 60ml | 100ml |

Surface Preparation

- Ensure all surfaces are dry and free from grease, silicone, and contamination
- Abrade machined areas as required and clean thoroughly
- Final wipe using approved silicone remover or preparation wipe
- Recommended substrate temperature: 15–25°C

Application

- Shake all components thoroughly before mixing
- Use conventional spray gun equipment
- Apply **2 coats**
 - First coat: light/grip coat
 - Second coat: full wet coat for gloss and even tint
- Flash-off time between coats: **2 minutes**
- Final flash-off before curing: **5 minutes**
- Typical dry film thickness: **20–30 microns**

Tint intensity can be adjusted slightly by application technique; always test spray before full application.

Curing

- Oven bake: **15–20 minutes at 60°C** (substrate temperature)
- IR curing: **10–15 minutes** at approx. 20 cm distance using 1 kW lamp

Allow wheels to cool to ambient temperature before exposure to external conditions.

Coverage

Approx. **12–12.5 m² per mixed litre**

(Assuming 100% transfer efficiency at 25 micron dry film thickness)

Post Application Care

- Do not wash or chemically clean wheels for **7 days** after application
- This allows full chemical curing of the coating

Pot life

Approx. 7–8 hours at 20°C, when stored in a spray gun pot or PPS container.

Storage

- Store in cool, dry conditions
- Keep containers tightly sealed when not in use
- Shelf life: **Minimum 12 months** in unopened original packaging

Health & Safety

Always read and understand the appropriate Safety Data Sheet (SDS) before use. Use suitable PPE and ensure adequate ventilation during application.

Notes

Always check colour, tint level, and finish before proceeding with full application. Application conditions, equipment, and technique may affect final appearance.

HBC Systems A/S cannot accept liability for product performance outside of agreed specifications or application conditions unless confirmed in writing prior to use.