

# Diamond Cut Clearcoat Mini Gold

## Technical Data Sheet

Item no.	Product description
851	Diamond Cut Clearcoat Mini Gold – 3 Liter Kit

2K fast-curing DTM (Direct-to-Metal) non-isocyanate clearcoat system with a **subtle gold tint**, specifically developed for **diamond cut alloy wheels**. The Mini Gold tint enhances depth and warmth while maintaining the sharp machining detail and high-gloss appearance expected from OEM-style diamond cut finishes.

This product is based on the proven Diamond Cut Clearcoat technology, with the addition of a controlled gold tint for premium aesthetic enhancement.

### Key Features:

- Designed specifically for diamond cut alloy wheels
- Subtle **Mini Gold** 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

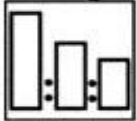
#### Mixing ratio

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 m<sup>2</sup> 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.