



TECHNICAL DATA SHEET

PRODUCT NAME: METALFLAKE FX

Version: 09/05/2012

DESCRIPTION:

Metalflake FX is a unique coating that has a tremendous sparkling effect in bright light, but in normal light will give you a subtle metallic look. Metalflake FX is easily applied by normal spraying equipment. Apply Metalflake FX over any colour base coat for novel effects but also mixing different Metalflake FX colours will give you a real custom effect. Apply our Candy colours over the top of Metalflake FX to give a real "pop" to the Candy effect.



SURFACE PREPARATION:

Apply 2K Primer as directed. Follow recommended drying times to sand and clean primed surface of all contaminants and debris. Sand with P600 or finer grade wet or dry paper (or machine sanded with P320 grade or finer). Clean surface of all sanding debris with solvent. Allow to dry completely prior to ground coat application. Previously painted surfaces must be sanded with 600-1000 grit paper.



GROUND COAT:

Metalflake FX colours require a ground colour. For a strong effect use Base Black but can be applied over other Metallic Base colours. Allow 60 minutes for Base colour to dry before applying Metalflake FX.



MIXING:

MIX RATIO: 2:1 – Mix by volume, mix thoroughly prior to spraying (do not strain).
 · 2 Parts Metalflake FX Colour (mix well)
 · 1 Part D-Thinner

INSPIRE AIRBRUSH: Comes ready you use but can be thinned up to 100% with Inspire Thinner.

POT LIFE:

Not Applicable – will keep in airtight container if unactivated.



GUN SET UP:

Conventional (Gravity) & HVLP (Gravity)
 Fluid tips required:
 Small Flake (100µm) - 0.8mm or larger
 Medium Flake (200µm) - 1.4 mm or larger
 Large Flake (400µm) - 2.0mm or larger.

AIR PRESSURE:

Conventional: 40 – 50 psi at the gun
 HVLP: 10 psi maximum at the cap
 (Refer to spray gun manufacturer's recommendations)



APPLICATION:

HVLP Guns are recommended.

- **IMPORTANT NOTE:** Do not use a material filter in the spray gun. The particles are too large to fit through many of the spray gun filters.
- Apply 2 - 5 coats wet coats with 75% pattern overlap. Allow 10 - 20 minutes flash time between coats.
- Gun distance while spraying should be approximately 6 inches away from the surface.
- Avoid dry spraying, as loss of adhesion is possible with basecoats.
- Always spray a series of test panels first to determine the colour and appearance required.
- Spray the vehicle sides in one continuous pass rather than individual panels to avoid film build up on the edge of panels with could cause a patchy appearance on the finished article.
- Wait for 60 minutes before applying the topcoat.



FLASH TIME:

Allow 10 - 20 minutes flash time between coats.



TOPCOATING:

Topcoat with 2K SHOWCLEAR to provide the ultimate deep gloss finish.
Follow 2K SHOWCLEAR application directions.



SPECIAL NOTES:

NOTE: Always spray a test panel first to establish the ground coat colour and amount of coats required to achieve the desired colour effect.

HEALTH & SAFETY:

Read all warnings, first aid and safety for all components before using. Keep out of reach of children and animals. Wear a properly fitting NIOSH/MSHA approved respirator. Select positive pressure supplied respirator (TC-19C or equivalent) for isocyanates. Follow the respirator manufacturer's directions for use. Protect hands with impervious rubber gloves. Wear face, skin and eye protection. Specialist Paints finishes are for industrial use by professional, trained painters.

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 CUSTOM PAINTS LTD is given in good faith and intended to be a general guide only. CUSTOM PAINTS LTD 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 CUSTOM PAINTS LTD 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, CUSTOM PAINTS LTD shall replace the defective product, or, at its sole discretion refund the purchase price.