



## Metal Flake Repair Manual

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## Method #1

Metal flake repair requires three separate sprays

After all repairs have been made, you will spray the area with the base color. See metal flake chart to determine the correct base color and metal flake or contact manufacturer.

- Spray base color *with out patch aid or surfacing agents*. You may let it fully cure or spray the flake mix (see below) over the top of it immediately after spraying the base gel coat. There is a risk of sagging if both are sprayed one after the other on vertical surfaces. It is recommend to let the base coat dry 4-6 hours and then spray clear/metal flake mixture.
- To spray the metal flake mixture, Mix three parts Spectrum Color Clear to one part metal flake. Mix thoroughly before adding catalyst. Depending on the size of the flake, the amount of flake you add may vary
- Add 2% catalyst *Do not add any other patch aids or additives*
- Spray metal flake clear mix in a circular motion
- This prevents flake build up, overlap lines and allows for a uniform coating of metal flake

See final step for spraying clear



Spray Base Coat



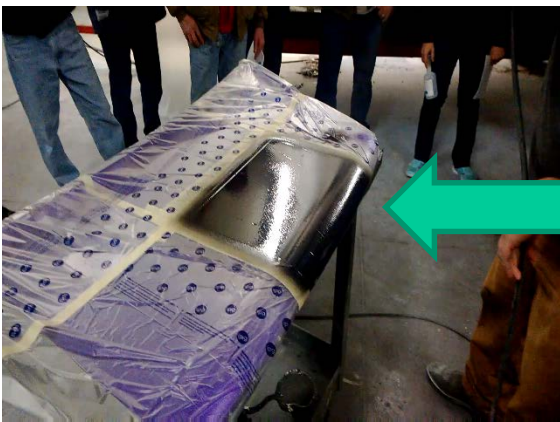
Spray Clear Flake Mix in a Circular Motion

## Method 2

After all repairs have been made, you will spray the area with the base color. See metal flake chart to determine the correct base color and metal flake or contact manufacture

- Spray base color gel coat over the repair area with out patch aid or surfacing agents
- Let cure 1-2 hour or until tacky
- Using a note card or similar card stock, fold card in half and put 2 or so ounces of metal flake in the fold
- Carefully blow the flake on to the tacky base gel coat (the gel will dry tacky with no patch aid and the flake will stick to the gel)
- For larger jobs, a flake buster 2 gun can be used. This gun works best with larger flake and can be found at a variety of places on the internet. It is air driven and shoots dry flake directly onto the repair
- Depending on the size and type of flake, you may also use a clean cheese cloth to carefully pat down the metal flake. This will get the flake to “lay down” and look more like it does when shot into the mold.

See final step for spraying clear





- Mix Spectrum Color Armor Clear with desired amount of clear reducer.
- Use only the Amor Clear reducer, do not use any patch aides or surfacing agent as it will cause clouding in the clear.
- Overspray with PVA and let cure 4-6 hours before finish sanding
- Be careful not to sand through your final layer of clear into the metal flake or the repair will be ruined.