

SOLID METAL

APPLICATION INSTRUCTIONS



INTRODUCTION

OVERVIEW: Solid Metal is a unique metallic finish that consists of a (a) metallic coat and a (b) protective clear coat.

a) METALLIC COAT: The metallic base coat in this finish is the color coat and must be spray applied to achieve the approved results.

c) PROTECTIVE CLEAR COAT: Clear coat must be spray applied using conventional spray equipment, HVLP or Hybrid.

FINISH COMPONENTS

FINISH NAME:	METALLIC BASE:	PROTECTIVE COAT:	ADDITIVE:
SOLID METAL	METALLIC-COAT 2000	ULTRA CLEAR (FLAT/SATIN/GLOSS)	MASTERLINK

IMPORTANT NOTE ABOUT ADDITIVE: Masterlink™ is a performance additive that is added to both components of the Solid Metal finish. This additive increases the stain resistance and durability of the finish. Failure to **add 2 ounces of Masterlink per gallon** will result in a finish that is not as durable as is published and in addition, will void the warranty.

IMPORTANT NOTE ABOUT ULTRA-CLEAR: The Ultra Clear provides a layer of protection as well as a **consistent sheen** for the Smooth Pearl finish.

REQUIRED EQUIPMENT

CONVENTIONAL:

- BINKS® 2001 - 63 PB External Mix Air Cap
- 66 SS Fluid Nozzel
- 565 Needle
- 2 Gallon Pressure Pot

HVLP:

- Graco 4900 ProComp
- 4 Stage Turbine
- #3 Needle/Nozzle set-up or
- comparable equipment

HYBRID:

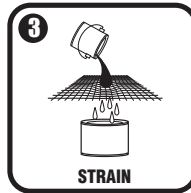
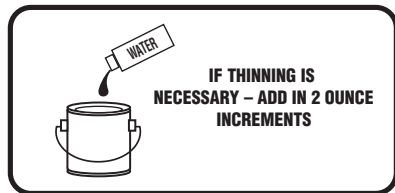
- BINKS Mach 1 - 94P air cap
- 97 Fluid Nozzle
- 2 gallon Pressure Pot or Comparable Equipment

NOTE ABOUT EQUIPMENT: The size of the application should play a large part in what type of equipment is used. Conventional will provide the fastest method. HVLP is much more convenient and more suitable for smaller projects. Hybrid offers more speed than HVLP and less overspray than conventional. All three methods will provide the same finish.

PRODUCT PREPERATION



READ MASTERLINK MSDS



1. ADD TWO OUNCES OF MASTERLINK PER ONE GALLON OF PAINT.

NOTE: Wait to add Masterlink to the Scuffmaster products until immediately prior to its application. Mix thoroughly!

RATIO OF MASTERLINK TO PRODUCT: 2 ounces / gallon

SHELF LIFE ONCE ADDED: 36 hours

POT LIFE ONCE ADDED: 8 hours

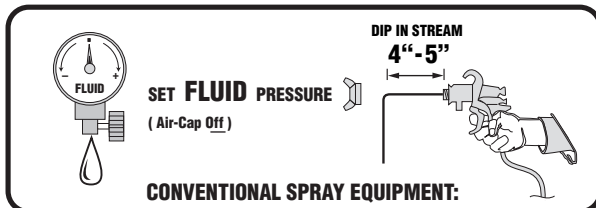
2. Thin MC2000 with water, if necessary. This may be required if using a siphon feed or a gravity feed HVLP. Add 2 ounces at a time.

NOTE: Use an empty 2 ounce Masterlink bottle to measure water.

3. Strain MC2000 with nylon strainer bag.

EQUIPMENT SET-UP

CONVENTIONAL SPRAY EQUIPMENT SETTINGS:



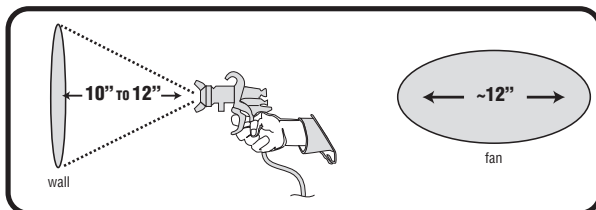
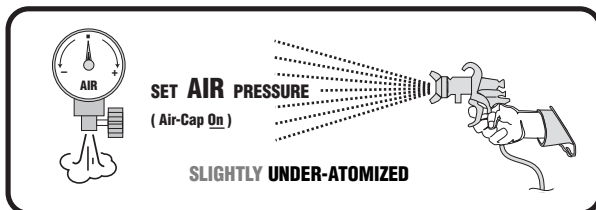
IMPORTANT NOTE: ILLUSTRATIONS TO THE LEFT ARE ONLY FOR A CONVENTIONAL SYSTEM

A) CONVENTIONAL SPRAY EQUIPMENT:

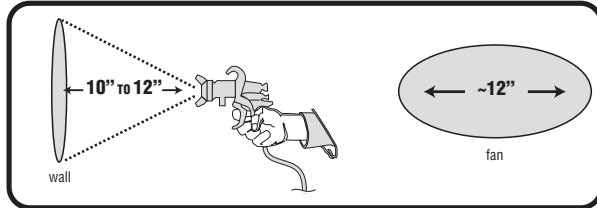
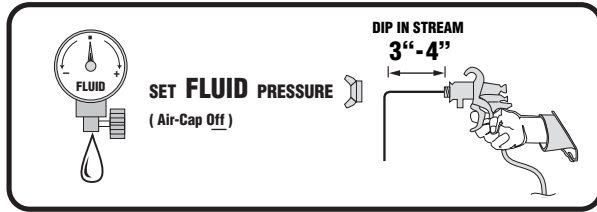
1. Remove the air cap
2. Set the air pressure & fluid pressure to "0"
3. Increase fluid pressure to produce a 4 to 5-inch stream of paint before it begins to arch.
4. Replace the air cap and add air pressure until atomization has been achieved. Then, back air pressure off slightly.

NOTE: Ideal air pressure would leave paint slightly under-atomized, with a very slight "spit" visible.

NOTE: Look for a fan width of approximately 12" when the gun is approximately 10-12" from the wall.



HYBRID SPRAY EQUIPMENT SETTINGS:



IMPORTANT NOTE: ILLUSTRATIONS TO THE LEFT ARE ONLY FOR A HYBRID SYSTEM

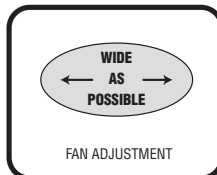
B) HYBRID SPRAY EQUIPMENT:

1. Remove the air cap
2. Set the air pressure and fluid pressure to "0"
3. Increase fluid pressure to produce a 3 to 4-inch stream of paint before it begins to arch.
4. Replace the air cap and add air pressure until atomization has been achieved. Then, back air pressure off slightly.

NOTE: Ideal air pressure would leave paint slightly under-atomized, with a very slight "spit" visible.

NOTE: Look for a fan width of approximately 12" when the gun is approximately 10-12" from the wall.

HVLP SPRAY EQUIPMENT SETTINGS:



IMPORTANT NOTE: ILLUSTRATIONS TO THE LEFT ARE ONLY FOR AN HVLP SYSTEM

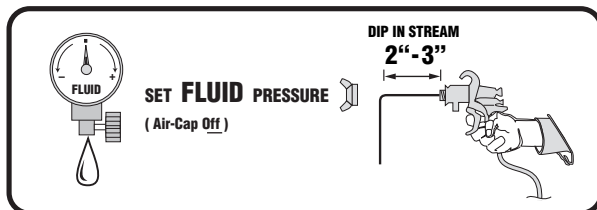
C) HVLP SPRAY EQUIPMENT:



1. Set fan adjustment as wide as possible.
2. Use highest air setting.
3. The trigger should start wide open

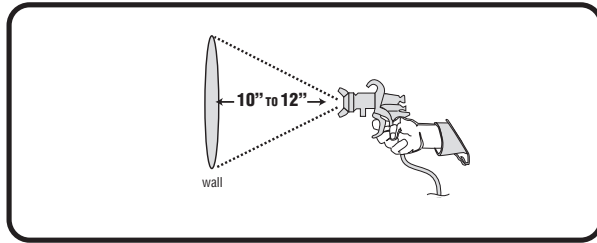
NOTE: If the material is not atomized, adjust the trigger to restrict material flow.

NOTE: It may also be necessary to thin the material with water.

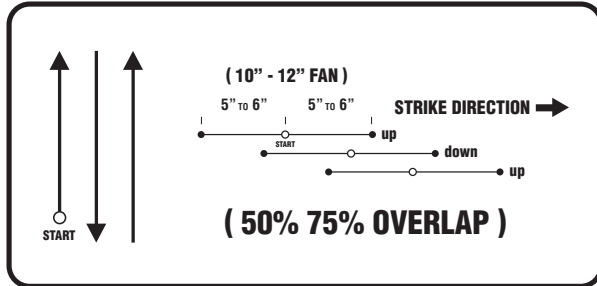


4. If using an HVLP with a pressure pot, set fluid pressure to produce a 2-3" stream of paint before it begins to arch.

SPRAY TECHNIQUE



1. Position the gun 10" to 12" from the surface.
2. Keep the gun at a right angle to the surface to be sprayed at all times
3. Begin each spray stroke a few inches before the edge of the surface. Move the gun in a continuous motion until the other edge is reached. Release the trigger but continue the motion for a few inches past the edge. Follow the same process for the return stroke.
4. Use a 50-75% overlap.



NOTE: A tighter overlap will require a faster spray stroke

NOTE: Typical Solid Metal application requires 4-5 light passes.

NOTE: Wait until each pass is dry to the touch before proceeding.

SPRAY TECHNIQUE NOTES

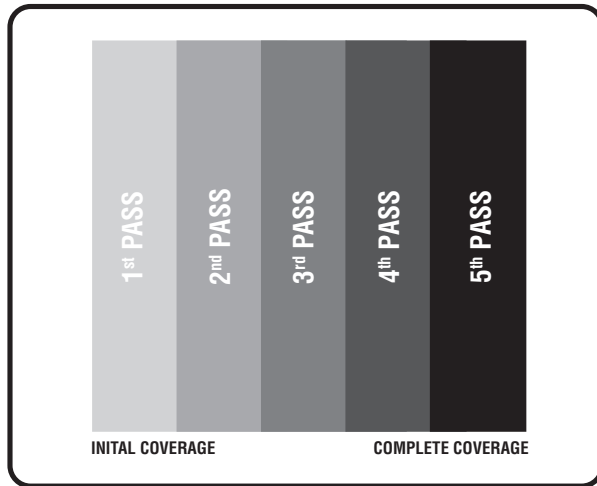
TECHNIQUE ALTERNATIVES: Applying a heavy pass with a wet-edge will slow the process. It will use too much material in addition to taking 5-6 times longer to dry. It will also result in striping.

DO NOT RUSH APPLICATION: If you do not wait enough time between passes the end result will be color blemishing and more time and material needed to correct problems.

VISIBLE BLEMISHES: The finish will look slightly blemished after each pass. Wait until this has dried before applying the next pass or moving on to the clear coat. As the finish dries, these blemishes, unless severe, will dry into the finish and disappear.

IMPORTANT NOTE — FINAL FINISH: Examine the metallic base coat from multiple directions before determining if it is finished. View the same spot on the surface from various angles. When completed it should look the same from every angle. If striping or blemishes are noticeable when viewed at an angle apply another light pass of the MC2000. Repeat until the finish is uniform.

WHAT TO EXPECT WITH EACH PASS



1st PASS: Primer still visible – may appear cloudy or striped.

2nd PASS: Finish begins to fill in – becoming more uniform. Striping and cloudiness may still be visible.

3rd PASS: Cloudiness and striping should begin to disappear as finish fills in.

4th PASS: The surface should be close to complete. Proceed to fifth pass – if necessary.

5th PASS: Process should be complete.

NOTE: WAIT UNTIL EACH PASS IS DRY TO TOUCH BEFORE PROCEEDING ON TO THE NEXT COAT.

CLEAR COAT

1. Protective clear coat can be applied as soon as the metallic base coat is dry to the touch.

NOTE: The clear coat will not hide any flaws or imperfections in the metallic base coat.

2. Use the same settings to apply the Ultra Clear protective clear coat.

NOTE: Apply in one coat.

NOTE: The clear coat may appear milky upon application but will dry clear.

IMPORTANT: FOR BEST RESULTS, SCUFFMASTER RECOMMENDS APPLICATION ON A VERY SMOOTH SURFACE. WE ALSO RECOMMEND THAT NEW SHEETROCK BE PREPARED TO A LEVEL 5 SMOOTHNESS IN ACCORDANCE WITH THE GYPSUM ASSOCIATION'S GA214 STANDARD.

technical support: 1.800.898.0219

documents: www.scuffmaster.com

