Scuffmaster™ architectural finishes

Pretty. Tough. Paint.

Pretty Collection | Application Instructions

Solid Metal™

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Finish Components

Metallic base coat: Metalli-Coat 2000 (MC2000)
Clear coat: Ultra Clear Flat/Satin/Gloss

Equipment

- Conventional: Binks 2001 / 63 PB external mix air cap / 66 SS fluid nozzle / 565 needle
- HVLP: 4 stage turbine / #3 nozzle/needle
- Hybrid: Binks Mach 1 / 94P air cap / 97 fluid nozzle
- **DO NOT USE AIRLESS SPRAYERS**

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.

Important Note: **Masterlink™** is a performance additive that is added to all Scuffmaster finishes. This additive increases the durability of the finish. Failure to add 2 ounces of Masterlink per gallon will result in a finish that is not as durable as it should be in addition to voiding the warranty.

Thoroughly mix Masterlink into the Scuffmaster product immediately prior to application.

Ratio: 2 ounces / gallon | **Shelf life**: 36 hours | **Pot life**: 8 hours

Material Prep

The MC2000 can settle during shipment and storage. Mix thoroughly before application.

1. Add Masterlink immediately prior to application.
2. Thin MC2000 with water, if necessary. This may be required if using a siphon feed or a gravity feed HVLP. Use an empty 2 ounce Masterlink bottle to measure water. Add 2 ounces at a time until proper viscosity is achieved.
3. Strain with nylon strainer bag.

Paint set-up

Conventional:

1. Set air pressure and fluid pressure to "0".
2. Remove air cap. Increase fluid pressure to produce a 4-5" stream of paint before it begins to arch.
3. Replace the air cap and add air pressure until atomization has been achieved. Ideal air pressure would leave paint slightly under-atomized, with a very slight "spit" visible. Look for a fan width of approximately 12" when the gun is approximately 10-12" from the wall.

Hybrid:

1. Set air pressure and fluid pressure to "0".
2. Remove air cap. Increase fluid pressure to produce a 3-4" stream of paint before it begins to arch.
3. Replace the air cap and add air pressure until atomization has been achieved. Ideal air pressure would leave paint slightly under-atomized, with a slight spit visible. Look for a fan width of approximately 12" when the gun is approximately 10-12" from the wall.

HVLP:

1. Set fan adjustment as wide as possible. Use highest air setting. The trigger should start wide open. If the material is not atomized, adjust the trigger to restrict material flow. It may also be necessary to thin the material with water.
2. If using an HVLP with a pressure pot, set fluid pressure to product a 2-3" stream of paint before it begins to arch.

There are a few reasons for leaving the paint slightly under-atomized. This reduces the amount of overspray. Too much air can lead to a narrow fan, which can result in striping and dry spray. The slight spit helps fill in the finish faster.

Spray Technique

Regardless of the type of equipment used, the application technique is the same.

- Position the gun 8-10" from the surface.
- Keep the gun at a right angle to the surface to be sprayed at all times.
- 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.
- Use a 50-75% overlap. (A tighter overlap will require a faster spray stroke)
- Typical Solid Metal application requires 4-5 light passes.
  - Pass #1: Primer still visible may appear cloudy or striped. Wait until this pass is dry to the touch.
  - Pass #2: Finish begins to fill in, becoming more uniform. Striping and cloudiness may still be visible. Wait until this pass is dry to the touch.
  - Pass #3: Cloudiness and striping should begin to disappear as finish fills in. Wait until this pass is dry to the touch before applying the 4th pass.
  - Pass #4: The surface should be close to complete.
  - Pass #5: If necessary.

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. Rushing the application by not waiting enough time between passes will result in color blemishing and will require more time and material to correct.
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.

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.

Clear Coat can be applied as soon as the metallic base coat is dry to the touch. The clear coat will not hide any flaws or imperfections in the metallic base coat.
Use the same settings to apply the Ultra Clear protective clear coat. Apply in one coat. The clear coat may appear milky upon application but will dry clear.

Solid Metal: Troubleshooting

Typical problems fall into two categories: smooth and textured

Problem	Cause	Solution
Striping (Smooth) Vertical or horizontal banding.	1. MC2000 sprayed with the gun too close to the surface. 2. Sprayed with a wet edge. 3. Air pressure was too high, narrowing the spray fan.	Apply multiple light passes with the gun approximately 8-10 inches from the wall to even out striping. If the cause was #3, readjust the fluid and air pressure as outlined above.
Dry spray (texture) Consistent gritty texture most common near the ceiling and floor.	1. MC2000 applied using wrong pressure settings: too much air pressure or not enough fluid pressure. 2. Gun was too far from the wall causing paint to partially dry in mid-air. 3. Bad spray technique. The gun was arched at the top and bottom of the spray stroke	Once dry spray is detected stop spraying. Let finish dry and lightly sand smooth with fine grit sand paper. If textured becomes too coarse, the entire surface must be sanded smooth with a fine-grit sandpaper. When surface is smooth, apply a light pass of the MC2000. Do not try to bury the texture with a heavy pass of MC2000.

Blotching (Smooth) Irregular patches of discoloration	Discoloration caused by either too much material applied at one time or by not allowing sufficient dry time between coats	Wait until previous finish is completely dry. Then apply a very light pass of the MC2000. Normally, one pass is enough, but two or three may be necessary.
Wrong color (Smooth)	Insufficient paint preparation. Be sure that all sediment is mixed off the bottom of the can	If it was an otherwise good installation, simply obtain the right color material and apply 2-3 light passes right over the protective clear coat.
Sagging (texture)	Too much material applied at once OR by over-thinning	Let MC2000 dry. Sand sagging area until smooth. DO NOT SAND THROUGH TO PRIMER. Then, apply 1-2 light passes of MC2000.
Flashing (smooth)	Insufficient clear coat application.	Apply another coat of clear coat.

If you have questions or issues, please do not hesitate to contact our Technical Services team at 800.898.0219 ext. 4859