

F, MF, UMF FLAKES



GENERAL INFORMATION

Flakes may be added to any of our Kandys or Clears. We offer flakes in five grain sizes:

- 1/64 inch Flake (the most difficult to use)
- Mini Flake (comes on fast with greatly reduced surface roughness)
- Ultra-Mini Flake (3 sizes, easy to apply and smoothes out with topcoats)

Built from ultra thin polyester, our flakes are the lightest and easiest to use. The mini and ultra-mini flakes have the brilliance of a much larger flake, combining the ultimate in a flake look and ease of use. Check out our MBC Basecoats. These basecoats offer outstanding brilliance, producing a medium Flake look without the extra work associated with flake.



6. MIXING FLAKES AND GUN SET UP

For maximum reflectivity and ease of use, we recommend adding Flakes directly to the clear and spraying over the base coat. Flakes may be added to any of our Kustom or Kosmic Clears, including SG100 Intercoat Clear and SG150 Intercoat Flake & Pearl Karrier. For best results we recommend the use of SG150 Intercoat Flake & Pearl Karrier **(see tech sheet on SG150)** Use SG100 and SG150 over SHIMRIN® Universal Bases only. The color of your base coat will determine how much flake to use. The following chart is a guide for proper mixing. If a full flake look is desired, be sure your base color is similar to the flake color, preferably 4-5 shades darker than the flake, to create the illusion of coverage in 2 coats. 3 or more coats of flake will greatly increase the roughness of the finish. Always do a test panel first to gauge the coverage, color and roughness before committing to the paint job. You may find you'll need to add additional flake to achieve the proper coverage. (Always measure for consistency of mix)

NOTE: With a gravity feed gun, remove flakes between coats, simply stir and add for next coat or purchase an agitator gun cup.

NOTE: Flake should not be applied with an Air Brush.

NOTE: On large objects, use a reducer (or thinner) on the slow side to allow the flakes to flow into the clear, for better leveling and reduced roughness.

NOTE: When mixing straight clear to be sprayed over flake to bury it, use a faster reducer. Don't use SG100 as a build clear.

NOTE: Flakes may also be added (in small amounts) to any of our SHIMRIN® Bases, Kustom Bases, and to first coats of Kustom and Kosmic Kandys. A great place for creativity. (Do not add Flakes to UB04, UB05, BC25 or BC26 as these high pigmented bases will diminish the flakes.)

ITEM NUMBER	DESCRIPTION	FLAKE SIZE	MIN. NOZZLE SIZE	DARK BASE	LIGHT BASE
F14.B02	RAINBO (1/64)	1/64th HEX	1.8	4 - 12 Tbls	12 Tbls
F15.B02	SILVER (1/64)	1/64th HEX	1.8	4 - 12 Tbls	12 Tbls
F16.B02	LITE GOLD	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F17.B02	DARK GOLD	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F18.B02	ORANGE	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F19.B02	APRICOT	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F20.B02	RED	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F21.B02	FUSCHIA	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F22.B02	ROYAL BLUE	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F23.B02	GREEN	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F24.B02	ABALONE	1/64th Hex	1.8	4 - 12 Tbls	12 Tbls
F25.B02	SMOKE	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F28.B02	KAMEN BLUE	1/64th Hex	1.8	3 - 9 Tbls	9 Tbls
F31.B02	RICH GOLD	1/64th Hex	1.8	3 - 9 Tbls	9 Tbls
F32.B02	FIREBALL	1/64th Hex	1.8	3 - 9 Tbls	9 Tbls
F33.B02	FINE RAINBO	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F34.B02	PINK ROSE	1/64th Hex	1.8	3 - 9 Tbls	9 Tbls
F61.B02	MINI KAMEN BLUE	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F64.B02	MINI RICH GOLD	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F65.B02	MINI FIREBALL	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F66.B02	MINI PINK ROSE	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F70.B02	RED GOLD TRANS	1/166th Square	1.5	1 - 3 Tbls	3 Tbls
F71.B02	GREEN GOLD TRANS	1/166th Square	1.5	1 - 3 Tbls	3 Tbls
F72.B02	BLUE GREEN TRANS	1/166th Square	1.5	1 - 3 Tbls	3 Tbls
F73.B02	VIOLET RED TRANS	1/166th Square	1.5	1 - 3 Tbls	3 Tbls
MF01.B02	GOLD MINI FLAKE	1/256th Rectangle	1.4	1 - 3 Tbls	3 Tbls
MF02.B01	SILVER MINI FLAKE	1/256th Square	1.4	1 - 3 Tbls	3 Tbls
UMF01.B01	ULTRA GOLD MINI	1/500th Square	1.3	1 - 3 Tbls	3 Tbls
UMF02.B01	ULTRA SILVER MINI	1/500th Square	1.3	1 - 3 Tbls	3 Tbls
UMF03.B01	ULTRA RAINBO MINI	1/256th Square	1.4	1 - 3 Tbls	3 Tbls
UMF04.B01	ULTRA RAINBO MINI	1/500th Square	1.3	1 - 3 Tbls	3 Tbls

2. APPLYING FLAKES

WHEN USING LARGE FLAKES - BE SURE YOUR SPRAY GUN HAS A LARGE ENOUGH FLUID TIP TO ALLOW PASSAGE OF THE FLAKE.

Strain the paint into the paint gun, then add the Flake. Air pressure varies gun to gun, but lower pressure works best to reduce overspray. Apply 1- 2 medium coats with 75% pattern overlap. Gun distance while spraying should be 4-5 inches. If Flake is sprayed too far away from the vehicle, dryness can occur which can be difficult to smooth out. Walk long objects. Allow 15 to 30 minutes flash time between coats.

NOTE: TRY NOT TO APPLY MORE THAN 2 COATS. Succeeding coats add greatly to increased surface roughness and will require more clear and sanding to smooth out.

3. KANDY COAT (optional)

Once you are satisfied with the flake application, allow flash time. Using a white scuff pad, lightly scuff over the flake to lay down or knock off any standing flake, then topcoat with 3 - 4 coats of Urethane Clear. Let dry overnight and D.A. sand with 320P grit sandpaper the next day. Be careful of high points and edges, as it is easy to sand through and ruin all you have done. Air and tack. Then begin Kandy coats. Follow label instructions. **See appropriate tech sheets for Kandy application.**

NOTE: When using 1/64 inch Silver Flake (only) you may simply dry sand with 220P grit sandpaper and a washing motion to knock down standing flakes; then begin topcoats. Do not use this method with colored flakes as the color is easily sanded off. Silver is the true flake color.

4. CLEAR COAT

FOR ACRYLIC LACQUER PAINT JOBS:

Allow flash time before top coating with clear. Apply 5-7* coats of C01 or SC01 CLEAR. **See tech sheet for clear coat application.**

NOTE: The normal critical dry time of 48 hours is not a problem with Flakes. You may re-coat at any time with no fear of line checking or crows feet.

***NOTE:** Flake size, Kandy coat, application expertise, thinner, etc. will determine the number of clear coats required. Sand between every 5-7 coats.

FOR URETHANE ENAMEL FINISHES:

Allow flash time before top coating with clear. Paint should be sticky and not string when touched at the wettest point before next coat is applied. (When using the touch test always touch a new spot). Monitor closely for maximum merging of coats.

Apply 2-4* coats of our UC01 or UC35 Cosmic Klear. See tech sheet for clear coat application. Do not use SG100 as a topcoat clear.

***NOTE:** Flake size, Kandy coat, application expertise, thinner, etc. will determine the number of clear coats required.

5. COLOR SANDING & REFLOW

FOR 1/64 INCH SILVER FLAKE AND RAINBOW FLAKE:

Use D.A. Sander with 320P grit dry sandpaper to begin smoothing the paint job. Hold D.A. at eye level and spin pad. It should not wobble, but spin true. Avoid high points, edges or any area where you might sand through.

NOTE: D.A. color sanding requires practice and a true sandpaper pad.

Air and tack. Re-clear. Wet sand with 400 or 500 grit sandpaper for final clear coats.

NOTE: Flake jobs often require more than one reclearing to achieve full coverage and flatness of the flake prior to polishing.

FOR MINI FLAKE AND ULTRA-MINI FLAKE:

Color sand and finish with normal methods. **See tech sheet on Polishing & Finishing for instructions.**

6. POLISHING

Allow a Flake job to dry down before polishing, usually 30 days minimum for lacquer and 48 hours for urethane (in temperatures of 70-80°F). As the paint dries, it shrinks down around the Flakes and if you polish too soon you may wind up polishing again after the dry down. In winter months, it may take 60-90 days or more for dry down. If possible, let the paint bake in the sun for a good cure before polishing. Urethanes cure chemically at 70°. Color sand wet; if rough, start with 500 grit. Finish color sanding with 1200 to 2000 grit.

See tech sheet on Polishing & Finishing for more information.



CAUTIONS

Read Cautions and Warnings on all product can labels. Wear eye protection and approved respirator based on the type of paint the Flake is mixed into. The polyester flakes offer no hazard in dry form, but when sprayed may enter eyes, nose, throat or lungs if proper protection is not worn.

