



#12691 Sprayclad w/powder coat

Description

#12691 Sprayclad is a spray applied, liquid metalizing coating. The coating's appearance will simulate a polished or satin nickle finish. It can be applied to any substrate such as metal, wood, plastic or glass, and can produce a near mirror finish. #12691 Sprayclad and is very versatile and can be used on small runs or large items and does not require special equipment.

Suggested Uses: #12691 Sprayclad can be used in every industry; particularly effective in the automotive industry. Use on wheels, trim reflective hardware or custom design details.

DOT SPECIFICATIONS:

PAINT, 3, Flammable Liquid UN1263, PGII

Benefits

- * Near mirror finish.
- * Many vehicle types.
- * Use with your existing conventional spray equipment
- * Airdry or bake depending on vehicle.
- * Easy application
- * Use on small runs or large items.
- * Topcoat can be toned or antiqued to match almost any metal finish.

Properties

Vehicle Type:	Acrylic
Gloss:	Full
Specific Gravity:	.93
Weight per gallon:	7.76 lbs.
Package Life:	One year
VOC lb/gal gm/ltr:	7.49# / 898 gm

Curing

Bake:	15 minutes @ 325° F
	30 minutes
Pack:	upon cooling



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Directions for Use: Base Coat Primer

#12691 *Sprayclad* will metalize well on a variety of powder basecoats. Basecoats which will not re-dissolve give the best results. Urethane, acrylic, and epoxies are all suitable.

Using a primer as a basecoat for #12691 *Sprayclad* is important for two reasons. First, it insures the best adhesion of the metalizing to the substrate. Second, it smooths any imperfections that may be present on

the substrate such as casting or polishing marks.

When used on basecoats that will re-dissolve, the metalizing effect is disturbed and subsequently is not as bright. The same problem occurs when top coating #12691 *Sprayclad* with solvent based clears or toners, as much of the metalizing effect is muted.

Directions for Use: Application

Metalizing with #12691 *Sprayclad* is accomplished in three steps: powder primer coat; liquid metalizing coat; and clear or toned powder topcoat.

Base Coat using a good flowing, high gloss, powder coat which exhibits good intercoat adhesion. Urethane, acrylic, or epoxy are suitable. Polyester is not recommended as intercoat adhesion is generally not as good. It is important that the base coat is smooth and glossy because the metalizing coat will mimic what is underneath. If the base coat is flat or semi-gloss, the metalizing coat will be flat or semi-gloss. Sometimes a clear powder with high gloss is needed after the basecoat to smooth out any imperfections.

Metalize after curing the base coat powder and while the part is 150° F. Shake or Stir #12691 *Sprayclad* to thoroughly mix the contents. Filter before applying using a fine paint strainer (50 to 100 micron). Using a siphon or gravity feed spray gun, set atomizing pressure between 25 to 35 psi. #12691 *Sprayclad* is very thin, and it will not take much pressure to atomize. Use the lowest pressure necessary to achieve a wet coat. Apply a single wet (not misty or dry sprayed) coat. Cover the part quickly, fast enough so lap patterns are going on top of wet metalizing. The metalizing effect will be reduced if a second coat is applied after the first coat has set or dried. The metalizing coat will appear dull when first sprayed. It will begin to metalize as the solvent evaporates, generally in 20 to 50 seconds. Full metalizing takes place after full cure.

Curing: Allow metalizing to flash off for five minutes, then bake #12691 *sprayclad* at 325° F for 15 minutes before topcoating.

Clear Coat using the same powder resin system used for the base coat. The best results have been achieved by applying the topcoat while the part is still hot, after the #12691 *Sprayclad* has been baked and fresh out of the oven. Again, intercoat adhesion is important and polyester systems will not bond as well as epoxy or acrylic.



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Protective Equipment

- Eyes:** Safety glasses
Skin: Neoprene rubber gloves
Respiratory: NIOSH approved respirator for organic vapor.
For long term exposure, use Supplied Air Respirator
In case of fire: Use foam, dry chemical, CO2, water or spray fog.
Grounding: When transferring, fill stem and container must be grounded and bonded.
CONSULT MSDS PRIOR TO HANDLING.

Precautions

Supplied air respirators are recommended for long term exposure. Production equipment must be cleaned daily to prevent build up and fouling from hardened coating. Only mix as much material as will be used in any eight hour shift. If used over uncatalyzed base coats, lifting may occur when applying a second coat the following day or when doing touch up.

Safety

Keep away from heat, sparks, and flames.

USE WITH ADEQUATE VENTILATION.

Avoid prolonged or repeated contact with skin. Avoid prolonged breathing of vapor or spray mist. Do not take internally. **KEEP OUT OF THE REACH OF CHILDREN.**

Before smoking or eating and after using, cleanse hands thoroughly. Keep container closed when not in use.

Effects of Overexposure:

Prolonged use may cause mild irritation to eyes.

Skin Contact:

Can cause irritation, may be absorbed through the skin and cause defatting.

Inhalation:

May cause respiratory irritation, dizziness and drowsiness.

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee, as conditions and methods of use of our products are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.



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