



Metalflake® Corporation
 7 Arrowhead Circle Rowley, MA 01969
 1-508-932-3339 MetalFlake@Comcast.net

APPLICATION GUIDE SPINDRIFT Soft Multi-Colored Translucent Flakes

1. Prepare surface:




- A. If surface is stripped bare, sand with oscillating sander using #180 grit paper. Wash thoroughly with a metal conditioner.
- B. If the existing surface is a factory baked finish in good condition, scuff with #400 sand paper and apply a bleeder-sealer before applying a ground coat. Otherwise, we recommend removing finish down to original surface. (A bleeder-sealer should be used over all primers and other-existing finishes.)

2. Prime with 3 coats of Primer-surfacer. Allow 15 minutes drying time between first two coats and 45 minutes after final coat. Sand with #360 grit paper.

3. Apply 3 coats of Black or White Acrylic Lacquer, allowing 15 minutes drying time between coats.

4. Mix 2 ounces of Spindrifft to a quart of reduced (one-to-one) Clear Acrylic lacquer, and apply 3 coats, alternating spraying direction with each coat. Use 2 ball bearings in cup and hand agitate constantly to keep flake in suspension. Alternate spray pattern with each coat to avoid streaking.

SPRAY PATTERN:

First coat	Second coat	Third coat
		

Use a Devilbiss #043, #30, or #306 nozzle or their equivalent to apply the Spindrifft (use 25 lbs. pressure at the gun.) Allow 10 minutes drying time between each coat.

Other Suggested Uses: Add 1 to 2 ozs. of Spindrifft to a reduced quart of a candy color and apply over a black or white base. Apply lightly over any color for soft iridescent highlights.

5. Final Finishing:

Option #1. Apply enough Clear Acrylic to allow for sanding without exposing the Spindrifft (14-18 coats suggested.) Allow 10 minutes drying time between coats. After final coat, allow 3 weeks drying time before sanding with #220 grit sand paper using an oscillating sander until all orange peel disappears. All edges and sharp curves must be hand sanded to avoid sanding through to flake. Apply 2 more coats of Clear Acrylic. Allow to dry overnight, then wet-sand with #1000 grit paper, compound with buffing wheel and wax.

Option #2. Apply enough Clear Acrylic to allow for sanding without exposing the flake (14-18 coats suggested) Allow 10 minutes drying time between coats. After final coat allow 3 weeks drying time before sanding with #220 grit sand paper using an oscillating sander until all orange peel disappears. All edges and sharp curves must be hand sanded to avoid sanding through to flake. Apply 3 coats of catalyzed Crysta-Crylor for "Wet Look". 3 coats of catalyzed Polygloss Clear, allowing 1 hour drying time between first two coats and 4 hours between second and third coats. Do not re-coat-can cause wrinkling and/or lifting.