



Technical Data Sheet

**2K Fire Flake (2:1), 2K Micro Fire Flake (2:1),
2K 004 Silver (2:1), 2K 004 Gold (2:1)**

2K HS Acrylic Urethane Topcoat

Date: 21st October 2016

Version:01

Product Name	
Full Product Name	2K Fire Flake (2:1) 2K Micro Fire Flake (2:1) 2K 004 Silver (2:1) 2K 004 Gold (2:1)
Type of Product	2K acrylic urethane topcoat
Description	Spray Chief 2K Fire Flake (2:1), 2K Micro Fire Flake (2:1), 2K 004 Silver (2:1) and 2K 004 Gold (2:1) are custom paints utilising the finest hologram flakes available. They shimmer through a rainbow of colours when viewed at different angles. Because of their protective coating, they do not fade in sunlight, exhibiting excellent durability. They can be used by themselves or as a base for Spray Chief 2K Candy Apple (2:1) colours.

Products						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
2K Fire Flake (2:1)	52.8	58.7	1.017	8.48	420.5	3.51
2K Micro Fire Flake (2:1)	53.2	59.1	1.019	8.50	417.3	3.48
2K 004 Silver (2:1)	56.4	62.6	1.038	8.66	388.5	3.24
2K 004 Gold (2:1)	56.4	62.6	1.038	8.66	388.5	3.24
2:1 MS Hardener	39.9	33.9	0.986	8.23	593.1	4.95
2K Thinner	0.0	0.0	0.882	7.36	881.9	7.36

Properties
<ul style="list-style-type: none"> Shimmer effect
<ul style="list-style-type: none"> High brightness and colour depth



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Substrates

- Spray Chief Epoxy Primer (4:1) Black, White or Grey





Substrate Preparation



All Substrates

- All surfaces must be thoroughly sanded and cleaned with a suitable Wax & Grease Remover prior to application.

Product Preparation

 Mixing Ratio 2:1 (by volume)	Spray Chief 2K Fire Flake (2:1) or 2K Micro Fire Flake (2:1) or 2K 004 Silver (2:1) or 2K 004 Gold (2:1)		Spray Chief 2:1 MS Hardener
	2 parts		1 part
 Reducer	Up to 10% (v/v) of Spray Chief 2K Thinner, if required		
 Pot life @ 25°C (77°F)	2-3 hours		
 Spray viscosity @ 25°C (77°F)	BSB 4 Cup Ford 4 Cup	18-20 s	16-18 s



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



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Product Preparation cont

Spray equipment	Gun type	Fluid tip	Spray pressure	Spray Distance
	Gravity feed	1.3-1.4 mm 0.051-0.055"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
	Suction feed	1.3-1.4 mm 0.051-0.055"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
	HVLP	1.2-1.3 mm 0.047-0.051"	40-70 kPa 0.4-0.7 bar 6-10 psi	15-20 cm 6-8 inch
 Number of coats	3 (minimum)	Apply three or more coats even full coats to achieve desired effect. Avoid heavy wet coats.		
 Application Notes	<ul style="list-style-type: none"> Apply minimum of three coats to achieve desired effect. Apply the last pattern coat, just before it flashes off, to obtain an even finish. Allow sufficient flash-off time (approx. 30 min, or till touch dry) before applying a 2K Candy Apple (2:1) colour, if required. Alternatively, allow sufficient flash-off time (20-30 min, or until touch dry) before applying Spray Chief's 2K Clear (HS) 2:1. 			
Warning	<ul style="list-style-type: none"> Refer to the relevant Technical Data Sheet. The spraying environment must be clean and free from any dust particles. Because any particle landing in these products will be highlighted dramatically, in the 2K Candy Apple (2:1) colour. 			
 DFT Recommended	40-50 µm 1.6-2.0 mils			
 Flash off time @ 25°C (77°F)	5-10 min between coats. Approx. 20-30 min before overcoating.			
 Overcoating	Overcoat with Spray Chief's 2K Candy Apple (2:1) colour or 2K Clear (HS) 2:1 after 20-30 min final flash off, or until touch dry.			
<p>Spray Chief has no control over the thickness or application of the product being applied nor the conditions under which it is being used. These instructions are a guide only and a test panel is recommended before use. Spray Chief has no control over the thickness or application of the product being applied nor the conditions under which it is being used. These instructions are a guide only and a test panel is recommended before use.</p> <p>This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.</p>				





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Remarks	
	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
	Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Equipment Cleaning
Use recommended Spray Chief cleaner

Dry Film Properties	After 7 days drying, <u>when compared to similar technology products.</u>
Durability	Excellent
Lightfastness	Excellent

Product Data	
Colour	Fire Flake, Micro Fire Flake, 004 Silver and 004 Gold
Theoretical Coverage	Approx. 9 m ² /L (365 ft ² /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature away from sunlight.



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Product Packaging

Product Code 1	Product Code 2	Product Name	Package Size
A16/FF2:1	8778008	2K Fire Flake (2:1)	1.5L (Kit)
A16/MFF2:1	8778009	2K Micro Fire Flake (2:1)	1.5L (Kit)
A16/SHS004	8778013	2K 004 Silver (2:1)	1.5L (Kit)
A16/SHG004	8771019	2K 004 Gold (2:1)	1.5L (Kit)
A16/2:1HARDMS	8899200	2:1 MS Hardener	500mL, 1L
A16/2KTHIN	8949200	2K Thinner	1L, 4L, 20L

Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations

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This Technical Data Sheet supersedes all previous issues.

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