



Technical Data Sheet

Date of issue	Revision Date	Version
13/11/05	18/10/16	1.5
Product Code	Product Name	
FS/FH/FM/FC	FlakeZ™	

Stand-out & highly reflective FlakeZ™ produces awesome “BLING” and will make your project stand-out from the crowd. The DNA® FlakeZ™ range allows you to get the right size, color and type of flake for your project. Many colors and sizes to choose from including Metal, Shimmering, Micro, Hologram and Crystal FlakeZ™!

FlakeZ™ Always check that you have the latest TDS



SURFACE PREP

Surface must be suitably prepared, clean & dry



MIXING RATIO

Percentages by weight
50-100µm - 5-6%
150 - 375µm – 10-12%
1000-1500µm – Dry application



NUMBER OF COATS

Apply until desired effect is achieved.



CONVENTIONAL - GUN SET UP

1.4~2.5 Fluid tip
10~20 cm Spray distance
20~45 psi Air pressure
15~25 cm Fan size



HVLP - GUN SET UP

1.4~2.5 Fluid tip
10~15 cm Spray distance
10~15psi at the cap
15~25 cm Fan size



DRY FLAKE GUN- GUN SET UP

20~30 cm Spray distance
10~15psi at the cap



CURE TIMES @ 25°C

See relevant TDS



THEORETICAL COVERAGE

Will vary on desired mixing ratio and carrier used.



POT LIFE

Not Applicable



SPRAYING VISCOSITY

Not Applicable



SAFETY

Always wear appropriate safety clothing, gloves, breathing & apparatus



MSDS

Observe all safety precautions in relation to this products Material Safety Data Sheet



CLEAN UP

Clean equipment with Gun Wash, Reducer or Thinners

QUICK APPLICATION GUIDE:

Dry Flake Gun Application. For Large Flakes

1. The Dry Flake Gun method is generally recommended for FlakeZ™ 375-1550µm in size.
2. Correctly prepare substrate with desired DNA® BaZecoat™.
3. Correctly mix and apply Diamond Clear™ refer to Diamond Clear™ TDS.
4. While the Diamond Clear™ surface is still wet apply the desired FlakeZ™ using the Dry Flake Gun™ until desired coverage is achieved.
5. Using an air gun or blower, very lightly blow over the surface to help remove any loose FlakeZ™.
6. Apply final coats of Diamond Clear™ to seal the FlakeZ™

Wet Application High Definition Inter-Coat™ For Smaller Flakes

1. Wet application method is generally recommended for FlakeZ™ 50-375µm in size depending on gun tip available
2. Correctly prepare the substrate with desired DNA® BaZecoat™.
3. Thoroughly mix FlakeZ™ into High Definition Inter-Coat at desired percentage. It is recommended that some test samples be sprayed out to determine percentage.
4. Apply the High Definition Intercoat, refer to the High Definition Intercoat TDS. Apply until desired effect is achieved
5. Apply your final coats of Diamond Clear™.

DETAILED APPLICATION GUIDE:**CLEANING**

Thoroughly clean the surface using a wax and grease remover such as DNA[®] wax & grease remover and finish with DNA[®] Prep Clean X™

MIXING

Percentages by weight
 50-100µm - 5-6%
 150-200µm – 10-12%
 375µm – 10-12%/Dry Flake Gun Method
 1000-1550 – Dry Flake Gun Method

PREPARATION

Sand using P500-800 wet or dry. Clean with DNA[®] Prep Clean X™ or DNA[®] wax and grease remover if required.

SPRAYING

Using the High Definition Intercoat or the Dry Flake Gun Method. Apply until your desired effect has been achieved.

SUBSTRATE

Correctly prepare the substrate and apply with DNA[®] BaZecoat™ of your desired colour.

BLOWOFF

If using the Dry Flake Gun Method be sure to blow off any loose FlakeZ™ before applying the final coats of Diamond Clear™.

APPLICATION

For FlakeZ™ sizes 50-375µm it is recommended that the High Definition Intercoat method be used. For larger FlakeZ™ 375-1550µm it is recommended that the dry flake gun method be used.

FLASH OFF

Refer to relevant TDS either HDIC or Diamond Clear™.

GUN SELECTION

≤100µm FlakeZ™ a 1.2-1.4 Fluid Tip is recommended.
 100-375µm FlakeZ™ a 1.4-1.8 Fluid Tip is recommended.
 >375 µm FlakeZ™ the dry flake gun is recommended.

CURING TIME @ 25°C

Refer to relevant TDS either HDIC or Diamond Clear™.

DIAMOND CLEAR™ - FINAL CLEAR COAT

Refer Diamond Clear™ TDS for full Technical Data Specifications.



After surface has flashed off; apply Diamond Clear™ at 20°- 30°C. Apply two to three medium wet coats. Allow 10 minutes between coats and 15 minutes before baking.

Note: Flow coating maybe required to obtain a smooth finish

For further information refer to the DNA[®] Training Manual, or contact your DNA[®] Distributor for Technical Support.

Note: Custom painting can be difficult. All products should be fully tested prior to commencing any job to determine suitability, final finish and overall appearance. All information and data provided by DNA[®] is given in good faith and intended to be a general guide only. DNA[®] shall not accept liability as a result of any failure or lack of expertise on the part of the applicator, condition of substrates, lack of, or incorrect preparation, use of incompatible materials, equipment failure or use of incorrect equipment or any other reason beyond the control of DNA[®] and further offers no warranties of whatever nature express or implied as to merchantability or fitness for a particular use or purpose and shall not accept liability for any specific or consequential damage as a result of using these products unless otherwise agreed to in writing. Should a product be defective, DNA[®] shall replace the defective product, or, at its sole discretion refund the purchase price.

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