



Technical Data Sheet

Date of issue	Revision Date	Version
13/11/05	15/09/09	1.6
Product Code	Product Name	
HC-	HolaChrome™	

DNA® HolaChrome™ creates the look of chrome with sharp stunning prismatic color changes. HolaChrome™ is a highly reflective coating with a sensational holographic look and is easy to apply without the need for specialized equipment. When applied as directed using our Key Clear™ you will achieve a unique effect with great adhesion characteristics. HolaChrome™ offers an exciting highly reflective holographic finish that can be applied to vehicles, wheels, trim components, artwork, plastics, wood, tiles and glass; almost anything that you can paint or imagine can be painted in HolaChromed™!

HolaChrome™ *Always check that you have the latest TDS*



SURFACE PREP

Surface must be clean & dry



MIXING RATIO

Ready to Spray
Shake contents for 5mins



SPRAY GUN

DNA® Chrome Gun
HTE or Fine atomization gun



GUN SET UP

0.7~1.2 Fluid tip
10~15cm Spray distance
10~30psi Air pressure
5~8cm Fan size



NUMBER OF COATS

3~4 very light coats



FLASH TIME @ 25°C

10~60sec between coats
1.5~2hrs before Key Clear™



CURE TIMES @ 25°C

Dust Free: 15 sec
Tack Free: 1 min
Dry to Handle: Handle with extreme care until clear coated



THEORETICAL COVERAGE

7~8 m² per litre



POT LIFE

Not Applicable



SPRAYING VISCOSITY

Ford 4 Cup: 9.5sec



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

STORAGE

1 Year in cool, dry conditions

QUICK APPLICATION GUIDE:

1. Apply HolaChrome™ over a Pure Black BaZecoat™ which has been clear coated with Diamond Clear™. The clear coat must have a high gloss finish and must be fully cured.
2. Using a HTE gun, apply very light coats of HolaChrome™ best results are normally achieved with 3-4 light coats.
3. Allow the HolaChrome™ to dry and then polish with microfiber cloth.
4. After 2 hours, apply Key Clear™, to protect and lock the HolaChrome™ in place.
5. Finally apply Diamond Clear™ top coat.

DETAILED APPLICATION GUIDE:

SUBSTRATE BLACK



For a true chrome-like finish, HolaChrome™ must be applied over a black basecoat that has been clear coated with a high gloss 2K clear. DNA® Pure Black BaZecoat™ #B113 and Diamond Clear™ are recommended by DNA® for use with HolaChrome™.

SUBSTRATE 2K CLEAR COAT

Refer Diamond Clear™ TDS for full Technical Data Specifications.



Apply Diamond Clear™ 2K Clear coat over your black item. It is most important that your final coat of 2K clear has a very high gloss level off the gun. This high gloss finish determines the chrome effect you will achieve. The higher the gloss of your clear coat, the more chrome-like your HolaChrome™ will be. This finish is the reflective surface and any imperfections will show through. If you have not achieved a high gloss level off your gun it is best to rub back and re-apply your clear coat ensuring a high gloss finish. Diamond Clear #DC- is specially formulated for a high gloss finish and is highly recommended for use by DNA® when using HolaChrome™.

Note: Do not to handle the clear coat after it has been applied. Any dust, marks, scuffs or scratches will show through when the HolaChrome™ is applied. A clear coat with orange peel or a rough and dull surface will produce a dull or frosted silver finish.

SUBSTRATE 2K CLEAR COAT CURING



For maximum chrome-like effect it is important that the 2K clear coat is “fully cured” wait a minimum of 3-4 days before applying the HolaChrome™.

Note: If you apply the HolaChrome™ before the clear coat is “fully cured” the chrome effect will be dull, milky and more frosted in appearance.

CLEANING 2K CLEAR COAT



If the previously clear coated surface has been handled or contaminated in any way gently clean the surface with DNA® Anti-Static Cleaner and dry thoroughly before applying HolaChrome™. Anti-Static Cleaner Part #CA02

*Always apply HolaChrome to a clean surface free of all dust, wax or residue contaminants.

*DNA recommends learning to apply HolaChrome™ on small objects like DNA® Aeroshapes and then moving on to larger practice panels and projects.

HOLACHROME™

HolaChrome™ adheres to substrates differently to other paints. To create a mirror like finish the surface should be as smooth as possible and not scuffed.

Note: This product requires careful application to ensure you do not apply material too heavily or unevenly resulting in tram tracks, blotchiness or an uneven finish. Applying less HolaChrome™ often achieves the best results. Less is best!

GUN SET UP



(DNA® CHROME GUN Part # SG08)

Fluid Tip 0.8	Spray Distance 10-15cm
Air Pressure 15-20psi	Material volume 1/4 -1/2 turn
Fan Size 5-8cm @ 15-20cm	Spray Distance

STANDARD HTE or FINE ATOMIZATION SPRAY GUN

Fluid Tip 0.7 - 1.2mm	Spray Distance 10 -15cm
Air pressure 10-30psi	Material volume 10-25%
Fan Size 5-8cm @ 15-20cm	Spray Distance

MIXING



HolaChrome™ is ready -to-use, no thinning or mixing is required. Shake contents by hand for 5 minutes before use.

HOLACHROME™ APPLICATION



Blow off any dust that may have settled on the substrate with compressed air. Do not use tack rags before, in between or after application of HolaChrome™!

Apply HolaChrome at 20° - 30°C and humidity below 70%

FIRST COAT



To overcome possible static problems it is recommended that your first coat be applied at a reduced air pressure of 7-10psi with your material volume decreased by about 30%. Apply HolaChrome™ as a very light wet mist or light wet dusting effect, (very small volume of material with a reasonable amount of air) this first pass assists in breaking any static on the surface and will allow your next coats to lay down more evenly on the surface. Apply this coat with a 75% spray overlap.

FLASH OFF



Allow 10 seconds to 1 minute between coats. 3-4 light coats are recommended. Do not try and obtain coverage in a single pass. Do not apply too much material. Less is more!

REMAINING COATS



Occasionally agitate the material in the gun cup. At the recommended gun set up continue applying additional coats of HolaChrome™ as very light mist coats until the desired effect is achieved using a 75% spray overlap.

CURING TIME



Wait 30 minutes for HolaChrome™ to dry. Then using the DNA® Micro Fibre Polishing Cloth Part #MFPC, gently wipe and polish the surface area to remove all loose and dusty particles of HolaChrome™. **WARNING** using other cloths to wipe or polish HolaChrome™ will scuff and or scratch the HolaChrome™ finish.

Allow to sit for a minimum of 2 hours before application of Key Clear™, however to obtain the most reflectivity it is recommended that you wait 24 hours to allow all tail solvents to out-gas from the HolaChrome™ then apply Key Clear™.

KEY CLEAR™ - CLEAR COAT

Refer Key Clear™ TDS for full Technical Data Specifications.



For maximum adhesion it is important to lock the HolaChrome™ in place using Key Clear™. Key Clear™ is specifically formulated to promote adhesion and to maximize the chrome like finish. Use of other clears directly over the HolaChrome is likely to cause delamination and /or loss of chrome like effect.

Apply Key Clear™ at 20° - 30°C with humidity below 70%

Spray 1-2 medium coats of the Key Clear™ over the HolaChrome™. Allow 5-10 minutes between coats.

DIAMOND CLEAR™ - FINAL CLEAR COAT

Refer Diamond Clear™ TDS for full Technical Data Specifications.



After Key Clear™ has flashed off; apply Diamond Clear™ at 20° - 30°C. Apply one to two medium wet coats or until desired coverage has been achieved. Allow 10 minutes between coats and 15 minutes before baking.

For further information refer to the DNA® Training Manual, HolaChrome™ TDS or contact DNA® Technical Support.
Phone: +61 (03) 9764 2088

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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