



## Technical Data Sheet

Date of issue	Revision Date	Version
13/11/05	21/05/14	1.4
Product Code	Product Name	
<b>HGX-</b>	<b>HolaGrafiX™</b>	

DNA® HolaGrafiX™ is a semi transparent coating saturated with light reflecting holographic pigments. In sunlight a brilliant rainbow effect can be observed. HolaGrafiX™ with its continually changing colour accents will add depth and mystery to your finish. When applied as directed you will achieve a uniquely holographic effect. HolaGrafiX™ offers an exciting 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 sparkle like the rainbow!

**HolaGrafiX™** *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 m<sup>2</sup> per litre



### **POT LIFE**

Not Applicable



### **SPRAYING VISCOSITY**

Ford 4 Cup: 9 - 10sec



### **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:**

- HolaGrafiX™ can be applied over any ground coat colour, for the best effect DNA® B113 Pure Black BaZecoat™ is recommended. This must be clear coated with Diamond Clear™. The clear coat must have a high gloss finish and must be fully cured. Before the application of the HolaGrafiX™.
- Using a HTE gun, apply very light coats of HolaGrafiX™ best results are normally achieved with 3-4 light coats.
- Let the HolaGrafiX™ dry for 2 hours, and then apply the Key Clear™, to protect and lock the HolaGrafiX™ in place.
- Finally apply Diamond Clear™ top coat.

### **DETAILED APPLICATION GUIDE:**

#### **SUBSTRATE**



HolaGrafiX™ can be applied over any ground coat which has been clear coated with a high gloss 2K clear. For the strongest holographic look it is recommended that DNA® Diamond Clear™ and DNA® B113 Pure Black BaZecoat™ are used.

**SUBSTRATE 2K CLEAR COAT**

Refer Diamond Clear™ TDS for full Technical Data Specifications.



Apply Diamond Clear™ 2K Clear coat over your chosen ground coat colour. 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 holographic effect you will achieve. The higher the gloss of your clear coat, the more holographic your HolaGrafiX™ 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 HolaGrafiX™.

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

**SUBSTRATE 2K CLEAR COAT CURING**



For maximum holographic effect it is important that the 2K clear coat is “fully cured” wait a minimum of 1-2 days or bake for 2 hours at 60°C and rest over night before applying the HolaGrafiX™.

Note: If you apply the HolaGrafiX™ before the clear coat is “fully cured” the holographic effect will be duller 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 HolaGrafiX™. Anti-Static Cleaner Part #CA02

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

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

**HolaGrafiX™**

HolaGrafiX™ adheres to substrates differently to other paints. To create a holographic 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 HolaGrafiX™ 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**



HolaGrafiX™ is ready -to-use, no thinning nor mixing is required. Shake contents by hand for 5 minutes before use.

**HolaGrafiX™ 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 HolaGrafiX™!  
Apply HolaGrafiX 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 HolaGrafiX™ using a very light mist or light dusting effect. The 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 to 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 HolaGrafiX™ as very light mist coats until the desired effect is achieved using a 75% spray overlap.

**CURING TIME**



Allow to sit for a minimum of 2 hours before application of Key Clear™, It is recommended that you wait 24 hours to allow all tail solvents to out-gas from the HolaGrafiX™ 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 HolaGrafiX™ in place using Key Clear™. Key Clear™ is specifically formulated to promote adhesion and to maximize the holographic like finish. Use of other clears directly over the HolaGrafiX™ is likely to cause delamination and /or loss of holographic effect. Apply Key Clear™ at 20° - 30°C with humidity below 70%  
Spray 1-2 medium coats of the Key Clear™ over the HolaGrafiX™. 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™ according to the TDS.

*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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