

SUPER FLAKES & HOLOGRAPHIC FLAKES



TECHNICAL DATA SHEET

Kirker's new line of effect additives includes SF-Series Super Flakes and HF-Series Holographic Flakes. These long-lasting stir-in flakes are lightfast and solvent resistant, so they'll remain bright and beautiful. Drop into a Midcoat Clear or candy topcoat, or add directly to an existing factory-pack color to add more punch and reflectivity.

SUPER FLAKES

SF-Series Super Flakes are brightly colored particles, precision cut from ultra-thin sheets of vacuum metalized polyester film. The resulting dimensional pigment brings big life to any finish. Strong, beautiful colors from across the spectrum combine with dazzling glitter effects to add plenty of punch. Hex-shaped flakes are cut to .004" (that's about 100 microns, or roughly 1/256 of an inch). Super Flakes are available in 16 brilliant color options which can be applied over different ground coats or blended together to provide unlimited opportunities for customization.

- SF410 Orange Burst Super Flake
- SF412 Copper Penny Super Flake
- SF415 24 Karat Gold Super Flake
- SF430 Livewire Green Super Flake
- SF433 Aquatica Super Flake
- SF440 LED Blue Super Flake
- SF442 Crystal Blue Super Flake
- SF444 Electric Blueberry Super Flake

- SF449 Midnight Blue Super Flake
- SF450 Voltage Red Super Flake
- SF455 Ultra Violet Super Flake
- SF456 Cherry Cola Super Flake
- SF458 Fuchsia Super Flake
- SF460 Silver Dollar Super Flake
- SF470 Obsidian Super Flake
- SF480 Snowflake Super Flake

HF-SERIES

Holographic Flakes go a step further with an even flashier effect. These dazzling iridescent particles are cut from the same material as the SF-Series, but are two times larger. Twice the size means twice the reflectivity, but the HF-Series flakes also add a spectacular color-shifting prismatic effect. Hex-shaped flakes are cut to .008" (roughly 200 microns, or about 1/125 of an inch). There are five different Holographic Flake colors to choose from, but blending these into complementary SF-Series Flakes will lead to countless new combinations and unique color effects.

- HF580 Redline Holographic Flake
- HF581 Blazer Blue Holographic Flake
- HF582 High Sparkle Orange Holographic Flake
- HF583 Caribbean Green Holographic Flake
- HF584 Silver Bling Holographic Flake



PHYSICALS:

- Appearance:** Glitter flakes (appearance varies)
- Particle Size:** Super Flakes 100 microns
Holographic Flakes 200 microns
- Package Measure:** 6 ounce plastic jar
- Package Weight:** 50 grams (net weight)

DIRECTIONS FOR USE

Super Flakes and Holographic Flakes can be used in a wide range of concentrations; add as little or as much as desired to achieve a wide variety of results. Users are encouraged to experiment and reminded to always spray test panels before applying directly to a vehicle. Flake concentration, ground coat color, application pattern, gun settings and other factors will have an impact on the end result.

Creating a Midcoat Color

Most users will apply Super Flakes and Holographic Flakes in a Midcoat Clear, layered between a ground coat and a clear topcoat. In this application, flake particles are added to a clear base, then sprayed over a properly-prepared ground coat. Any urethane clear will suffice, however Kirker's EC310 Midcoat Clear was designed specifically to hold flakes in suspension and improve the application, making the whole job easier.

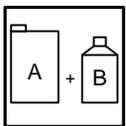
- Ground coats may be freshly painted or, if the surface is in good condition, may also be a factory finish or other previously-applied paint job. If using a cured paint film as a ground coat, be sure to sufficiently clean, sand and reclean the entire surface according to the paint or clearcoat's directions for use.
- Ground coats need not be solid colors (metallic and pearl finishes can also be used), however a ground coat should be the same over the entire vehicle to ensure a consistent appearance.
- No matter how much flake is used, it is unrealistic to expect the additive alone to provide full hiding (coverage). Therefore, any differences in ground coat colors will be visible through the flake midcoat.
- To create the appearance of a full flake effect, choose a ground coat that is close to the flake in both shade value (light/dark) and hue (color). This will provide the most natural, cohesive appearance.
- Using ground coats that are drastically different in shade and/or hue will generate a more extreme, high-contrast effect. The greater the difference, the more obvious any application inconsistencies will be as well. This is especially true when applying flake sparingly for a more randomized sparkle effect.



SURFACE PREPARATION:

Always refer to the Technical Data Sheet for EC310 Midcoat Clear, or whatever coating the Super Flake or Holographic Flake effect additive is being used with for appropriate directions on surface prep, as well as mixing and application instructions.

Be sure to mask all adjacent panels to prevent dry overspray.



MIXING:

Super Flakes and Holographic Flakes can be added to already-activated, ready-to-spray mixtures, but for optimum consistency, and to ensure repeatable results, users are advised to stir flake effect additive into clear, SSU topcoat, SPECTRA Series candy or other mixing base before activating and preparing to spray.

If straining Midcoat Clear or other clear mixing base, be sure to do so before adding flakes.

For best results, use a mixing wand attachment driven by a hand held power drill. Begin with the mixing blades fully submerged in the coating. Slowly increase power until the material is mixing under force with a visible vortex around the shaft of the mixing wand. Shake or spoon flake from the jar directly into the vortex and continue mixing for at least one minute, or as long as it takes for the flake additive to appear uniform throughout the can.

EC310 Midcoat Clear is packaged in a round gallon can, and a round quart can, both $\frac{3}{4}$ full, to allow room for mixing at high speed. If mixing smaller quantities, pour EC310 Midcoat Clear (or other mixing base), into graduated plastic mixing cups. Marked cups will make it easier to continue mixing activator and/or reducer as needed.

Be sure to agitate containers frequently to ensure effect particles are suspended evenly.

How much to use?

Each jar = 50 grams of flake additive. For Super Flakes, that's roughly 16 level teaspoons. For Holographic Flakes, 50 grams is about 12 level teaspoons. That's enough to add to one sprayable gallon of EC310 midcoat clear or other clear mixing base.

TO MAKE THIS MUCH MIDCOAT	ADD THIS MUCH SUPER FLAKE	OR THIS MUCH HOLOGRAPHIC FLAKE	TO THIS MUCH RTS CLEAR
1 gallon	50 grams or 16 level tsps	50 grams or 12 level tsps	1 gallon (128 ounces)
$\frac{1}{2}$ gallon	25 grams or 8 level tsps	25 grams or 6 level tsps	$\frac{1}{2}$ gallon (64 ounces)
1 quart	12.5 grams or 4 level tsps	12.5 grams or 3 level tsps	1 quart (32 ounces)
1 pint	6.25 grams or 2 level tsps	6.25 grams or 1.5 level tsps	1 pint (16 ounces)

Use caution when adding flake. The amount of flake can always be increased, but users will not be able to decrease the concentration without adding back more clear mixing base.

It is better to use flake sparingly and build up extra coats than it is to load too much into each coat.

To ensure repeatable results, keep a record with specific details including which flakes were used, amount of flake, type of clear base, color of ground coat, number of coats applied, etc.



GUN SETTINGS:

Refer to the Technical Data Sheet for the midcoat clear or other mixing base used to suspend SF and HF-Series flakes for suggested spray gun types, air pressure and other recommended settings.

Remove in-cup filters and be sure to select a fluid tip that will accommodate large flake sizes:

Flake Type	Particle Size	Microns	Minimum Fluid Tip
Super Flake	.004" (1/256)	100	1.4 mm
Holographic Flake	.008" (1/125)	200	1.8 mm



APPLICATION:

Apply in even, consistent coats, taking care to maintain good technique.

Each coat should be applied medium wet. Too wet risks runs which will be difficult to correct, and potentially uneven orientation of flake effect particles. Too dry risks a rough surface that will be difficult to smooth out.

For large jobs, be sure to walk the entire length of the vehicle to avoid uneven build up at overlaps.

Follow application directions for the specific system (EC310 Midcoat Clear, SPECTRA Series Candy, etc.). This includes recommended flash times between coats, and dry time after the final coat.

Once midcoat has had sufficient time to flash, but before the recoat window has passed, apply several coats of clear or candy topcoat to bury the flake effect particles and provide a surface to polish. For very rough surfaces, when coating over extra large Holographic Flakes, or any other time extra coats are required to fully bury the flake, apply no more than 3-4 coats, then stop to allow film to fully dry for several days. Sanding after a day or two will open the surface and allow it to dry more thoroughly. Abrade, clean, then apply more coats to continue to build the clear film.

Do not expect to be able to cut and buff directly over Super Flake or Holographic Flake midcoat without damaging and forever altering the appearance of flake effect particles.



HEALTH / SAFETY PRECAUTIONS:

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted fresh-air-supplied NIOSH/MSHA-approved respirator (TC-19C or equivalent) as directed by the manufacturer. Protect hands with impervious nitrile gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. READ ALL WARNINGS ON ALL LABELS BEFORE USING.

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Safety Data Sheet for additional health and safety information.

WARRANTY:

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

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