Quick Tips.

SOLID METAL
APPLICATION GUIDE

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Scuffmaster®

Finish Overview

Solid Metal is a waterbased metallic finish that consists of (a) a base metallic color coat and (b) a protective clear coat.

> **BASE COLOR (a):** MetalliCoat 2000 (MC2000) provides the metallic base coat for Solid Metal. MetalliCoat 2000 must be spray applied.
>
> **CLEAR COAT (b):** Ultra Clear clear coat seals the surface and protects the Pearl Coat. Is is available in three sheens, flat, satin and gloss. Ultra Clear must be spray applied using conventional spray equipment, HVLP or Hybrid.

Masterlink Additive

Masterlink™ is a performance additive that is added to both coats of the Solid Metal finish. Masterlink increases the stain resistance and durability of the finish. Failure to add 2 ounces of Masterlink per gallon will result in a finish that is not as durable as published and will void the warranty.

> **NOTE:** Product life once Masterlink has been added: 36 hours, 8 hours under pressure.
>
> Wait to add Masterlink to each Scuffmaster product until immediately prior to its application. Mix thoroughly. Strain.

Getting Started

REQUIRED MATERIALS: To ensure a proper match, please follow the steps in this guide and be sure your setup is correct.

> **CONVENTIONAL:** BINKS® 2100 - 63 PB External Mix Air Cap • 66 SS Fluid Nozzle • 565 Needle • 2-gal. pressure pot
>
> **HVLP:** Graco 4900 ProComp™ • 4-stage Turbine • #3 Needle/Nozzle Setup or comparable equipment
>
> **HYBRID:** BINKS® Mach 1 - 94P Air Cap • 97 Fluid nozzle • 2-gallon pressure pot or comparable equipment
>
> **COMPRESSOR:** Minimum 6.5 cfm at 90 psi

Conventional & Hybrid Setup

> **1.** Add Masterlink and mix MetalliCoat 2000 following the directions found in the Preparation section on the following page.
>
> **2a.** Remove air cap and set fluid and air pressure to zero.
>
> **2b.** Conventional: Increase FLUID pressure to produce a 3-5 inch stream of paint before it begins to arch (see ill.).
>
> **2c.** Hybrid: Increase FLUID pressure to produce a 3-4 inch stream of paint before it begins to arch (see ill.).
>
> **3.** Replace air cap and add AIR pressure until atomization is achieved. Then, back air pressure off slightly.

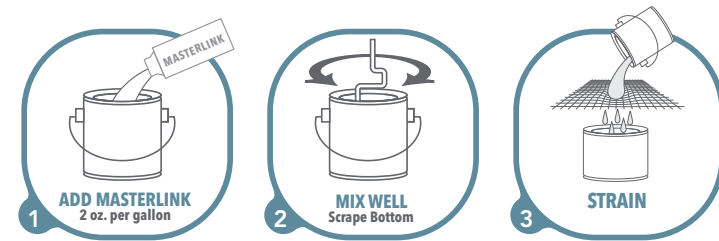**NOTE:** IDEAL AIR PRESSURE WILL LEAVE PAINT SLIGHTLY UNDER ATOMIZED!
NOTE: LOOK FOR A FAN WIDTH APPROXIMATELY 12" WITH GUN 10"-12" FROM WALL!
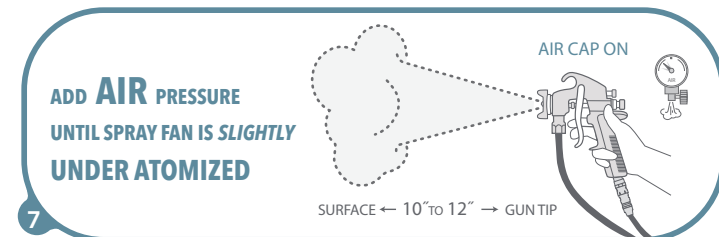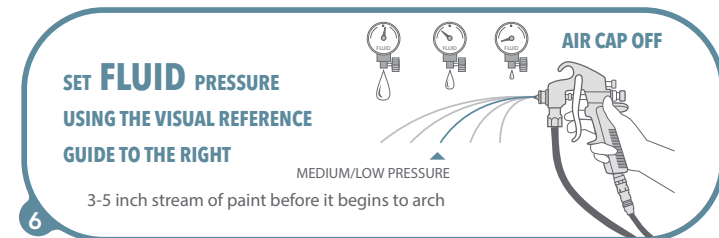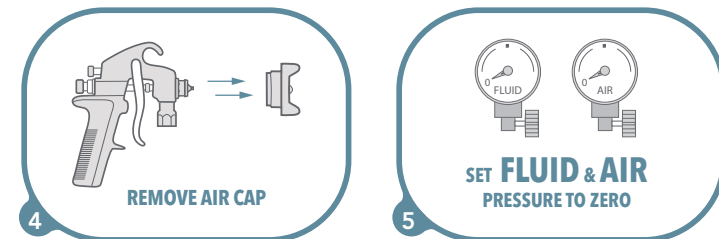
HVLP Setup

> **1.** Add Masterlink and mix MetalliCoat 2000 following the directions found in the Preparation section on the following page.
>
> **2.** Set fan adjustment as wide as possible.
>
> **3.** Use highest air setting.
>
> **4.** The trigger should start wide open. FOR PROPER APPLICATION, MATERIAL SHOULD BE <u>SLIGHTLY</u> UNDER ATOMIZED! MAY NEED THINNING! 8 oz. WATER MAX!
>
> **5.** If using an HVLP with a pressure pot, set fluid pressure to produce a 2-3 inch stream of paint before it begins to arch.

Preparation

IMPORTANT: Be sure surface is as smooth as possible before application! All approved samples are spray applied!

1 ADD MASTERLINK 2 oz. per gallon

2 MIX WELL Scrape Bottom

3 STRAIN

PRODUCT LIFE ONCE MASTERLINK HAS BEEN ADDED: 36 HOURS – 8 HOURS UNDER PRESSURE

4 REMOVE AIR CAP

5 SET **FLUID** & **AIR** PRESSURE TO ZERO

6 SET **FLUID** PRESSURE USING THE VISUAL REFERENCE GUIDE TO THE RIGHT

AIR CAP OFF

MEDIUM/LOW PRESSURE

3-5 inch stream of paint before it begins to arch

7 ADD **AIR** PRESSURE UNTIL SPRAY FAN IS *SLIGHTLY* UNDER ATOMIZED

AIR CAP ON

SURFACE ← 10"TO 12" → GUN TIP

Application Technique

DO NOT SPRAY WITH A WET EDGE! Examine the base coat from multiple angles before determining if it is finished. It should look the same from every direction. If striping or blemishes occur, apply another light pass of MasterCoat 2000.

SIDE VIEW

FACING VIEW

10" to 12"

10" to 12"

10" to 12"

STROKE 2

50-75%
SPRAY FAN
OVERLAP

**10" TO 12"
SPRAY FAN**
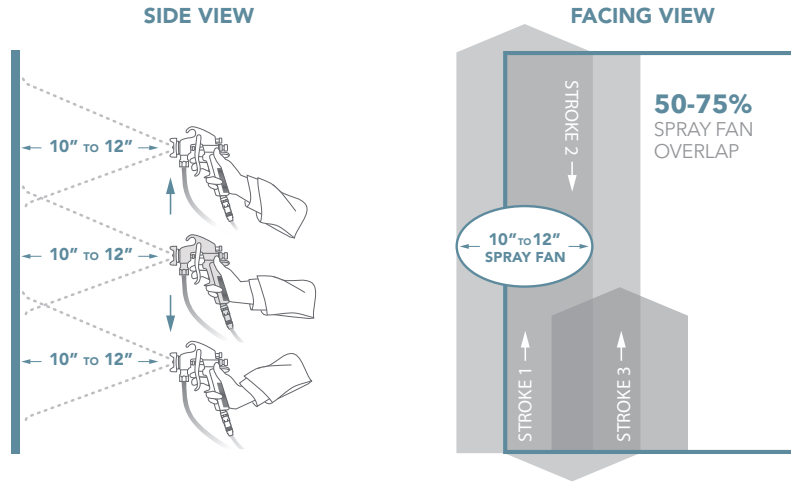
STROKE 1

STROKE 3

KEEP GUN LEVEL AT ALL TIMES!

DO NOT SPRAY WITH A WET EDGE!
SPRAY 4-5 LIGHT PASSES. DO NOT OVER APPLY!

SPRAY GUN POSITION	Position the spray gun approximately 10-12 inches from the surface to be painted. Keep spray gun level at all times.
SPRAY STROKE RANGE	Begin each stroke a few inches before the edge of the surface. Move in one continuous vertical direction until the other edge is reached. Release the trigger and continue the motion for a few inches past the edge. Repeat process for the return stroke.
SPRAY FAN OVERLAP	Overlap each spray stroke by 50-75%. Do not spray with a wet edge. The spray stroke should be fast enough that a wet edge does not develop. Keep each pass light.
NUMBER OF PASSES	**4 to 5 light passes. 1st Pass:** Primer still visible–may appear striped. **2nd Pass:** Finish begins to fill in–striping still visible. **3rd Pass:** Color should appear solid and uniform. Close to complete. **4th Pass:** Surface should be complete. **5th Pass:** ONLY IF NECESSARY. **Wait until each pass is dry before proceeding to the next pass.**

Troubleshooting

IMPORTANT: Call our support line at 212 255 3300 if you are unclear on any step of the application.

Striping/Banding (Smooth):

Cause 1: MC2000 sprayed with gun too close

Cause 2: Spray stroke too slow (wet edge)

Cause 3: Air pressure too high, narrowed spray fan

Solution for 1&2: Don't change pressure settings. Spraying quick, light passes 2x-3x faster than original application will blend the striping together.

Solution for 3: Increase fluid pressure or, preferably drop air pressure until under atomized. Spray quick, light passes until striping blends together.

Dry Spray (Gritty Texture):

Cause 1: Too much air pressure or not enough fluid pressure

Cause 2: Spray gun too far from wall causing paint to partially dry in mid-air

Cause 3: Gun was arched at top and bottom of stroke

Solution: Once dry spray is detected, stop spraying. Let finish dry then lightly sand with fine-grit sandpaper.

Note: If texture becomes too course, the entire surface must be sanded smooth with fine-grit sandpaper. When surface is smooth, apply a light pass of the MC2000.

Blotchy Patches (Smooth):

Cause 1: Too much material applied at one time

Cause 2: Did not allow enough dry time between coats

Solution: Wait until finish is completely dry. Apply another very light pass of the MC2000. May need to apply 2-3 very light passes.

Wrong Color (Smooth):

Cause 1: Improper paint prepping

Solution: Be sure all sediment is off the bottom of the can and all material is boxed. Apply 2-3 light passes with the right color material.