### F, MF, UMF FLAKES

**GENERAL INFORMATION**
Flakes may be added to any of our Kandyo or Clears. We offer flakes in five grain sizes:
- 1/64 inch Flake (the most difficult to use)
- 1/64 inch Flake (comes on fast with greatly reduced surface roughness)
- Ultra-Mini Flake (3 sizes, easy to apply and smooth out with toppants)

Built from ultra thin polyesters, our flakes are the lightest and easiest to use. Ultimate in a flake look and ease of use. Check out our MBC Basecoats. These basecoats offer outstanding brilliance, producing a medium flake look without the extra work associated with flake.

1. **MIXING FLAKES AND GUN SET UP**
For maximum reflectivity and ease of use, we recommend adding flakes directly to the clear and spraying over the base coat. Flakes may be added to any of our Kustom or Kosmic Clears, including SG100 Intercoat Clear and SG150 Intercoat Flake & Pearl Kerier (see tech sheet on SG150). Use SG100 and SG150 over Shmirin® Universal Bases only. The color of your base coat will determine how much flake to use. The following chart is a guide for proper mixing. If a full flake look is desired, be sure your base color is similar to the flake color. Preferably 4-5 shades darker than the flake, to create the illusion of coverage in 2 coats or more coats of flake will greatly increase the roughness of the finish. Always do a test panel first to gauge the coverage, color and roughness before committing to the paint job. You may find you'll need to add additional flake to achieve the proper coverage. (Always measure for consistency of mix)

### NOTES
- With a gravity feed gun, remove flakes between coats, simply stir and add for next coat or purchase an agitator gun cup.
- Flakes should not be applied with an Air Brush.
- On large objects, use a reducer (or thinner) on the slow side to allow the flakes to flow into the clear, for better leveling and reduced roughness.
- When mixing straight clear to be sprayed over flake to bury it, use a tester reducer. Don't use SG100 as a build clear.
- Flakes may also be added (in small amounts) to any of our Shmirin® Bases, Kustom Bases, and to first coats of Kustom and Kosmic Kandyo. A great place for creativity. (Do not add flakes to UB04, UB05, BC25 or BC26 as these high pigmented bases will diminish the flakes.)
- Mixing ratios listed for flakes are for ready-to-spray material, per Quart.

### ITEM NUMBER | DESCRIPTION | FLAKE SIZE | MIN. NOZZLE SIZE | DARK BASE | LIGHT BASE
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F14.C01 | RANBO (1/8A) | 1/64th HEX | 1.8 | 4 - 12 Tbs | 12 Tbs
F15.C01 | SILVER (1/64) | 1/64th HEX | 1.8 | 4 - 12 Tbs | 12 Tbs
F16.C01 | LITE GOLD | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F17.C01 | DARK GOLD | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F18.C01 | ORANGE | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F19.C01 | APRICOT | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F20.C01 | RED | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F21.C01 | FLESCHA | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F22.C01 | ROYAL BLUE | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F23.C01 | GREEN | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F24.C01 | ASH/ONE | 1/64th Hex | 1.8 | 4 - 12 Tbs | 12 Tbs
F25.C01 | SMOKE | 1/128th Rectangle | 1.5 | 1 - 3 Tbs | 3 Tbs
F26.C01 | KAMEN BLUE | 1/64th Hex | 1.8 | 3 - 9 Tbs | 9 Tbs
F31.C01 | RICH GOLD | 1/64th Hex | 1.8 | 3 - 9 Tbs | 9 Tbs
F32.C01 | FIREBALL | 1/64th Hex | 1.8 | 3 - 9 Tbs | 9 Tbs
F33.C01 | FINE RAINBO | 1/128th Hex | 1.5 | 1 - 3 Tbs | 3 Tbs
F34.C01 | PINK ROSE | 1/64th Hex | 1.8 | 3 - 9 Tbs | 9 Tbs
F61.C01 | MINI KAMEN BLUE | 1/128th Hex | 1.5 | 1 - 3 Tbs | 3 Tbs
F64.C01 | MINI RICH GOLD | 1/128th Hex | 1.5 | 1 - 3 Tbs | 3 Tbs
F65.C01 | MINI FIREBALL | 1/128th Hex | 1.5 | 1 - 3 Tbs | 3 Tbs
F66.C01 | MINI PINK ROSE | 1/128th Hex | 1.5 | 1 - 3 Tbs | 3 Tbs
F70.C01 | RED GOLD TRANS | 1/16th Square | 1.5 | 1 - 3 Tbs | 3 Tbs
F71.C01 | GREEN GOLD TRANS | 1/16th Square | 1.5 | 1 - 3 Tbs | 3 Tbs
F72.C01 | BLUE GREEN TRANS | 1/16th Square | 1.5 | 1 - 3 Tbs | 3 Tbs
F73.C01 | VIOLET RED TRANS | 1/16th Square | 1.5 | 1 - 3 Tbs | 3 Tbs
F74.C01 | GREEN TO PURPLE | 1/125th Hex | 1.5 | 4 - 6 Tbs | 6 Tbs
F75.C01 | BLUE TO RED | 1/125th Hex | 1.5 | 4 - 6 Tbs | 6 Tbs
F76.C01 | GOLD TO GREEN | 1/125th Hex | 1.5 | 4 - 6 Tbs | 6 Tbs
2. APPLYING FLAKES

WHEN USING LARGE FLAKES: BE SURE YOUR SPRAY GUN HAS A LARGE ENOUGH FLUID TIP TO ALLOW PASSAGE OF THE FLAKE.

Shake the paint into the paint gun, then add the Flake. Air pressure varies gun to gun, but lower pressure works best to reduce overspray. Apply 1-2 medium coats with 75% pattern overlap. Gun distance while spraying should be 4-5 inches. If Flake is sprayed too far away from the vehicle, dryness can occur which can be difficult to smooth out. Walk long objects. Allow 15 to 30 minutes flash time between coats.

NOTE: TRY NOT TO APPLY MORE THAN 2 COATS. Successive coats add greatly to increased surface roughness and will require more clear and sanding to smooth out.

3. KANDY COAT (optional)

Once you are satisfied with the Flake application, allow flash time. Using a white scuff pad, lightly scuff over the Flake to lay down or knock off any standing Flake. Then topcoat with 3-4 coats of urethane Clear. Let dry overnight and D.A. sand with 320-320 grit sandpaper the next day. Be careful of high points and edges, as it is easy to sand through and run all you have done. Air and tack, then begin Kandy coats. Follow label instructions. See appropriate tech sheets for Kandy application.

NOTE: When using 1/64 inch Silver Flake (only) you may simply dry sand with 220-320 grit sandpaper and a washing motion to knock down standing flakes, then begin topcoats. Do not use this method with colored flakes as the color is easily sanded off. Silver is the true Flake color.

4. CLEAR COAT

FOR ACRYLIC LACQUER PAINT JOBS:

Let clear coat dry before top coating with clear. Apply 5.79 oz. coats of SC200 Sunscreen Clear. See tech sheet for clear coat application.

NOTE: The normal critical dry time of 48 hours is not a problem with flakes. You may re-coat at any time with no fear of line cracking or crow's feet.

*NOTE: Flake size, Kandy coat, application expertise, thinner, etc. will determine the number of clear coats required. Sand between every 5-7 coats.

FOR URETHANE ENAMEL FINISHES:

Apply flash time before top coating with clear. Paint should be sticky and not string when touched at the wettest point before next coat is applied. (When using the touch test always touch a new spot). Monitor closely for maximum merging of coats. Apply 2-3 oz. coats of our UC200 or UC205 Clear. See tech sheet for clear coat application. Do not use UC1100 or UC1105 as topcoat clear.

*NOTE: Flake size, Kandy coat, application expertise, thinner, etc. will determine the number of clear coats required.

5. COLOR SANDING & REFLOW

FOR 1/64 INCH SILVER FLAKE AND RAINBOW FLAKE:

Use D.A. Sanders with 320-320 grit dry sandpaper to begin smoothing the paint job. Hold D.A. at eye level and spin pad. It should not wobble, but spin true. Avoid high points, edges or any area where you might sand through.

NOTE: D.A. color sanding requires practice and a true sandpaper pad. Air and tack. Re-clear. Wet sand with 400 or 500 grit sandpaper for final clear coats.

NOTE: Flake jobs often require more than one reclaring to achieve full coverage and flatness of the flake prior to polishing.

FOR MINI FLAKE AND ULTRA-MINI FLAKE:

Color sand and finish with normal methods. See tech sheet on Polishing & Finishing for instructions.