



custom automotive paint

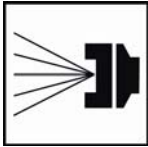
Application Guide

Updated June, 2006. Supersedes all previous versions.
Visit www.autoaircolors.com for additional product information.

Auto Air Colors™ is a durable paint intended for use as base coat and graphic paint for automotive finishes and other exterior applications. Auto Air Colors™ are meant to be top coated with a durable, urethane clear. Auto Air Colors™ are compatible with all urethane, waterborne and water-based paint systems. For use with lacquer and enamel paint systems, test first.

Conditions **Recommended painting conditions: 70° F or higher in a dry, dust-free environment.** When painting in humid or colder conditions, allow for extended drying time. Use of warm moving air, a heat gun or infra-red lamp is recommended to decrease cure time. Air source should be free of contaminants, especially oil and water.

Set-Up



Spray Gun Tip Size: 1.2mm: 35-40+ PSI. Pressure settings may vary. Adjust for optimum atomization.

Reducing: Auto Air Colors 9:1 4011 Flash Reducer

Touch-Up Gun: 0.8mm to 1.0mm tip size.

Follow gun manufacturer's recommendation for distances to surface.

Airbrush Tip Size: 0.5mm: @ 40-50+ PSI

0.3mm and smaller: Transparent Colors thinned 3:1 4011 Flash Reducer.

Reducing: Refer to 4000 Series Reducer Product Guide & 4200 Series Product Guide for additional information. Downloads available at www.autoaircolors.com

Materials



A 4 oz. bottle of Auto Air Color will generally cover 3 square feet.

Refer to specific Series Product guide for additional coverage information.

Motorcycles: 1 quart and 1 pint

Small vehicle: 2 quarts

Medium to large vehicle: 2 1/2—3 quarts

Full size truck or SUV: 1 gallon

Preparation



Proper preparation is crucial to ensuring a successful paintjob. Prepare surface using normal custom painting methods with attention to the following:

Clean surface thoroughly, before and after sanding. Use a solvent-based, post-sanding cleaner.

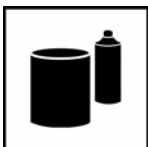
Scuff: Over primed surfaced, use 600 grit wet & dry paper/scuff pad or coarser.

1. When applying graphics over urethane finish which serves as base color for Auto Air Colors, scuff with 800 grit wet & dry paper to avoid large scratches.

2. Sanding and/or scuffing needs to completely remove any gloss points from the surface. Close attention needs to be made with crevices, edges, folds and other areas that are difficult to sand with broad strokes.

Strain Colors: Use a nylon meshed-filter to strain colors prior to each usage.

Primers



Auto Air Colors™ are compatible with all urethane, waterborne and epoxy automotive primers. Use of a urethane, epoxy or other-type sealer is not required. Instead, use Auto Air 4000 Series Sealer.

Metal – Apply 4009 Auto Air Direct to metal Primer. Use 4009 as sealer coat direct to metal. Top Coat with Auto Air Colors.

Plastics – Use of an adhesion promoter necessary when working over plastics which have an oily composition. Scuff thoroughly removing all gloss. An adhesion/tape test is the best method to determine whether an adhesion promoter is necessary.

Aluminum – Apply 4000 Series Sealer direct to substrate after scuffing.

Urethane, Enamel and Lacquer Finishes – Auto Air Colors™ may be used direct to existing any cured finish, urethane, lacquer, enamel and others. Apply 4000 Series Sealer direct to substrate after scuffing. If using finish as base color for graphics with Auto Air Colors, use direct to finish after scuffing with 800 grit wet & dry paper without use of 4000 Series Sealers.

Fiberglass - Apply 4000 Series Sealer direct to substrate after scuffing.

Carbon-fiber - Apply 4000 Series Sealer direct to substrate after scuffing.

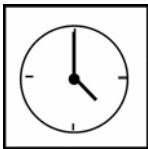
Application and Dry Times



3 Coats – The majority of the colors achieve coverage in 3 coats. Refer to color’s specific Product Guide for further coverage information.

Apply the first coat lightly. – Apply the first coat of Auto Air Colors™ as a light coat, similar to a guide coat. The second and third coat may be applied with more material create an even finish. Avoid wet coats with excess material build-up. Applying a wet coat over a wet coat which has not dried significantly increases drying times and may result in peeling during taping.

- Initial coats have a speckled appearance. Additional coats fill in coverage producing even finish. Final coat should fill in field of color and create an even finish.
- Working in light coats is important to ensuring successful results. A light coat of a water-based paint is much thinner than a light coat of urethane paint. Do not try to get total coverage from one coat. Avoid overly wetted coats. Overly wetted coats may cause pigment to migrate causing a “fish-eye” effect. The last coat should be applied with more material to create an even finish.
- There are no time windows when working with Auto Air Colors™. Additional coats may be applied at any time once the underlying coat has dried. Additional coats may be done within minutes of the last coat or several days may pass before the next coat is applied without the need to sand or scuff.



Recoat Time:

Booth conditions- Generally 5-10 minutes.

Open conditions- Generally 15 min. to 1 hour, depending on humidity levels and temperature.

Use of moving air and/or heat will reduce recoat time. Allow coat to dry prior to application of next coat. Curing each coat with heat is recommended but not necessary if colors are applied with adequate dry time in between coats and final finish is completely cured prior to taping or clearing. When air curing, avoid applying wet coat over wet coat. Allow each coat to dry prior to applying next coat.

Mid-Coats: Optional use of 4004 Transparent Base as mid-coat prior to taping protects colors from markings during taping, especially when taping over 4100 Series color.

- Apply 1 – 2 coats after curing underlying paintjob.
- Humid conditions: use of a urethane mid-coat works best when protecting colors prior to taping.
- Transparent Base used as a filling mid-coat over large pearl-flaked and metal-flaked colors prior to clear coat application. Use over 4400 Series Gem Color-Shift™ Colors and 4500 Series Hot Rod Sparkle™, Cosmic Sparkle™ and Sparkle Flake™ Colors prior to clearing.
- Use 4004 Transparent Base as a protective mid-coat prior to taping over 4600 Series Candy Colors.

Spot Repair



Before attempting spot repair, make sure paint is thoroughly cured. 4200 Series Transparent, 4500 Series Sparklescent and 4600 Series Candy Colors do not sand cleanly for spot repairing.

- 1.) Sand paint off failed area. Use coarse dry paper. Do not wet sand.
- 2.) Sand paint past failed area insuring all paint is removed and no edge remains.
- 3.) Begin repairing by painting sanded area first. Apply enough coats to completely cover.
- 4.) After filling in sanded area, blend by painting entire panel or extended area surrounding repair.

Curing



Auto Air Colors can be cured in a spray booth with air movement, by infrared heat lamps, a heat gun or simply allowing colors to air dry completely.

Curing in Spray Booth- A spray booth is the preferred environment for painting vehicles with the Auto Air Colors. Bake paint at 120-150°F for 15-20 minutes or until colors are completely dried.

For quicker drying times, increase airflow rate and booth temperature. Colors may be cured in excess of 300°F.

Curing in Open Conditions- Recommended minimum temperature 70°F and low humidity. Curing Auto Air Colors™ in humid or cold damp conditions may require extended exposure to heat. Use airflow to speed up drying time.

- Auto Air Colors™ are cured with heat and/or airflow. Use heat gun or infra-red lamp to cure colors. If not curing with heat, allow colors ample time to dry prior to taping or clear coat application. Drying time will vary depending upon environment.
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Curing



- In Infra-red lamp (IR) – allow lamp to cure colors at a safe distance generally over 12 inches to prevent blistering paint. Cure colors dry to the touch without tack.
- A heat gun is effective when curing smaller areas such as body panels, tanks, fenders, helmets, etc. Generally colors cure 1-2 minutes per square foot. Keep gun moving at a safe distance of 6” or more to avoid blistering. Avoid aggressively heating colors as adhesion failure may occur. Allow colors to air cure initially followed by gentle application of heat from gun. Cure colors dry to touch without tack.

Taping



When used correctly, Auto Air Colors™ will not peel when taped. Most types of tape work excellent. For transfer tape, use a high tack tape such as 4870 Stickey Mickey’s Masking Tape.

Tape Time:

Air Curing : 1 – 6 hours, depending upon room temperature, humidity levels and proper application of colors (namely allowing individual coats to dry prior to application of the next coat).

Heat Curing: 30 min. to 1 hr. Allow paint surface to cool to room temperature after heating.

Helpful Tips for Masking and Taping.

1.) Use of 4004 Transparent Base as Mid-Coat prior to taping.

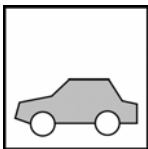
Use of Transparent Base or a urethane mid-coat/ inter-coat clear over base color prior to taping allows for easier application as overspray may be removed without marking colors. Application of mid-coat also allows tape to better adhere to Auto Air Colors. The mid-coat creates a less-textured surface upon which masking material, fine-line tape and low-tack tape can better lay down without lifting (not peeling the paint up, but the tape lifting off the surface).

2.) Recoat With Base Colors- To create a cleaner, crisper edge along the tape line, apply another coat of base color prior to applying graphics color. Additional coat of base color fills in open spaces under tape, creating a crisper line when the graphic color is applied.

Cleaning

Optional use of a solvent based post-sanding degreaser (final prep cleaner) may remove any dust, particulates, smudges or fingerprints that may be on the painted surface. Do NOT clean with water.

Cleaning



A) Start with 1 light tack coat. Allow ample flash time to ensure acclimation with paint.

B) Apply wet coats. Follow clear manufacturer’s instructions.

C) Use a medium or high temperature catalyst. Avoid using low temperature (fast curing) as rapid curing will not allow optimum adhesion with Auto Air Colors. Slower cure times allow better acclimation with the underlying paint.

Auto Air Colors are compatible with all urethane clears. Compatibility with other clear types varies. Test first.

Use a slower activator/ hardener to allow for more reflow & self-leveling, allowing clear time to acclimate with paint. Avoid use of hyper-cure hardeners.

Do not over-reduce when using a 3-part clear. Over-reducing may cause die-back or peeling as excess solvent will not release quickly once acclimated into Auto Air Colors.

There are no time window limitations to follow when applying the clear. Clear may be applied at any time after colors cure without scuffing.

When clearing over large flaked colors such as 4400 Series Gem Color-Shift™ Colors and 4500 Series Colors, use of a high-solids clear is recommended to bury the pearl-flakes.

Application of 4004 Transparent Base as mid-coat prior to urethane clear application is recommended to create a smooth surface for clear coat, especially with larger flaked colors such as Hot Rod Sparkle™, Sparkle Flake™, Gem Color-Shift™, etc.

Equipment Clean Up

Use Auto Air Cleaner or Restorer as directed on label for best removal and maintenance of spray equipment when using Auto Air Colors.

Safety

Although Auto Air Colors™ contain 0.1 VOC, the user or any persons who may be exposed to the airborne particulates are required to wear a NIOSH/MSHA approved respirator. Protect from contact with skin or eyes. Use standard safety and handling procedures to minimize potentials hazards. See Material Safety Data Sheets for complete safety and handling information.

Product Series General Application Overview

See specific product label or *Auto Air Colors Technical Bulletin* for detailed usage information.

4000 Series Reducers, Sealers & Cleaners

Sealer Dark and White – Use as initial layer of Auto Air Colors™ over prepared surface. Suitable for use as a replacement of urethane or epoxy sealer except over bare, untreated metal. May be applied direct to urethane, enamel, lacquer and other finishes after scuffing with 800 grit wet/dry paper or coarser grade of abrasive. Scuffing Base Coat prior to application of color is not required.

Use of Sealer may be omitted when using existing finish for a color-keyed base (example, 4500 Series Hot Rod Sparkle Color over a black urethane finish) or when using a similar 4200 Series Semi-Opaque Colors such as 4220 Deep Black.

Tinting 4001 Sealer with top-coat color improves coverage of top-coat color. This is especially beneficial when working with red, yellow and orange colors and transparent colors such as the 4500 Series Sparklescent™ Mango and Tequila Yellow. Tinting Base Coat Sealer White with 4205 Semi-Opaque Flame Orange will create a pastel-like orange base color which the Sparklescent™ Mango will cover quicker with less material required for the Mango's finish.

Transparent Base – Use as base for mixing with 4600 Series Candy Colors and as mid-coat. Prior to clearing, use as a filling, mid-coat (inter-coat) over other colors as fill coat over large pigments and flakes for more even paint film, especially prior to clearing 4500 Series and 4400 Series Colors.

Reducer – 4011 & 4010 Flash Reducers improve flow, leveling and decrease cure times. Flash Reducers are recommended for use with all Auto air applications. Refer to *Auto Air Colors Product Guide* for mix ratios and more information.

Cleaner- Highly concentrated biodegradable cleaner used to clean airbrushes or spray guns.

Restorer- Removes Auto Air Colors™ or dissolves cured and uncured water-based paints. Makes for easy clean-up and complete removal of Auto Air Colors for cured finishes (prior to clear) and dried paint in spray guns and airbrushes.

4100 Series Aluminum Bases – Highly reflective aluminum silver base for 4600 Series Candy Colors.

4200 Series Graphic Colors

Semi-Opaque Colors – Standard base coat colors.

Fluorescent Colors – Limited lightfast when exposed to sunlight, use with discretion.

Transparent Colors – Use for fine-detailed airbrushing, blending and as a toner by mixing with other series colors.

4300 Series Special FX™ Colors

Pearlized, Metallic and Iridescent Colors - Colors are opaque and cover well. May be used as a base for 4600 Series Candy Colors

4400 Series Color-Shift FX™

Gem Color-Shift™ – Holographic, color-shifting pearl flakes in a transparent base. Use over black or other color base for color-keying effects. Best if 4004 Transparent Base applied as mid-coat over Gem's large pigment size for a more-even paint film prior to clearing.

Flair Color-Shift™ – Multiple color shifting colors.

Hi Lite Interference - Subtle color changing pearl in a transparent base. Use over black or other colors for color-keying effects. Travels from respective color to transparent. Great for ghostlike effects.

4500 Series Sparkle™ Colors

Hot Rod Sparkle™ – Large pearl flakes in a transparent base. Use over black or other colors for color-keying effects. Mix direct with 4200 Series Transparent Colors for candied-pearl bases. Mix direct with 4600 Series Candy Colors for pearlescent candy colors (replaces by volume the 4004 Transparent Base needed in candy mix ratio). Best if 4004 Transparent Base applied as mid-coat over Hot Rod Sparkle's™ large pigment size for a more-even paint film prior to clearing.

Sparkle Flake™ – A metal flake in a transparent base. Use over black or other colors for color-keying effects. Mix direct with 4600 Series Candy Colors for pearlescent candy colors (replaces by volume the 4004 Transparent Base needed in candy mix ratio). Best if 4004 Trans. Base applied as mid-coat over flake's large pigment size for a more-even paint film prior to clearing.

Cosmic Sparkle™ - Small pearl flakes in a transparent base. Similar to Hot Rod Sparkle™

Sparklescent™ - Unique blends of multiple effects colors that create a single stage “candied” custom finish color. Apply over white base or color key with a 4300 Series Metallic Colors base. For extra effects, use Sparklescent™ Colors as base for 4400 Series Gem Color-Shift Colors and 4500 Series Hot Rod Sparkle™ and Cosmic Sparkle™ Colors.

4600 Series Candy Colors

Concentrated dye-based translucent color for true candy effects. Reduce 1:1 with 4004 Transparent Base for large panels. Candy Colors blemish easily. Avoid direct contact, even after curing. Use urethane mid-coat prior to taping or masking. After curing, colors dry to a matte finish. Candy effects not visible until clear applied. Due to Candy Colors limited lightfastness use clears that feature maximum UV protection for best results.

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