

# **SEM**® **FLAKES, LIGHTNING FX & PASTE PEARLS**

## TECHNICAL DATA SHEET

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Check local VOC regulations to ensure compliance of all products in your area.

### **DESCRIPTION**

**Flakes** are precision cut, resin coated chips for adding intense sparkle to custom paint jobs.

**Lightning FX** are vibrant, glass pearl pigments that provide extra brilliance and sparkle to custom paint jobs.

**Paste Pearls** are concentrated effect pigments that add a mild frosted sparkle effect to custom paint jobs.

### **FEATURES**

#### **FLAKES**

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- Brilliant, jewel-like colors
- Provides extreme effect
- Fade and solvent resistant
- Easy to apply

#### **LIGHTNING FX**

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- Add to color or clear
- Highly reflective
- Adds intense sparkle in sunshine

#### **PASTE PEARLS**

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- Concentrated for easy mixing
- Highly reflective pigments
- Easy to create one-off colors

### **SUITABLE SUBSTRATES**

- Basecoat
- Mix Clear
- Urethane Clearcoat
- Properly prepped OEM finish



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## TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
06014	Flakes	Mini Gold	4 oz. Jar
06024	Flakes	Mini Silver	4 oz. Jar
06034	Flakes	Blue	4 oz. Jar
06044	Flakes	Gold	4 oz. Jar
06054	Flakes	Red	4 oz. Jar
06064	Flakes	Green	4 oz. Jar
06124	Flakes	Solar Fire	4 oz. Jar
06144	Flakes	Silver Rainbow	4 oz. Jar
06154	Flakes	Silver	4 oz. Jar
33012	Lightning FX	White Lightning	2 oz. Jar
33022	Lightning FX	Sun Gold	2 oz. Jar
33032	Lightning FX	Hurricane Red	2 oz. Jar
33042	Lightning FX	Ultra Violet	2 oz. Jar
33052	Lightning FX	Thunder Blue	2 oz. Jar
33062	Lightning FX	Electro Green	2 oz. Jar
35202	Paste Pearls	Platinum	2 oz. Jar
35212	Paste Pearls	Red 2-Tone	2 oz. Jar
35222	Paste Pearls	Gold 2-Tone	2 oz. Jar
35232	Paste Pearls	Blue 2-Tone	2 oz. Jar
35242	Paste Pearls	Green 2-Tone	2 oz. Jar
35252	Paste Pearls	Violet 2-Tone	2 oz. Jar
35262	Paste Pearls	Orange 2-Tone	2 oz. Jar
35272	Paste Pearls	Aztec Gold	2 oz. Jar

**Regulatory VOC Paste Pearls:** 602-620 g/L, 5.02-5.17 #/gal

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## HANDLING AND APPLICATION

### PREPARATION:

#### OVER BASE COLORS:

**Base Colors** should be allowed sufficient dry time, typically 30 minutes from last coat, before applying **Paste Pearls, Lightning FX** or **Flakes**.



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## OVER OEM FINISH:

Clean OEM finish with **SEM Solve** or **Zero VOC Surface Cleaner**. Sand with 400-600 grit paper or a gray scuff pad then re-clean with **SEM Solve** or **Zero VOC Surface Cleaner**.

## MIXING:

The mixing ratio for **Flakes**, **Lightning FX**, and **Paste Pearls** is based on the painter's preferences.

**Flakes**, **Lightning FX**, and **Paste Pearls** can be added to **Mix Clear** and sprayed as a fast drying base for extra control or the topcoat clear.

### Note:

Always spray a test panel to insure the desired look. Lighter base colors will require more material.

## RECOMMENDED STARTING POINTS:

### Flakes

- 10 grams (roughly one tablespoon) per ready to spray quart
- Up to 100 grams for a heavy flake appearance

### Lightning FX

- 10 grams (roughly two tablespoons) per ready to spray quart

### Paste Pearls

- 1/4 to 1/2 tablespoon Paste Pearl per ready to spray quart

### Note:

1 capful of most urethane clearcoat hardeners can be added to **Mix Clear**. This addition yields excellent early adhesion, superior chip resistance and is especially useful in multi-layered designs which result in excessive film build. Pot life is one hour when making this addition. Test compatibility before spraying and always use hardeners that meet VOC regulations for your area. If using more than 10 grams of **Flakes** per ready to spray quart, hardener must be used in **Mix Clear** or adhesion is very poor.

For best results, use a siphon-fed type gun with an agitator cup. **Flakes**, **Lightning FX**, and **Paste Pearls** will settle quickly and will build up in the gun tip when using gravity-fed type guns. When using gravity-fed type guns, be sure to shake product in the gun periodically to reduce settling and ensure even product distribution.

Always use the reducer best suited to shop conditions. Dry times may vary depending on film build, shop conditions and reducer used.



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## APPLICATION:

### SET AIR PRESSURE TO:

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<b>Non-HVLP:</b>	45-60 psi for
<b>HVLP equipment:</b>	8-10 psi at the cap

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### USE A GUN EQUIPPED WITH:

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<b>Paste Pearls:</b>	1.2-1.3 fluid tip/nozzle for small projects
	1.3-1.4 fluid tip/nozzle for large projects
<b>Lightning FX:</b>	1.4 fluid tip/nozzle
<b>Flakes:</b>	(mini 100 micron) 1.5-2.2 fluid tip/nozzle
	(large 1/64") 2.2-3.0 fluid tip/nozzle

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Allow to flash, approximately 10-15 minutes between coats.  
Allow final coat to flash 30 minutes before applying top coat.

### Note:

Use of larger fluid tip/nozzle sizes while applying **Flakes** will allow for the flakes to lay flatter on the surface, resulting in less clear needed to cover the flake.

## CLEANUP:

Use appropriate cleaning materials compliant with VOC regulations in your area.

## STORAGE:

**Flakes**, **Lightning FX**, and **Paste Pearls** should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Paste Pearls** is 3 years when stored under normal conditions while the shelf life of **Lightning FX** and **Flakes** is unlimited.



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## RELATED PRODUCTS:

Part:	Product Name:	Size:
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
40401	Zero VOC Surface Cleaner	Gallon
40404	Zero VOC Surface Cleaner	Quart
MC011	Mix Clear	Gallon
MC014	Mix Clear	Quart
SR104	Fast Reducer	Quart
SR204	Medium Reducer	Quart
SR304	Slow Reducer	Quart
SRX14	Fast Exempt Reducer	Quart
SRX24	Medium Exempt Reducer	Quart
SRX34	Slow Exempt Reducer	Quart

### Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

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Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.