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COLOR HORIZONS
USERS MANUAL



COLOR HORIZONS is a premium custom finish paint system with exceptional versatility and a wide product offering. For over 20 years, painters have trusted **COLOR HORIZONS** to help them create works of art and one-of-a-kind masterpieces. With a complete line of primers, base colors, candies, pearls and clears, **COLOR HORIZONS** will take your paint job to the next level!

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TECHNICAL INSTRUCTIONS FOR COLOR HORIZONS

Read all instructions before you begin your project. All **COLOR HORIZONS** products are for trained professionals and are not intended for use by the general public.

CHECKLIST:

Equipment needed for proper use of **COLOR HORIZONS** products include:

- Proper safety equipment (respirator, gloves, safety glasses, etc.)
Please read the appropriate MSDS before using products.
- Proper ventilation and lighting.
- Air system (with dryer preferred).
- Fundamental knowledge of painting.

NOTE: It is not recommended to apply paint in temperatures below 70°F (21°C).

For best results, use SEM as a complete system from start to finish on your custom paint job. Do not intermix products from other paint lines, as mixing different chemistries can cause problems. Follow the guidelines provided in this booklet, such as mix ratios, reducers, dry times and clearcoat times.

WARNING LABELS:

Read all label cautions and warnings on all products.

MSDS:

Material Safety Data Sheets are available online at **www.sem.ws**.

VOC INFORMATION:

The National Rule and SCAQMD Rule 1151 both make distinctions between basecoat and mid-coat application. The VOC calculations are different depending on which application procedure is chosen. It is important to know whether the system you are using is classified as basecoat/clearcoat or as mid-coat/multi-stage system.

Example:

1. Basecoat/Clearcoat: Primer/Sealer/Basecoat/Clearcoat
2. Mid-coat (3-stage): Primer/Sealer/Basecoat/Mid-coat/Clearcoat

PREPARATION:

Read all instructions before you begin! Poor preparation can cause serious problems with the finished product.

SPEND MORE TIME NOW, RATHER THAN A LOT MORE LATER.

- Before sanding, wipe down entire surface with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**.
- All areas that require body filler, putties or fiberglass resins must be topcoated with **MLO10 METALOCK DTM HIGH BUILD PRIMER, TPO0() TRU PRIME TINTABLE** or **TPO1() TRU PRIME GRAY**. All finish sanding should be completed with 400-500 grit sand paper (preferably wet).
- Most base/candy colors are susceptible to bleed through or staining. Before applying any base/candy combination, a tinted sealer should be applied to seal the area and to assist in the coverage of base colors. See Sealer Tint Guide on page 2 for assistance on transparent colors.
- Any existing paint job over 6-8 mils should be sanded or stripped. Paint failure can occur from excessive film build.

TECHNICAL ASSISTANCE:

For any additional questions, please contact **SEM Products, Inc.**, at **(800) 831-1122**. 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.

SEALER TINT GUIDE

	White	Black	Gray (Metallic)	Similar to Base
02014 GOLD				
02024 SILVER				
02044 BRIGHT WHITE				
02054 JET BLACK				
02064 TITANIUM				
02074 KILARNEY GREEN				
02094 LIGHT GOLD				
02104 TRU BLUE				
02114 BRIGHT YELLOW				
02124 BLUE				
02134 GREEN				
02144 ORANGE				
02154 RED				
02164 VIOLET				
HYPERBASE COLORS				
FLUORESCENTS				

REDUCER GUIDE

<u>Part Number</u>	<u>Description</u>	<u>Temperature Range</u>	<u>Container</u>
SR10()	FAST REDUCER	50-70°F (10-21°C)	(1)-Gl. and (4)-Qt.
SR20()	MEDIUM REDUCER	70-90°F (21-32°C)	(1)-Gl. and (4)-Qt.
SR30()	SLOW REDUCER	90-115°F (32-46°C)	(1)-Gl. and (4)-Qt.
SRX1()	FAST EXEMPT REDUCER	50-70°F (10-21°C)	(1)-Gl. and (4)-Qt.
SRX2()	MEDIUM EXEMPT REDUCER	70-90°F (21-32°C)	(1)-Gl. and (4)-Qt.
SRX3()	SLOW EXEMPT REDUCER	90-115°F (32-46°C)	(1)-Gl. and (4)-Qt.

COLOR HORIZONS METALOCK DTM HIGH BUILD PRIMER KIT

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



MLO10 METALOCK DTM HIGH BUILD PRIMER KIT is a true direct-to-metal epoxy primer designed for metal, aluminum, SMC and fiberglass. **MLO10** utilizes the latest technology to provide superior adhesion, outstanding corrosion protection and exceptional sanding properties creating a solid and dependable foundation for any project.

PREPARATION:



Metal and Aluminum:

- Clean with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**. Apply to 180 grit sanded or sandblasted metal or aluminum. If rust or corrosion is present, grind or sand blast until all rust and corrosion has been removed. Blow off and clean again with **3837()** or **38381**.

SMC and Fiberglass:

- First, clean with **3835() PLASTIC/LEATHER PREP** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**. Next, sand with 180 grit sand paper. Blow off dust and re-clean with **3835()** or **38381**. Blow off again to ensure the surface is completely dry.

NOTE: When using **METALOCK** as a sealer, sand the surface with nothing more aggressive than 320 grit sandpaper.

MIXING:



Thoroughly mix **MLO11 METALOCK DTM HIGH BUILD PRIMER** and **MLH14 METALOCK HARDENER** before use.

As a **HIGH BUILD PRIMER**,
mix by volume:

4	=	1
MLO11		MLH14

As a **PRIMER SEALER**,
mix by volume:

4	=	1	=	1
MLO11		MLH14		SR/SRX SERIES REDUCER

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

METALOCK is ready to spray once mixed and does not require an induction period.

NOTE: **MLH14** may appear yellow or darken over time. This is normal and will not affect the product's performance.

APPLICATION:



Strain mixture into gun.

	Fluid Tip	Distance	Coats	Flash Time between Coats
METALOCK as a HIGH BUILD PRIMER	1.7-2.0	6-8"	2 Medium	10-15 Minutes
METALOCK as a PRIMER SEALER	1.3-1.5	6-8"	1 Medium	10-15 Minutes

Air Pressure:	6-9 psi at the cap with HVLP equipment 25-45 psi for non HVLP equipment
Time to Apply Body Filler:	24 hours
Time to Sand:	2 hours
Time to Topcoat as Sealer:	1 hour

Dry times may vary depending on film build and shop conditions.

If waiting longer than 24 hours to recoat, **METALOCK** must be sanded with 180 grit or finer sand paper.

COLOR HORIZONS TRU PRIME

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



TP00() TRU PRIME TINTABLE is a high quality urethane primer surfacer that can be tinted with most paint systems. Designed for high film build and easy sanding, this product saves time and money by creating a ground coat that is extremely similar to the top coat. If tinting is not needed, use **TP01() TRU PRIME GRAY**.

PREPARATION:



Bare Steel and Aluminum:

- First clean the surface with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**. Next apply **MLO10 METALOCK DTM HIGH BUILD PRIMER** and then sand with 180 grit sand paper. Re-clean with **3837()** or **38381**.

Pre-painted Surfaces:

- First clean the surface with **3833() SCUFF & CLEAN** and a gray scuff pad. Rinse well with water and wipe dry. Next, clean with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**. Then, sand the repair area and feather edge using 180 grit sand paper. Blow off dust and re-clean area with **3837()** or **38381**.

SMC and Fiberglass:

- First, clean with **3835() PLASTIC/LEATHER PREP**. Next, sand with 180 grit sand paper. Blow off dust and re-clean with **3835()**. Blow off again to ensure the surface is completely dry.

Plastic:

- First, clean the surface with **3833() SCUFF & CLEAN** and a gray scuff pad. Rinse well with water and wipe dry. Next, clean with **3835() PLASTIC/LEATHER PREP** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**. To promote adhesion on TPO, EPDM, PP and other similar thermoplastics, use **3986() PLASTIC ADHESION PROMOTER**.

MIXING:



Shake and stir **TRU PRIME** thoroughly before use.

NOTE: TP00() MUST BE TINTED. Use only automotive type paint without any binders or reducers – colorant only. Do not use water based or lacquer based colorants.

TP01() TRU PRIME GRAY

Mix by volume:

4	1	1
TP01()	SR/SRX SERIES	TC01()
GRAY	REDUCER*	CATALYST*

TP01() TRU PRIME GRAY - AS A SEALER

Mix by volume:

4	2	1
TP01()	SR/SRX SERIES	TC01()
GRAY	REDUCER*	CATALYST*

TP00() TRU PRIME TINTABLE

Mix by volume:

4	1	1	1
TP00()	SR/SRX SERIES	TC01()	COLORANT
TINTABLE	REDUCER*	CATALYST*	

TP00() TRU PRIME TINTABLE - AS A SEALER

Mix by volume:

4	2	1	1
TP00()	SR/SRX SERIES	TC01()	COLORANT
TINTABLE	REDUCER*	CATALYST*	

COLOR HORIZONS TRU PRIME

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

***TCX1() TRU EXEMPT CATALYST** and **SRX EXEMPT REDUCERS** must be used to meet 2.1 VOC regulations.

NOTE: Pot life is 60 minutes at 70°F (21°C). Temperature and humidity will affect pot life.

Part No.	Description	Temperature Range	Container
TC01()	TRU CATALYST	ALL	(4)-Qt. and (8)-Pt.
TCX1()	TRU EXEMPT CATALYST	ALL	(4)-Qt. and (8)-Pt.

APPLICATION:



Strain mixture into gun.

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.4-1.8	6-9 psi at the cap with HVLP equipment 25-45 psi for non HVLP equipment	6-8"	2-3 Medium Wet	5-10 Minutes

NOTE: Clean gun immediately after use.

DRYING TIMES:

Dry to Touch:	15-30 minutes
Time to Sand:	60-90 minutes
DFT After Sanding:	2-3 mils

TRU PRIME may be baked for 20-30 minutes at 140°F (60°C).

Dry times may vary depending on film build and shop conditions.

RECOATING:

First, sand surface with 180 grit sandpaper. Then reapply as needed. Final sand with 500 grit sandpaper. As a surfacer, re-coat within 24 hours. After 24 hours, sand with 500 grit sandpaper. As a sealer, re-coat within 1 hour. After 1 hour, scuff with gray scuff pad.

COLOR HORIZONS MIX CLEAR

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



MC01() MIX CLEAR is designed for intermixing all **COLOR HORIZONS CANDY CONCENTRATES, FLUORESCENT CONCENTRATES, PASTE PEARL CONCENTRATES, HYPER FX, LIGHTNING FX** and **FLAKES**. **MC01()** is the perfect carrier for **COLOR HORIZONS** products offering excellent sprayability, superior color holdout and minimal tape tracking on multiple tape outs.

PREPARATION:



Finish sand with nothing more aggressive than 500 grit paper. Wipe down surface with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER** after sanding. When using over tinted sealer, allow sealer to flash for 5-10 minutes before applying.

MIXING:



See appropriate mixing ratios for **CANDY CONCENTRATES, FLUORESCENT CONCENTRATES, PASTE PEARL CONCENTRATES, HYPER FX, LIGHTNING FX** and **FLAKES**.

As an inter-coat clear, mix by volume:

1	:	1
MC01()	:	SR/SRX SERIES REDUCER

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

APPLICATION:



Strain mixture into gun.

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	6-9 psi at the cap with HVLP equipment 25-45 psi for non HVLP equipment	6-8"	2-3 Medium	5-10 Minutes

Generally, if appropriate reducer is used, **MC01()** may be sanded in approximately 1 hour with 600 grit sand paper or a red/gray scuff pad. Artwork/stripping can be done before clearing. Allow to dry for at least 30 minutes before taping or doing artwork.

If more than 5 coats are applied, allow 30 minutes before clear coating.

Do not use as **MC01()** a topcoat clear.

Dry times may vary depending on film build and shop conditions.

COLOR HORIZONS BASE COLORS

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS BASE COLORS are vibrant, ready to reduce colors that may be clearcoated or used as basecoats under **COLOR HORIZONS CANDY CONCENTRATES**.

PREPARATION:



Read technical preparation; **BASE COLORS** are susceptible to staining or bleed through of body filler, putties and some primers. The project should be sealed with **MLO10 METALOCK DTM HIGH BUILD PRIMER** or **TPOO() TRU PRIME TINTABLE** close to the color of the basecoat before spraying basecoat. Remember, the sealer is not a “preventative coating for poor prep work.” It is only an adhesion promoter and will help in coverage of the basecoat. Using tinted sealer will improve hiding. “The top is only as good as the bottom!” See Sealer Tint Guide on page 2 for best results.

MIXING:



Shake all **BASE COLORS** at least 5 minutes before opening. All **BASE COLORS** are ready to reduce. **BASE COLORS** should be mixed 1:1 with appropriate **COLOR HORIZONS REDUCERS**.

Mix by volume:

1	:	1
BASE	:	SR/SRX SERIES
COLOR	:	REDUCER

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

APPLICATION:



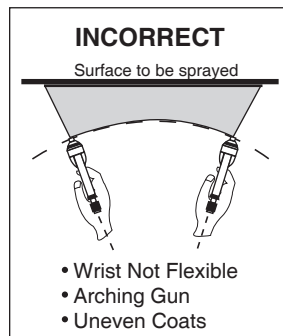
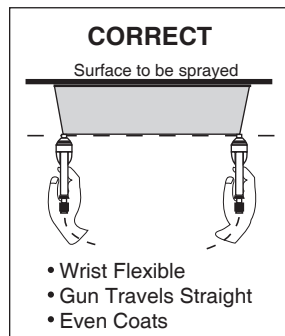
Strain mixture into gun.

LARGE PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	5-6"	2-4 Medium Wet	5-10 Minutes

SMALL PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.2-1.3	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	4-5"	2-4 Medium Wet	5-10 Minutes



- Always spray a test panel to confirm color and check for coverage.
- Overlap coats 50-75%.
- On large vehicles, use “full passes” when applying basecoat and candy colors. This will prevent dark or heavy edges on the ends of the panels.
- Do not apply heavy coats. Doing so will trap solvents and could cause splitting, cracking or solvent popping.
- Always allow plenty of flash time between coats.
- Allow 12-15 minutes before topcoating.
- Dry times may vary depending on film build and shop conditions.
- Do not rush! The time you spend now will triple if you have to redo it.

COLOR HORIZONS CANDY CONCENTRATES

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS CANDY CONCENTRATES offer incredible depth and clarity when applied over any **COLOR HORIZONS** product and help achieve the “custom look” for any project.

PREPARATION:



Read technical preparation; **CANDY CONCENTRATES** are susceptible to staining or bleed through of body filler, putties and some primers.

NOTE: At this time, check your base color to insure it has flashed off properly and coverage is obtained. Make sure all prep work looks good and the base color is smooth. Any imperfections in the base will be intensified by the application of candy. This is the moment where you can “make or break” your custom paint job. If extra attention is needed, now is the time!

MIXING:



Shake all **CANDY CONCENTRATES** thoroughly before use. All **CANDY CONCENTRATES** should be mixed 8:1 with **MC01() MIX CLEAR** before reducing.

First, mix by volume:

8	MC01()	:	1
MIX CLEAR			CANDY
			CONCENTRATE

Then

Mix by volume:

1	CANDY/MC01()	:	1
MIXTURE			SR/SRX SERIES
			REDUCER

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

APPLICATION:



Strain mixture into gun.

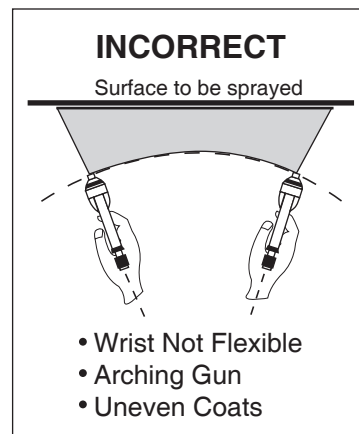
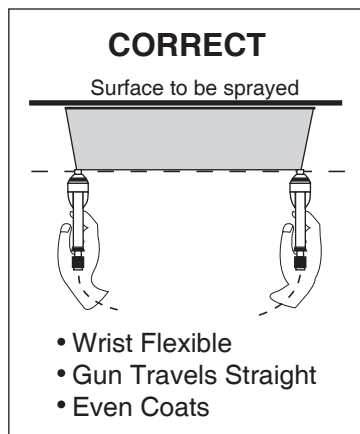
LARGE PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	5-6"	4-7 Medium Wet	5-10 Minutes

SMALL PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.2-1.3	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	4-5"	4-7 Medium Wet	5-10 Minutes

COLOR HORIZONS CANDY CONCENTRATES



PATTERN TEST:

Gun setup is critical to ensure a quality candy application.

Using a piece of masking paper, turn the air cap 90°, then spray material at 4-5" to check pattern. The width of the pattern should be the same, i.e. 4" distance = 4" pattern width.

Your pattern should look like this



and not this



or



Then return the air cap to the horizontal position.

- Always spray a test panel to confirm color and check for coverage.
- Always spray full passes when applying **CANDY CONCENTRATES**.
- Overlap coats 50-75%.
- Always allow plenty of flash time between coats.
- Dry times may vary depending on film build and shop conditions.

NOTE: Take your time when applying **CANDY CONCENTRATES**. Try to cover all edges when spraying panels. Failure to do so may leave thin spots in the paint job. Moreover, try not to go back over the edges, as it could leave dark or heavy areas. Pay close attention to how many coats you are applying. Your test panels will be very beneficial in determining the appropriate number of coats to achieve your custom look.

IMPORTANT: Some **CANDY CONCENTRATES** will bleed. To avoid bleed-through onto artwork or graphics, use **RC01() REAL CLEAR** between **CANDY CONCENTRATES** and artwork.

COLOR HORIZONS FLUORESCENT CONCENTRATES

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS FLUORESCENT CONCENTRATES are intense, eye-catching colors that are great for graphics on motorcycles, race cars or as a base for candy colors and pearls. All **FLUORESCENT CONCENTRATES** should be applied over **02044 BRIGHT WHITE** for maximum brightness.

NOTE: FLUORESCENT CONCENTRATES have a short lifetime because of their limited “light-fastness” in the sun and are not recommended for overall refinishing or when long life of the color application is required.

PREPARATION:



Read technical preparation; **FLUORESCENT CONCENTRATES** are susceptible to staining or bleed through of body filler, putties and some primers. The project should be sealed with **MLO10 METALOCK DTM HIGH BUILD PRIMER** or **TPOO() TRU PRIME TINTABLE** close to the color of the basecoat before spraying basecoat. See Sealer Tint Guide on page 2 for best results.

MIXING:



Shake all **FLUORESCENT CONCENTRATES** thoroughly before use. All **FLUORESCENT CONCENTRATES** should be mixed 4:1 with **MC01() MIX CLEAR** before reducing. To improve fluorescent coverage, you may tint **02044 BRIGHT WHITE** with desired **FLUORESCENT CONCENTRATE**, usually 10% before reducing.

First, mix by volume:

4	:	1
MC01()	:	FLUORESCENT
MIX CLEAR	:	CONCENTRATE

Then

Mix by volume:

1	:	1
FLUORESCENT/MC01()	:	SR/SRX SERIES
MIXTURE	:	REDUCER

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

APPLICATION:



Strain mixture into gun.

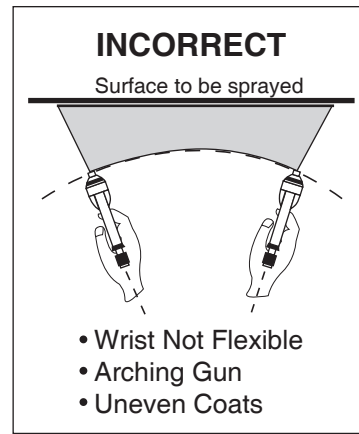
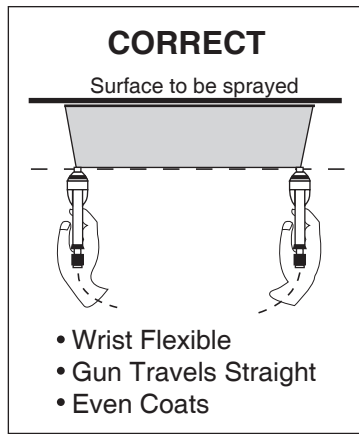
LARGE PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	5-6"	4-5 Medium	5-10 Minutes

SMALL PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.2-1.3	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	4-5"	4-5 Medium	5-10 Minutes

COLOR HORIZONS FLUORESCENT CONCENTRATES



PATTERN TEST:

Gun setup is critical to ensure a quality application and to prevent striping or streaking of the color. Using a piece of masking paper, turn the air cap 90°, then spray material at 4-5" to check pattern. The width of the pattern should be the same, i.e. 4" distance = 4" pattern width.

Your pattern should look like this



and not this



or



Then return the air cap to the horizontal position.

- Always spray a test panel to confirm color and check for coverage.
- Overlap coats 50-75%.
- Do not apply more than 6 coats of **FLUORESCENT CONCENTRATES**.
- All **FLUORESCENT CONCENTRATES** must be topcoated with candy or a clear coat.
- Always allow plenty of flash time between coats.
- Dry times may vary depending on film build and shop conditions.

NOTE: DO NOT DRY IN THE SUNLIGHT! The first 4-5 hours of dry time is the most critical. Special care is needed to prevent fading or discoloration in these early stages.

COLOR HORIZONS HYPERBASE COLORS

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS HYPERBASE COLORS are brilliant, ready to reduce pearlescent colors that may be clearcoated or used as basecoats under **COLOR HORIZONS CANDY CONCENTRATES**.

PREPARATION:



Read technical preparation; **HYPERBASE COLORS** are susceptible to staining or bleed through of body filler, putties and some primers. The project should be sealed with **MLO10 METALOCK DTM HIGH BUILD PRIMER** or **TPOO() TRU PRIME TINTABLE** close to the color of the basecoat before spraying basecoat. Remember, the sealer is not a “preventative coating for poor prep work.” It is only an adhesion promoter and will help in coverage of the basecoat. Using tinted sealer will improve hiding. “The top is only as good as the bottom!” See Sealer Tint Guide on page 2 for best results.

HYPERBASE COLORS can be applied over any **COLOR HORIZONS BASE COLOR**; however, coverage and color will be determined by the **BASE COLOR**. For maximum brightness, apply **HYPERBASE COLORS** over **02044 BRIGHT WHITE**.

MIXING:



Shake and stir all **HYPERBASE COLORS** to ensure proper mixing. All **HYPERBASE COLORS** are ready to reduce. **HYPERBASE COLORS** should be mixed 1:1 with appropriate **COLOR HORIZONS REDUCERS**.

Mix by volume:

1	:	1
HYPERBASE	:	SR/SRX SERIES
COLOR	:	REDUCER

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

APPLICATION:



Strain mixture into gun.

HYPERBASE COLORS contain heavy pearl pigments. When using gravity type guns, be sure to shake product in the gun periodically to reduce settling and ensure even pearl distribution.

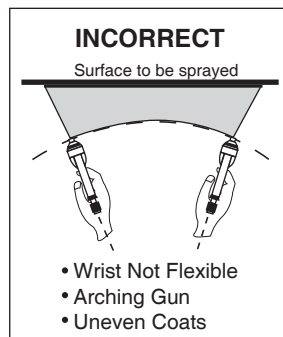
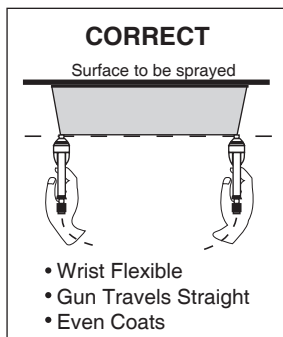
IMPORTANT: Some **HYPERBASE COLORS** will bleed. To avoid bleed-through onto artwork or graphics, use **RC01() REAL CLEAR** between **HYPERBASE COLORS** and artwork.

LARGE PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	5-6"	2-4 Medium	5-10 Minutes

SMALL PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.2-1.3	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	4-5"	2-4 Medium	5-10 Minutes



- Always spray a test panel to confirm color and check for coverage.
- Overlap coats 50-75%.
- On large vehicles, use “full passes” when applying basecoat and candy colors. This will prevent dark or heavy edges on the ends of the panels.
- Do not apply heavy coats. Doing so will trap solvents and could cause splitting, cracking or solvent popping.
- Always allow plenty of flash time between coats.
- Allow 12-15 minutes before topcoating.
- Dry times may vary depending on film build and shop conditions.
- Do not rush! The time you spend now will triple if you have to redo it.

COLOR HORIZONS LIGHTNING FX AND HYPER FX

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS LIGHTNING FX and **HYPER FX** will give your custom paint job a “pop!” **LIGHTNING FX** are glass pearl pigments with exceptional brilliance, transparency and reflectivity. **HYPER FX** contain Xirallic® pigments which intensify the level of color and add more glitter than traditional dry pearls. **LIGHTNING FX** and **HYPER FX** can be mixed with **MC01() MIX CLEAR**, **BASE COLORS**, **HYPERBASE COLORS**, **CANDY CONCENTRATES** or **RC01() REAL CLEAR**.

PREPARATION:



Read technical preparation; **COLOR HORIZONS LIGHTNING FX** and **HYPER FX** are susceptible to staining or bleed through of body filler, putties and some primers.

MIXING:



The mix ratio for **LIGHTNING FX** and **HYPER FX** is based on the painter's preferences.

Recommended starting points:

LIGHTNING FX: 10 grams (roughly two tablespoons) per ready to spray quart

HYPER FX: 5 grams (roughly one tablespoon) per ready to spray quart

APPLICATION:



Strain mixture into gun.

- Gun setup – 1.4 fluid tip.
- Always spray a test panel to insure the desired look.
- Lighter bases will require more material.
- For best results, use a siphon type gun with an agitator cup. **LIGHTNING FX** and **HYPER FX** will settle quickly and will build up in the gun tip when using gravity type guns.

COLOR HORIZONS FLAKES

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS FLAKES are precision cut chips; epoxy coated with light-fast color pigments. **06014 MINI GOLD** and **06024 MINI SILVER** are 100 microns while all other flakes are 1/64” in size. **FLAKES** are fade and solvent resistant to provide the maximum in lasting brilliance and can be mixed with **MC01() MIX CLEAR**, **BASE COLORS**, **CANDY CONCENTRATES** or **RC01() REAL CLEAR**.

MIXING:



The mix ratio for **FLAKES** is based on the painter's preferences.

Recommended starting points:

FLAKES: 10 grams per ready to spray quart

APPLICATION:



<u>FLAKE</u>	<u>FLUID TIP</u>
06014 – 06024 FLAKES	1.5 - 2.2
06034 – 06154 FLAKES	2.2 - 3.0

- Always spray a test panel to insure the desired look.
- Use a similar colored basecoat under **FLAKES**.
- For best results, use a siphon type gun with an agitator cup. **FLAKES** will settle quickly and will build up in the gun tip when using gravity type guns.

COLOR HORIZONS PASTE PEARL CONCENTRATES

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



COLOR HORIZONS PASTE PEARL CONCENTRATES are formulated in paste form for easy mixing with **MC01() MIX CLEAR**. For the ultimate custom look, mix **PASTE PEARL CONCENTRATES** with **BASE COLORS**, **HYPERBASE COLORS**, **CANDY CONCENTRATES** or **RC01() REAL CLEAR**.

PREPARATION:



Read technical preparation; **PASTE PEARL CONCENTRATES** are susceptible to staining or bleed through of body filler, putties and some primers.

MIXING:



Mix **PASTE PEARL CONCENTRATES** thoroughly before use.

Recommended starting points:

When applying **PASTE PEARL CONCENTRATES** over a dark base, add ¼ to ½ tablespoon of **PASTE PEARL CONCENTRATES** to one quart of ready to spray **MC01() MIX CLEAR**.

When applying **PASTE PEARL CONCENTRATES** over a light base or candy, add 1 to 2 tablespoons of **PASTE PEARL CONCENTRATES** to one quart of ready to spray **MC01() MIX CLEAR**.

APPLICATION:



Strain mixture into gun.

LARGE PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	5-6"	2-3 Medium Wet	5-10 Minutes

SMALL PROJECTS

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	4-5"	2-3 Medium Wet	5-10 Minutes

- Always spray a test panel to confirm color and check for coverage.
- Always spray full passes when applying **PASTE PEARL CONCENTRATES**.
- Overlap coats 50-75%.
- Do not apply heavy coats, as overcrowding of platelets will reduce the iridescent effect.
- Always allow plenty of flash time between coats.
- Dry times may vary depending on film build and shop conditions.
- Apply a candy color or clearcoat over **PASTE PEARL CONCENTRATES**.

COLOR HORIZONS VENOM ART FLUID

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



VF014 VENOM ART FLUID is another way to truly customize your project. **VENOM** can be used to create unlimited effects from a snake skin appearance to a marbled effect. **VENOM** can be mixed with everything from **HYPER FX** to **CANDY CONCENTRATES** and can be used as the finished product or topcoated with a candy. All you need is a little imagination. **VENOM** must be clearcoated after 30 minutes.

PREPARATION:



Apply desired basecoat color. **VENOM** may be applied over any color; however, **02054 JET BLACK** produces the most striking results. Let base dry 30 minutes before applying **VENOM**.

MIXING:



VENOM comes ready to spray. Shake well to ensure proper mixing. Strain into container and add desired **COLOR HORIZONS** product. Below is a chart for products and starting points. Always spray a test panel to insure desired look.

Recommended starting point per quart of **VENOM**

HYPER FX	1 tbsp.
LIGHTNING FX	2 tbs
PASTE PEARL CONCENTRATES	1 oz.
HYPERBASE COLORS	1 oz.
BASE COLOR	1 oz.
CANDY CONCENTRATES	1 oz.

NOTE: When using **COLOR HORIZONS CANDY CONCENTRATES** and **HYPERBASE COLORS**, dry times will speed up; do not apply **VENOM** to more area than you can cover with plastic wrap at one time. Work time is critical.

APPLICATION:



1. Allow base color to dry for 30 minutes before applying **VENOM**.
2. Apply 1 wet coat of **VENOM** mixed with desired **COLOR HORIZONS** product.
3. Immediately apply plastic wrap to wet **VENOM**.
4. Let **VENOM** dry for 1-2 minutes and then remove the plastic wrap.
5. Let project dry for 30 minutes.
6. Topcoat with **RC01() REAL CLEAR** or candy.

- Dry times may vary depending on film build and shop conditions.
- If **VENOM** dries before you apply the plastic wrap, simply reapply and try again
- Use thin plastic wrap for better effects. Thicker wrap = less effect.
- When doing small jobs like helmets or motorcycle parts, plastic wrap works great. On larger projects, use car cover plastic.

COLOR HORIZONS REAL CLEAR

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



RC01() REAL CLEAR is a premium, high solids urethane clearcoat designed for overall refinishing as well as spot repair. **RC01()** is formulated to provide excellent gloss and clarity and will result in excellent performance in both air dry and baking environments.

PREPARATION:



For OEM finishes/previously cleared:

Clean surface with **3833() SCUFF & CLEAN**. Rinse with water and dry. Next, sand surface with 500 grit sand paper. Wipe down with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**. Tack surface clean.

MIXING:



Mix **RC01()** thoroughly before use.

Mix by volume:

4	1	1
RC01()	RC02/RCX2()	SR/SRX SERIES
	CATALYST*	REDUCER*

***RCX2() REAL EXEMPT CATALYST** and **SRX EXEMPT REDUCERS** must be used to meet 2.1 VOC regulations.

Always use the reducer best suited to shop conditions. Please refer to Reducer Guide on page 2 for best results.

NOTE: Pot life is 60 minutes at 70°F (21°C). Temperature and humidity will affect pot life.

Part No.	Description	Temperature Range	Container
RC02()	REAL CATALYST	ALL	(4)-Qt. and (6)-½ Pt.
RCX2()	REAL EXEMPT CATALYST	ALL	(4)-Qt. and (6)-½ Pt.

APPLICATION:



Strain mixture into gun.

Allow basecoat color to flash 10-20 minutes before applying **RC01()**.

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	5-7"	2 Wet	Flash first coat until tacky, not stringy ~ 10 minutes

Dry times may vary depending on film build and shop conditions.

Flash time before baking	10 minutes
Bake time	1 hour @ 120°F (49°C)

NOTE: If buffing is required, allow **RC01()** to cure for 16 hours. Variations in film build, temperature, humidity and application will affect the time to buff. Begin by wet sanding with 2000 grit sand paper. Buff by machine at 1500-2000 rpm using a wool compounding pad and buffing compound. Continue with a quality grade foam finishing pad and a micro finishing polish. Finish with hand glaze. Do not use heavy build wax for 90 days.

COLOR HORIZONS HOT ROD BLACK

READ ALL INSTRUCTIONS BEFORE YOU BEGIN!

We do not recommend painting in temperatures below 70°F (21°C).

GENERAL INFORMATION:



HRO10 HOT ROD BLACK KIT is a matte finish 2K single stage topcoat system that provides outstanding color retention, excellent sprayability and superior mar resistance to create the ultimate custom look when painting accent stripes, hoods or entire vehicles.

PREPARATION:



Prime surface with **MLO10 METALOCK DTM HIGH BUILD PRIMER**, **TPO0() TRU PRIME** or **TP01() TRU PRIME TINTABLE**. Apply according to directions. Sand primed surface with 320-400 grit sandpaper. Blow off dust and clean with **3837() SEM SOLVE** or **38381 WORLD CLASS™ LOW VOC SURFACE CLEANER**.

MIXING:



Mix by volume:

4	=	1	=	1
HRO14		HRC02		HRR02

NOTE: Use of additives other than **HRC02 HOT ROD CATALYST** and **HRR02 HOT ROD REDUCER** are not recommended and will affect both the appearance and performance of **HOT ROD BLACK**.

APPLICATION:



Strain mixture into gun.

Fluid Tip	Air Pressure	Distance	Coats	Flash Time between Coats
1.3-1.4	8-10 psi at the cap with HVLP equipment 45-60 psi for non HVLP equipment	5-7"	2 Medium Wet	10-15 Minutes

Allow final coat of **HRO10** to flash for 10-15 minutes before baking for 30 minutes at 120°F (49°C), or air dry overnight.

Dry times may vary depending on film build and shop conditions.

NOTE: Always spray a test panel to ensure desired gloss level. Variations in temperature and gun set up can affect the final gloss of **HOT ROD BLACK**.

Do not re-coat after panel has been baked or air-dried without first sanding with 320 grit paper.

Do not buff or polish.



METALOCK pg. 3

ML010 METALOCK DTM HIGH BUILD PRIMER KIT

TRU PRIME pgs. 4-5

TP001	TRU PRIME TINTABLE (GL)	TC014	TRU CATALYST (QT)
TP004	TRU PRIME TINTABLE (QT)	TC018	TRU CATALYST (PT)
TP011	TRU PRIME GRAY (GL)	TCX14	TRU EXEMPT CATALYST (QT)
TP014	TRU PRIME GRAY (QT)	TCX18	TRU EXEMPT CATALYST (PT)

MIX CLEAR pg. 6

MC011	MIX CLEAR (GL)	MC014	MIX CLEAR (QT)
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BASE COLORS pg. 7

02014	GOLD	02074	KILARNEY GREEN	02134	GREEN
02024	SILVER	02094	LIGHT GOLD	02144	ORANGE
02044	BRIGHT WHITE	02104	TRU BLUE	02154	RED
02054	JET BLACK	02114	BRIGHT YELLOW	02164	VIOLET
02064	TITANIUM	02124	BLUE		

CANDY CONCENTRATES pgs. 8-9

03016	WINEFIRE	03076	ROOT BEER	03126	CALIFORNIA GOLD
03026	SUN DANCE	03086	MANDARIN	03136	ARUBA TEAL
03046	AQUA BLUE	03096	MINT GREEN	03156	MAGENTA
03056	ROYAL BLUE	03106	PASSION PURPLE		
03066	CLARET	03116	CANDY APPLE RED		

FLUORESCENT CONCENTRATES pgs. 10-11

03208	FIREBALL	03238	MAUI BLUE	03268	MARVEY MAGENTA
03218	CALIENTE	03248	MEAN GREEN	03278	WILD CHARTREUSE
03228	STOP LITE	03258	HOTTER THAN PINK	03288	SUN SPOT

HYPERBASE COLORS pg. 12

07014	LT.TITANIUM	07064	CORAL	07114	BLURPLE
07024	LEMONADE	07074	WISKEY	07124	REAL BLU
07034	24 KARROT	07084	SHOVELHEAD RED	07134	STEEL BLU
07044	MANGO	07094	CHERRY WINE	07144	AQUAMARINE
07054	ELECTRIC ORANGE	07104	PLUM	07154	LIMEADE

LIGHTNING FX pg. 13

33012	WHITE LIGHTNING	33032	HURRICANE RED	33052	THUNDER BLUE
33022	SUN GOLD	33042	ULTRA VIOLET	33062	ELECTRO GREEN

HYPER FX pg. 13

33302	QUICKSILVER	33332	FIRERED	33352	BLUE HAZE
33312	GOLDMINE	33342	GREEN ENVY	33362	PINK ICE
33322	COPPERHEAD				

FLAKES pg. 13

06014	MINI GOLD	06054	RED	06134	GOLD RAINBOW
06024	MINI SILVER	06064	GREEN	06144	SILVER RAINBOW
06034	BLUE	06074	BURNED COPPER	06154	SILVER
06044	GOLD	06124	SOLAR FIRE		

PASTE PEARLS pg. 14

35202	PLATINUM (2 OZ)	35224	GOLD 2-TONE (4 OZ)	35254	VIOLET 2-TONE (4 OZ)
35204	PLATINUM (4 OZ)	35232	BLUE 2-TONE (2 OZ)	35262	ORANGE 2-TONE (2 OZ)
35212	RED 2-TONE (2 OZ)	35234	BLUE 2-TONE (4 OZ)	35272	AZTEC GOLD (2 OZ)
35214	RED 2-TONE (4 OZ)	35242	GREEN 2-TONE (2 OZ)		
35222	GOLD 2-TONE (2 OZ)	35252	VIOLET 2-TONE (2 OZ)		

VENOM ART FLUID pg. 15

VF014 VENOM ART FLUID

REAL CLEAR pg. 16

RC011	REAL CLEAR (GL)	RC024	REAL CATALYST (QT)	RCX24	REAL EXEMPT CATALYST (QT)
RC014	REAL CLEAR (QT)	RC026	REAL CATALYST (½ PT)	RCX26	REAL EXEMPT CATALYST (½ PT)

HOT ROD BLACK pg. 17

HR010	HOT ROD BLACK KIT	HR013	HOT ROD BLACK AEROSOL
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REDUCERS

SR101	FAST REDUCER (GL)	SR301	SLOW REDUCER (GL)	SRX21	MEDIUM EXEMPT REDUCER (GL)
SR104	FAST REDUCER (QT)	SR304	SLOW REDUCER (QT)	SRX24	MEDIUM EXEMPT REDUCER (QT)
SR201	MEDIUM REDUCER (GL)	SRX11	FAST EXEMPT REDUCER (GL)	SRX31	SLOW EXEMPT REDUCER (GL)
SR204	MEDIUM REDUCER (QT)	SRX14	FAST EXEMPT REDUCER (QT)	SRX34	SLOW EXEMPT REDUCER (QT)



The Right Choice