



product name

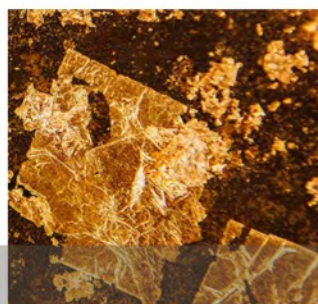
SMOKED METAL - METALLO BRUNITO

description

SMOKED METAL EFFECT PAINT

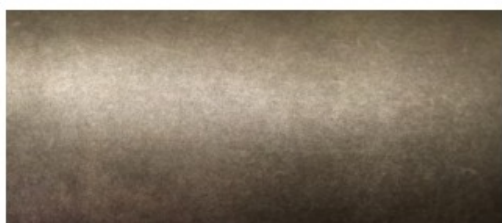


CROMAS

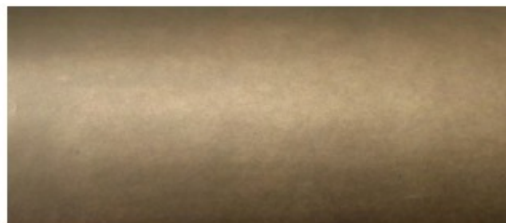


PAINTS INSPIRING CREATIVITY

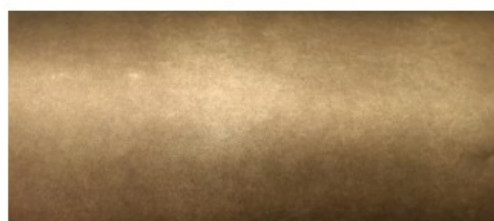
variazioni metalliche



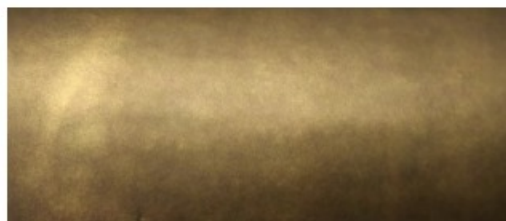
81015C | BURNED STEEL



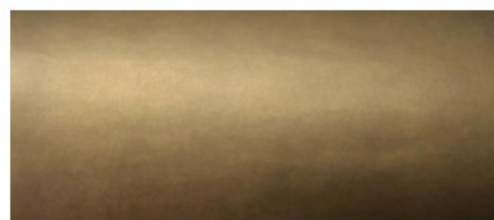
81016C | LONDON SMOKE



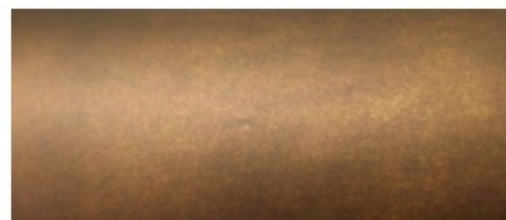
81017C | STEEL COFFEE



81018C | OLD LANTERN BRASS



81019C | BRONZED SHADOWS



81020C | BRONZED TOBACCO

product name

SMOKED METAL - METALLO BRUNITO

description

SMOKED METAL EFFECT PAINT

application

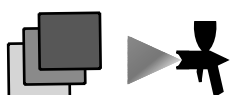


about	modified acrylic bi-component solvent-based paint
application area	commercial products, furniture, and artistic items to have an antiqued effect
application method	the product is applied by a spraygun or air-assisted pump

base colour and mixing of effect paint

the colours in the SMOKED METAL series are applied using the base colours from STEEL EFFECTS and SHINY METAL EFFECTS. See the below table as they use different amounts of hardener and thinner

CATALOGUE COLOUR	METALLIC BASE	PATINA	HARDENER (by weight)	THINNER (by weight)
81015C BURNED STEEL	SE.001 White Steel	DP7	10% SIN15	—
81016C LONDON SMOKE	SE.007 Burned Brass	DP7	10% SIN15	—
81017C STEEL COFFEE	SE.001 White Steel	SV177	10% SIN15	—
81018C OLD LANTERN BRASS	SM.001 Brass	DP7	20% SIN15	30% DP039/B
81019C BRONZED SHADOWS	SM.002 Bronze	DP7	20% SIN15	30% DP039/B
81020C BRONZED TOBACCO	SM.002 Bronze	SV177	20% SIN15	30% DP039/B



PAINTING CYCLE... see tables for details

**PRIMER + METALLIC BASE + BASE SV174 + Machine Sanding +
PATINA + TM069 MATT TRANSPARENT**



product description

- The painting cycle is simple, but some practise is needed to get the look you want. This is suitable for both large and small surfaces, flat or complex, tubular, etc.
- The painting can be made for indoor or outdoor (with transparent) use on many surfaces
- The effect is very realistic and can be customized. The final appearance looks like vintage metal that was subjected to a galvanic treatment and then aged to create darker areas
- It is very similar in appearance to the anodised surfaces produced with the galvanic method, but without the costs and the use of harmful substances typical of the galvanic industry

application cycle

The application of this product has been developed for spraying at 25°C. The product can also be dried in the oven, you will need to test the drying time.

1) The product can be applied over primers to prepare various surfaces. A primer must be applied on metal, plastics other than ABS plastic and MDF with a sealer coat

- **Primer Allgrip White or Primer VMP** are recommended primers, see primers on last page
- apply a white and even primer layer
- let the primer dry for at least 3-4 hours at room temperature, check surface

2) Apply the **Metallic colour**, mix according to the table on page 2...mix the paint well

- add Hardener SIN15 by weight
- add Thinner DP039-B by weight as needed
- apply one or more light cross-coat layers of the metallic base to build up a base layer colour.
- For the base paints SE.001, SE.002, SE.007 it is suggested to reduce the volume of paint from the spray gun and spray more layers to build up the metallic effect.
- Let the surface dry from 4-12 hours, check for dryness

3) Apply **BASE SV174**

- add Hardener SIN35 at 10% by weight, thinner is not required
- the base is needed to create an even sanded finish and also protects the metallic base colour
- let dry from 4 to a maximum of 24 hours before applying the patina, check surface for dryness

4) Apply the **Patina DP7 or SV177**

- the Patina DP7 and Patina SV177 should **be sprayed "dry" and not wet on the surface**
- **reduce the spray gun paint volume to spray multiple very light layers**
- Spray the patina on the surface at **4 m²/ltr**

application cycle

5) Sanding of the PATINA

- Shake and stir the can well before use. It is ready to use, no hardener or thinner required
- The patina dries quickly, after 1-2 hours, check surface, it needs to be completely dry
- Sand with an orbital sanding machine. Use abrasive pads like Mirka (MirlonTotal VF or MF) or with a rough Scotch Brite pad to make the effect you want. Do not use sandpaper
- Continually move the sander to remove the patina from the surface to make the Smoked Metal look you want. The sanding can also be done by hand. Be careful to not remove the patina from the edges and corners
- The effect allows you to sand off the patina until you see the effect you want. This is a creative process, but you **need to sand away most of the patina to have good adhesion with the transparent**

6) After sanding the patina, clean the surface and, within 4 hours, apply the **TM069 Matt Transparent** 2K Acrylic or another topcoat, see table on last page

- add hardener SIN35 at 30% by weight
- add thinner DP039-B only as needed, the surface will be less metallic when using thinner

ATTENTION:

- due to the required sanding of the patina to make the effect, it is recommended to perform spraying and sanding tests before beginning production to understand how to make the effect
- After the BASE SV174 is completely dry...check surface for smoothness, **if the surface is not smooth and clean, it will show as small marks during the sanding.** You can sand with 2000 grit sandpaper or higher to make the surface smooth

average coverage areas

PRODUCT	AVERAGE COVERAGE AREA (add hardener and thinner as required)	HARDENER AND THINNER
SE.001 White Steel	4 m ² /L	10% SIN15 - No Thinner
SE.002 Inox Steel	4 m ² /L	10% SIN15 - No Thinner
SE.007 Burned Brass	4 m ² /L	10% SIN15 - No Thinner
SM.001 Brass	4 m ² /kg	20% SIN15 - 30% DP039/B
SM.002 Bronze	4 m ² /kg	20% SIN15 - 30% DP039/B
BASE SV174	5 m ² /L	10% SIN35 - No Thinner
PATINA DP7	5 m ² /L	No Hardener - No Thinner
PATINA SV177	5 m ² /L	No Hardener - No Thinner
TM069 MATT TRANSPARENT	6 m ² /L	30% SIN35 - No Thinner



Other Suggested Primers

Product	Coverage	Hardener	Thinner	Colour
PRIMER SV366AF02 Epoxy Primer Anticorrosive	5 m2/kg	20% EP720	40-50% DN500	White
SV033AE01 Epoxy Vinyl Primer	5 m2/kg	15% EP720	40-50% DN500	White
PRIMER VMP Acrylic Primer	5-6 m2/L	10% SIN40	not required	Transparent
BASE DSA 80 Acrylic Primer	5-6 m2/kg	10% SIN40	40-60% DP039-B	Transparent
SV095AD02 Elastic Polyurethane Primer	5 m2/kg	25% SIN35	20-40% DP039-B	White
ALLGRIP Acrylic Primer	5 m2/kg	10% SIN40	40-50% DP039-B	White

Other Suggested Transparents

Product	Coverage	Hardener	Thinner	Colour
SV056AG02 Transparent acrylic for exterior use - high resistant topcoat with Teflon additives	6-8 m2/kg	30% SIN40	40% DP039-B	Transparent, gloss 10
TM069 Transparent acrylic for exterior use - topcoat with Teflon additives - low thickness topcoat, used on samples	6-8 m2/kg	30% SIN35	0-20% DP039-B	Transparent, gloss 10
SV142AD02 Transparent acrylic for exterior use - very clear, non-yellowing	6-8 m2/kg	30% SIN40	40% DP039-B	Transparent, gloss 5
NANOMATT 05 Transparent acrylic for interior use	6-8 m2/kg	25% SIN63	40% DP039-B	Transparent, gloss 5

Revisione scheda V1.19

I dati e le informazioni contenute nella presente scheda tecnica, sono frutto della nostra esperienza e di accurate prove e test di laboratorio. Essendo tuttavia la verniciatura, un processo che include un insieme di operazioni al di fuori delle nostre possibilità di controllo, l'applicazione e le prestazioni dei prodotti, ricadono sotto l'esclusiva responsabilità dell'utilizzatore.

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