



Spraying Glass With A Crackle Glaze

How our product works.

Firstly it is important to understand how our product works as it is different to most 2K products that are normally baked on after application. Our product produces a chemical reaction with the substrate to which you are applying onto, thus saving the time and cost of baking the coating on, making this product very quick and cost effective in use.

This means that if there are any contaminants left on the surface of the glass, the chemical reaction will not take place and the coating will not adhere to the substrate. Providing that the glass is clean, the chemical reaction will take place and there will be no problem with the adhesion, which is exceptionally good.





RECEIVING GLASS AND INSPECTION

Always inspect the glass when it is delivered to you as your supplier may not accept returns at a later date. Do not let water get onto the stored glass as it can leave water marks on the surface which cannot be removed, rendering the glass un-usable.

It is very important to thoroughly inspect the glass for any marks, scratches or air bubbles, as when the glass is coated the marks will be highlighted by the coating and could make the final product unacceptable for your customer.

If you have very small marks on the glass it may still be useable for a sparkle or crackle glaze finish, as they tend to hide these small marks.



Before any spraying takes place it is very important to ensure that the glass is crystal clean and free from contaminates and particles.



When applying our paint onto glass, we highly recommend the use of our AVKOTE Glass Cleaner to prepare the surface. Some other brands of glass cleaner can be oily which will leave a residue, stopping the paint from adhering to the glass. Vetro cleaner in particular is not suitable for use with our glass paint, due to it being an adhesion promoter and its oily consistency, which is not consistent with our product.



STEP 2.

HOW TO SET UP YOUR BOOTH

On trestles, it is advisable to apply masking tape to the top surface so that any build-up of paint can be easily removed.

It is advisable to spray a dip card for each job with the paint colour you are using, remembering to include a batch number so that it has traceability, or for colour matching of any future continuation jobs.

Cards can be taped next to the glass to be painted.



STEP 3.

PREPARING SPRAY GUNS AND PAINT

We recommend using two spray guns to carry out this part of the process. Always make sure that your spray equipment is clean and ready to use with the correct jet and air cap size.

The lacquer and paint always needs to be mixed well before pouring. This can be done in a shaker or stirred thoroughly using a mixing stick.



The first part of the mixing process is to pour out the required amount of shaken/stirred lacquer into the appropriate container.

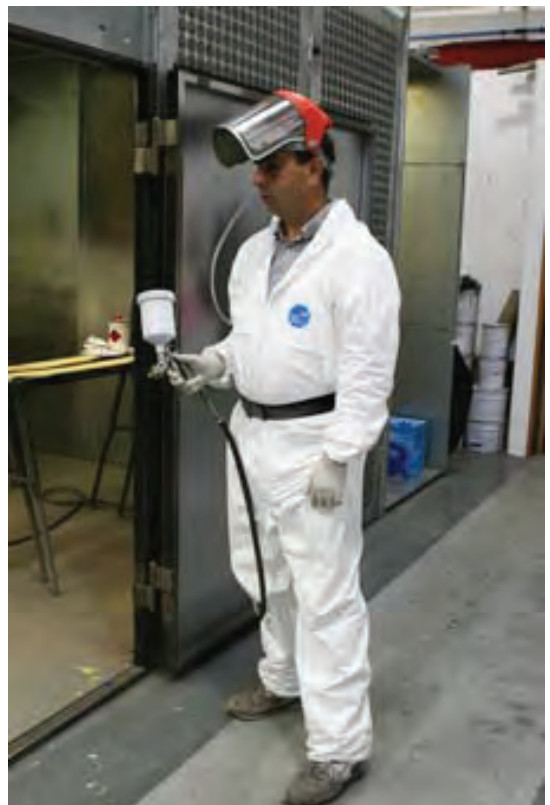
Mixing in the hardener can be done by weight on a set of scales. The mix ratio for the lacquer is 4:1 (4 parts lacquer: 1 part hardener).

This can also be done by volume in a measuring jug or in a container with a measuring stick. It is imperative that the correct amount of hardener is put in as this affects the drying time, the adhesion, the gloss level and the elasticity and longevity of the product.

When the paint is ready to be sprayed, pour it into your spray gun using an appropriate paint filter. Please note, if you are using the sparkle clear coat, please remove the filter.

Always use all of the appropriate safety equipment and extraction for the product being used. Please follow the relevant safety data sheets for the product you are using.

Next, you will need to measure out the required crackle colour into the appropriate container. Mixing in the hardener can be done by weight on a set of scales. The mix ratio for this is 10:1 (10 parts crackle colour: 1 part hardener).





FINAL PREPARATION

Always clean the glass just before the first coat is applied with a 100% lint free cotton cloth and an air gun, ensuring you remove any contamination from the surface. This will show up when the coating is applied.





SPRAYING THE FIRST FEW COATS SHOWING HOW YOU NEED TO BUILD UP THE FIRST FEW COATS TO GET TO THE RIGHT FINISH

It is important that the upmost attention is paid to the application of the first coat, as this is the top coat you are going to see.

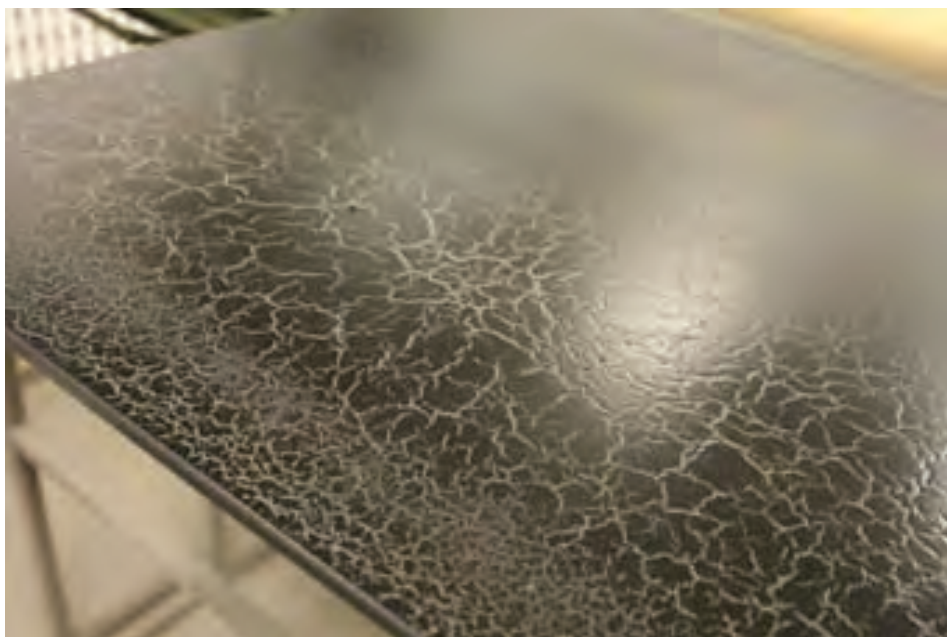
If any marks or contaminants do appear in this coat the crackle glaze will normally hide any small particles. However, if the particles are large then the coating should be cleaned off and started again. Please bare in mind after about an hour of drying it is very difficult to remove this coating and you will probably damage the glass in the process.



It is best to test the following process first to ensure that you achieve the desired amount of crackle effect before proceeding with the job.

Using Gun 1 - The first coat is a slow drying clear coat lacquer, which normally requires 2 full coats sprayed in opposite directions. This ensures you get even coverage.

Using Gun 2 – The first coat of the crackle colour can be a light coat followed by a heavier second coat. The first needs to be applied wet on wet with the clear coat lacquer (Gun 1). The heavier the coating, the bigger the crackle effect.





APPLICATION OF THE BACKING COAT

Leave the crackle colour to dry for approximately 30 minutes. The final backing coat can then be applied on top of the crackle coat. Subsequent backing coats can be applied after a few minutes as soon as they have flashed off.

You do not have to be as concerned about contamination on these coats as they will not be seen on the finished surface.



TESTING WITH LIGHT TO SEE IF IT'S OPAQUE AND COMPLETELY COVERED

If the backing colour is a light colour it is important to check that the finish is opaque. For this we recommend using a LED hand lamp which is put under the glass to check the opacity.





STACKING FOR DRYING

The product is tack free within about 3-5 minutes and can then be stacked for curing. Specification of the racking seen below can be obtained from AVKO.

We recommend using a racking system where you can lay the glass onto the rack and the arms can be inserted into the wall fixture, so the next sheet can lay on the next rack above/below. This way you will have less chance of damaging the coating.



The glass can now be left to chemically cure for 24 hrs. It will cure from 8-10 degrees and above. At 20 degrees it will be 70% cured in about an hour and will be dry enough to handle.

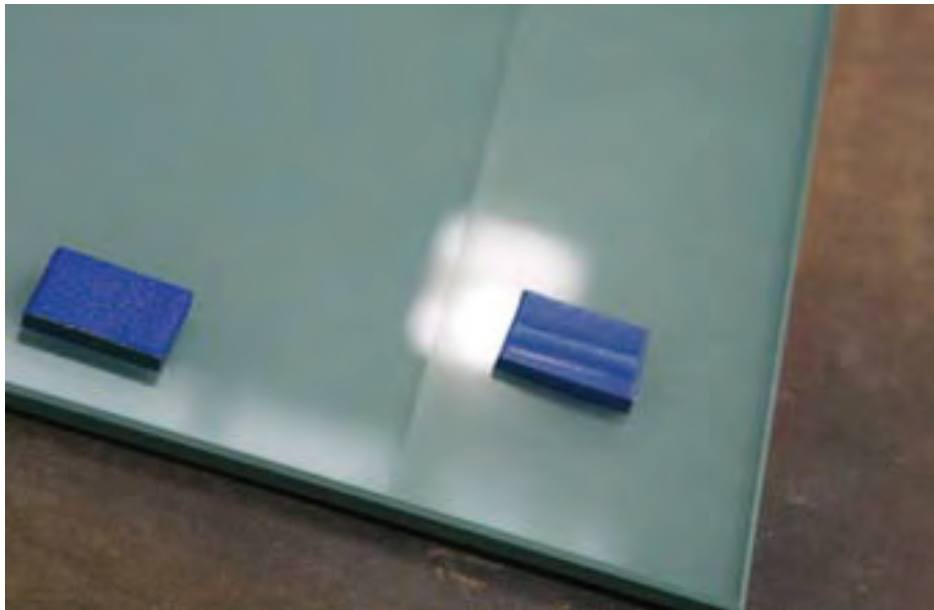
The only thing that must be noted, is that the coating must not be subjected to sub zero temperatures before it has a chance to cure, as it will go brittle and not cure sufficiently.



CLEANING & FINISHING BEFORE PACKING

Glass pads should be used to hold the glass apart to prevent any damage from occurring.

Any overspray should be removed and the finish inspected before packing the final product.



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