



Spraying Glass With A Metallic

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 useless.

It is very important to inspect the glass critically 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 rainbow 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 contaminants 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.



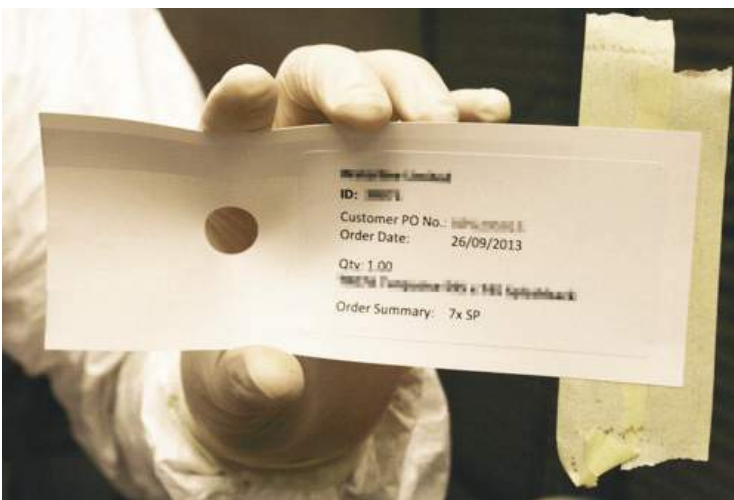
HOW TO SET UP YOUR BOOTH

Glass can be sprayed horizontally on trestles, a rotating table or vertically on A frames.

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.



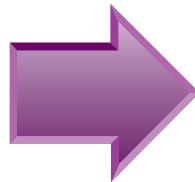


PREPARING SPRAY GUNS AND PAINT

Always make sure that your spray equipment is clean and ready to use with the correct jet and air cap size. The paint always needs to be mixed well before pouring. This can be done in a shaker or by hand with a mixing stick.



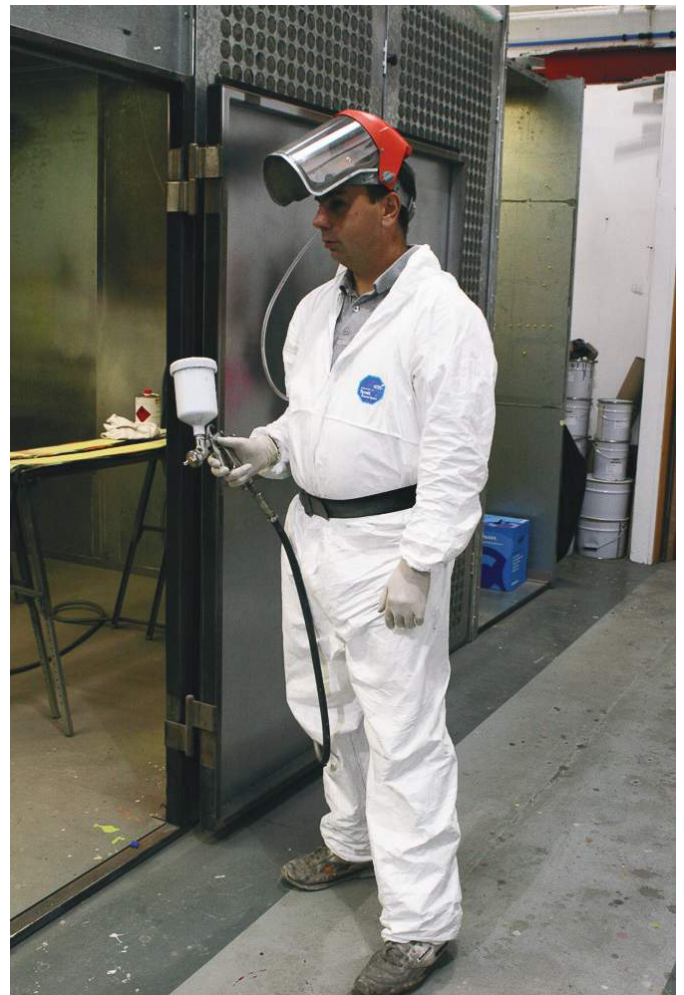
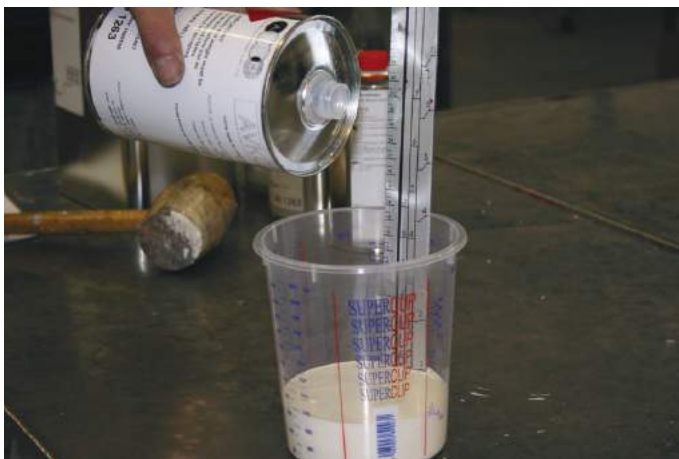
The first part of the mixing process is to pour out the stirred or shaken paint into the appropriate container. Mixing in the hardener can be done by weight on a set of scales.



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 the longevity of the product. Please refer to the TDS for the mixing ratio.

If required, when the paint is ready for spraying, pour it into your spray gun using an appropriate paint filter. Please note, if you are filtering the paint please use the relevant filter required for the grade of metallic that you are using.

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





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 as this will show up badly when the coating is on.





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 going to end up as the top coat you are going to see.

If any marks or contaminates do appear in this coat, the coating can be cleaned off and started again. Although after about an hour of drying it is very difficult to remove this coating and you will probably damage the glass.

The first two to three coats of a metallic finish are critical to obtaining an acceptable finished product.



The problem with a metallic finish is that if you do not get an even coat, the aluminium particles in the paint will converge together and reflect the light in a way that will look like dark wavy lines in the finish.

The way to stop this is to make sure that your gun is set right so that the paint is atomising correctly with the paint flow set low.

This will allow you to put 2-4 coats on lightly but evenly.

This is essential to get an acceptable finish.

Once you have applied 2-4 coats, inspect the finish before proceeding any further, If it is not a good finish, clean it off and start again



SPRAYING INTERMEDIATE AND FINAL COATS

Once you have achieved a good finish with the first 2-4 coats, you can then apply the last coats a lot heavier to achieve the required opacity of the coating.

Subsequent coats can be applied after a few minutes as soon as it has flashed off.

You do not have to be as concerned about contamination or the look of these coats as they will not be seen on the finished product.

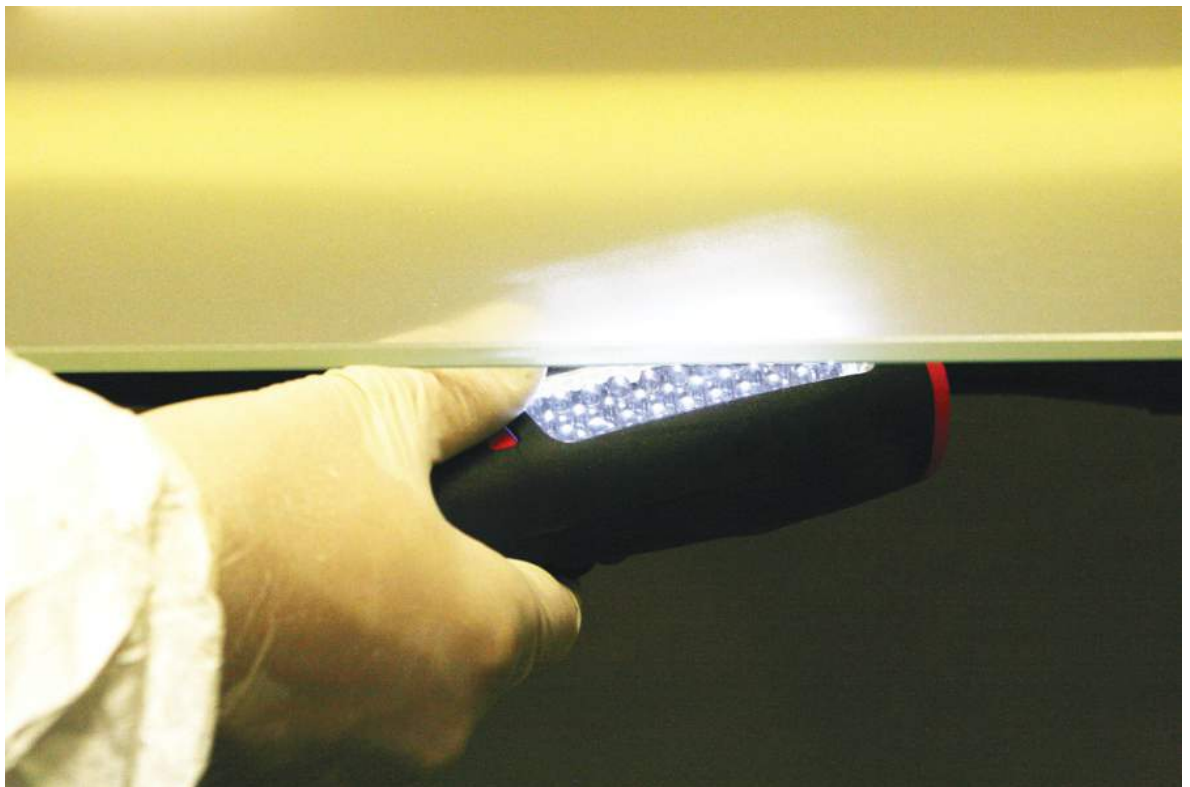




TESTING WITH LIGHT TO SEE IF IT'S OPAQUE AND COMPLETELY COVERED



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.



This 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 properly.



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 ready for your customer.

