



Product Information in GRS Basecoat



Ditzler® Big Flake™

VM4401 Big Flake™ – Gold	VM4421 Big Flake™ – Mini Silver
VM4402 Big Flake™ – Silver	VM4422 Big Flake™ – Red
VM4403 Big Flake™ – Green to Purple	VM4423 Big Flake™ – Orange
VM4404 Big Flake™ – Blue to Red	VM4424 Big Flake™ – Blue
VM4405 Big Flake™ – Red to Gold	VM4425 Big Flake™ – Purple
VM4406 Big Flake™ – Gold to Silver	VM4426 Big Flake™ – Green
VM4420 Big Flake™ – Mini Gold	

Ditzler Big Flake is offered in 9 colours as well as 4 colour-shifting versions to create a wide range of basecoat and tri-coat custom colour formulations.

Ditzler Big Flake can be added directly to basecoats or used as a ground coat for *Radiance II* midcoats. Big Flake can also be added to colour blenders, midcoats or *Radiance II* and used as a midcoat/pearlcoat effect.



Compatible Products and Systems

Ditzler Big Flake can be used in conjunction with the systems and products shown below:

- GRS BC – Refer to GRS BC Data Sheet for recommendations on correct preparation and compatible primers.
- D895 Colour Blender – Refer to Global BC Data Sheet for recommendations on correct preparation and compatible

Directions For Use

Surface Preparation:



When working on custom finishes close attention to the details outlined for standard basecoat preparation, sanding, and cleaning is needed to achieve the optimum results.



Ditzler Big Flake colours are designed to be applied over properly cleaned, sanded and primed surfaces. See product data sheets for GRS BC for appropriate preparation.

Directions For Use

Mixing:

(adding VM44xx to a basecoat colour or blender)

For a custom formulation you may add a maximum of 4% (by weight) *Ditzler Big Flake* to unreduced colour or 2% (by weight) to ready-to-spray container of BC, D895, VWM5555, VWM5556 or EHP. A **table for weights and amounts appears on page 3**. Please follow the instructions found in the clear section of this bulletin for recommended clearcoat film builds.

Reducing:

(basecoat colour or blender already containing VM44xx)



BC/D895 Reduction w/ VM44XX

Colour

D841

DXXX Thinner

8

:

1

:

7

D841 MS Hardener must be used in BC colours containing *Big Flake*.

When using *Big Flake* tri-coat custom colours, **D841** activator **must** be used in both the ground coat and midcoat colours. The Pot life of these mixtures is 2 hours at 20°C.

Spray gun Set-up:



Apply:

Sufficient number of coats to achieve desired effect

Fluid Tip:

1.2 - 1.5 mm or equivalent

1.6 - 1.8 mm or equivalent (for VM4401 Gold and VM4402 Silver flakes)

Air Pressure:

For optimum results use SATA sprayguns

1.3 – 1.8 bar (20-25 PSI) at the gun for HVLP/RP

1.8 – 2.5 bar (25-35 PSI) at the gun for conventional guns

Drying Times:



Between Coats:

@ 20°C

5 – 10 minutes

Dry Time to Clearcoat:

@ 20°C

15 minutes at (20°C)

24 hour maximum to clearcoat

Tape Time:

@ 20°C

30 - 60 minutes with D841

Note: Basecoat colours are designed to dry low in gloss. This makes colour match and its approval difficult to see until the clearcoat is applied. **A good technique is to spray the basecoat and clearcoat on a small test panel before spraying the job.**

If the basecoat colour is allowed to dry more than 24 hours, apply one single coat D895 mixed 1:1 with DXXX Thinner before proceeding.

Striping or Two Toning:

Tape time of BC is 30 - 60 minutes @ 20°C and 50% relative humidity.

All striping, two toning must be completed within 24 hours. If allowed to dry for more than 24 hours, apply one single coat D895 mixed 1:1 with DXXX Thinner before proceeding.

In all cases, avoid thick films of basecoat.

Tri-Coat Mixing:

When applying BC basecoats, D841 must be added to the basecoat prior to spraying in BOTH the ground coat and mid coat.

Ditzler Big Flake can be blended as a mid-coat colour with D895 Colour Blenders. In doing so you can achieve more transparency, when combined with varying ground coat colours and create different degrees of custom effects. D895 colour blender can be used in any quantity necessary to achieve the desired effect.

Clearcoating:

Due to the large particle size of the *Ditzler Big Flake* pigment, you **must** apply 65 – 75 microns of clear (usually 2 - 4 coats) to cover the basecoat.

Clear with any clear recommended for Global BC (see the relevant Data Sheets for correct mixing and application)

Technical Data:

Colour side mix:	BC/D895 (w/ VM44XX)
Applicable Use Category:	N/A
RTS Volume Ratio:	1:1
Volume Solids (RTS)	10-15%
Dry Film Build Per Coat	7.5 – 12.5 microns

Important:



The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Styling Tips

- A thicker and wetter film will help to level the VM4401 Gold and VM4402 Silver flakes. When flakes are sprayed on too dry, they stand up on end, appear dirtier and are harder to cover with clear.
- A fluid tip of 1.6 - 1.8 mm or equivalent will give the best results with VM4401 Gold and VM4402 Silver (see *Spray gun Set-up* section on previous page).
- When using as a midcoat, VM4401 Gold and VM4402 Silver flakes spray better in a medium solid clear than a basecoat blender. For example, used with D800, D8112, D8120, or D8173, the finished product will be much smoother than if you were doing the job with the flake mixed in BC basecoats or VWM5556 midcoat.
- The following basecoat colours are recommended for use under the *Big Flakes* to maximize effect. All *Big Flake* colour may be applied over a number of different basecoat colours to achieve many different effects and appearances..

Big Flake Colour		Basecoat Colour
Gold VM4401	over	25622
Mini Gold VM4420		
Silver VM4402	over	33896
Mini Silver VM4421		
VM4403 Green to Purple	over	9700
VM4404 Blue to Red		
VM4405 Red to Gold		
VM4406 Gold to Silver		

- Adding any of the colour shifting Ditzler Big Flake products directly to a basecoat colour may cause the final colour appear darker or dirtier.
- Applying any of the colour shifting Ditzler Big Flake products as a midcoat may cause the final colour to appear darker or dirtier than without the flake containing midcoat.
- It is recommended that a complete spray out panel (including clearcoat) is created for each colour combination to verify what the final appearance will be.

Mixing Amounts

For a custom formulation you may add a maximum of 4% (by weight) Big Flake to unreduced colour or 2% (by weight) to ready-to-spray container of BC, D895, VWM5556 or EHP. All amounts shown in the table below are by weight (grams or parts) and not volume (ounces)

Unreduced D895 Grams or Parts (by weight)	VM44xx Grams or Parts (by weight)	Reduced D895 Grams or Parts (by weight)	VM44xx Grams or Parts (by weight)
100	4	100	2
150	6	150	3
200	8	200	4
250	10	250	5
300	12	300	6
350	14	350	7
400	16	400	8



Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.

Global Hardeners and activated clearcoats contain isocyanate and therefore particular safety precautions must be taken.

Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.

Good ventilation and extraction must be provided in the working environment.

Wear suitable protective equipment to prevent skin contact with this material.

When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.

Do not smoke whilst using this material.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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