

## VOC-compliant special effect system: Marbleizing



Please also see the technical data sheet "CARIZZMA Substrates and Pretreatment"

### General information:

For this special effect system you need a covering basecoat. In the second step you apply the special effect coat using a plastic film technique. As a last step you apply the finishing clear. The special effect is achieved by using a suitable colour combination. You have free choice between all colours and so you should choose contrasting bright and dark colours to get a strong effect.

### Details for a model paint system:

The details below are for a paint system consisting of a white ONYX HD (or UNO HD CP) basecoat with clear and a blue ONYX HD special effect coat (SB174.00).


#### 1. Basecoat:

	Mixing ratio	ONYX HD white HYDROMIX	100% by vol. 60% by vol.
	Spraygun	HVLP gravity-feed spraygun	1.4 – 1.5 mm 0.7 bar at the nozzle
	Application	Spraycoats: Film thickness: Flash off	2 – 3 20 – 25 µm until mat after each spraycoat.
	Mixing ratio	CARIZZMA CUSTOMCLEAR CP H 420 SC 850	300% by vol. 100% by vol. 100% by vol.
	Spraygun	HVLP gravity-feed spraygun	1,3 – 1,5 mm
	Application	Spraycoats: Flash off:	2 3 min between spraycoats
	Drying	Drying at 60°C	30 min.

Note: Dry-sand by machine with P400 or wet-sand by hand with P800 before masking.


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### 2. Special effect coat:

	<b>Mixing ratio:</b>	<b>ONYX HD blue HYDROMIX</b>	<b>100% by vol. 60% by vol.</b>
	<b>Spraygun: Pressure: Number of spraycoats:</b>	<b>1.5 mm HVLP 2.0 bar 1 wet coat</b>	
	<b>Special effect:</b>	<b>Cover the wet basecoat with a plastic film and pull it off again. Repeat the process if necessary.</b>	
	<b>Flash-off:</b>	<b>until mat.</b>	

**Note:** Remove the masking film and adhesive strips after the flash-off.

### 3. Finishing clear

	<b>Mixing ratio:</b>	<b>CARIZZMA CUSTOMCLEAR CP H 420 SC 850</b>	<b>300% by vol. 100% by vol. 100% by vol.</b>
	<b>Spraygun and pressure: Number of spraycoats:</b>	<b>1.3 – 1.5 mm HVLP / 2.0 bar 2</b>	
	<b>Flash-off:</b>	<b>3 min. between spraycoats</b>	
	<b>Drying:</b>	<b>30 min. at 60°C</b>	

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