

## ROXATONE APPLICATION GUIDE

### CONVENTIONAL SPRAY EQUIPMENT:

- AIR COMPRESSOR (2.5 HP or larger)
- PRESSURE POT WITH DUAL REGULATORS (air + material)
- BINKS 2001 GUN WITH INTERNAL MIX TIP – AIR CAP SIZE: #201 or #204

### STEP 1 – SHEER COAT

The “sheer” coat is a high pressure first coat that requires complete coverage of the surface. This coat provides the durability and hiding power necessary for a successfully applied multicolor project. There is very little multicolor effect visible after the sheer coat is applied and there should be no primer or underlying paint color showing through the sheer coat. Make sure exposed areas not to be painted in Roxatone are properly masked and protected from product over-spray. Once masking is complete apply the Roxatone sheer coat with the following pressure settings:

#### FLUID AND AIR PRESSURE SETTINGS FOR THE SHEER COAT ARE:

**AIR PRESSURE:** 50 – 60 PSI

**FLUID PRESSURE:** 50 – 60 PSI

Apply Sheer Coat with a “cross-hatch” technique at a distance of 12 – 14 inches from the surface. Do a horizontal pass first, return to the starting point and apply vertical strokes. This method ensures complete surface coverage. The surface should be primed in high quality white primer before this application unless otherwise specified by the manufacturer or dealer.

### STEP 2 – THE PATTERN COAT

The “Pattern” Coat is the final coat and is applied using lower air pressure. This coat provides the color pattern and particle size required to match the approved sample. This coat is applied over a “tacky” or dry shear-coat. If the pattern coat is applied over a wet shear coat there will be an increased wet film build that may lead to sagging or reduced cure times.

#### FLUID AND AIR PRESSURE SETTINGS FOR THE PATTERN COAT ARE:

**AIR PRESSURE:** 40 – 50 PSI

**FLUID PRESSURE:** 50 – 60 PSI

Apply the Pattern Coat using the same cross-hatch method as in the Sheer Coat application. Use overlapping, horizontal and vertical strokes to ensure consistent and even distribution of the particles. Apply this coat from a distance of 20 – 24 inches from the surface.

**Note:** The air pressure used during the Pattern Coat may have to be adjusted in order to obtain proper particle size. If a larger particle is desired, the air pressure must be lowered. If a smaller particle is desired a higher air pressure setting must be used.

### HVLP APPLICATION INSTRUCTIONS:

- HVLP TURNIBE SPRAY MACHINE
- PRESSURE POT OR CUP GUN
- LARGE TIP SIZE (consult manufacturers tip charts)

Application of Roxatone using HVLP equipment is very easy and produces excellent results. It is important to have a good quality base coat applied before the Roxatone application. It is recommended that the base coat be tinted to a similar color to the Roxatone background color to ensure proper coverage. HVLP equipment does not yield high air pressure settings required for a “sheer coat” so the tinted primer is strongly advised.

PLEASE NOTE: ROXATONE IS DELIVERED READY TO APPLY, HOWEVER DUE TO THE VARIOUS EQUIPMENT TYPES AND METHODS OF APPLICATION SHOULD THE PRODUCT NOT SPRAY ADEQUATELY USING THE AVAILABLE EQUIPMENT THINNING WITH WATER IS ADVISED.

**PLEASE NOTE: Because of the many variables associated with the manufacturing process and application methods there may be a slight variance between the approved color sample and the final result.**