



## Special Effects Factory Packaged and Intermix Colors

FX1 – Maple    FX2 – Jade  
FX3 – Scarab    FX4 – Sapphire

### PRODUCT DESCRIPTION:

Special Effects creates a variety of effects depending on body contours, angle of view, and light sources. This effect is created by bending and dispersing light through spiral flakes, resulting in dramatic color travel and brilliance.

Special Effects are offered in Factory Packaged and Intermix Colors and utilize the ULTRA 7000® Basecoat Stabilizers. Special Effects can be custom mixed using ULTRA 7000® toners (see Guidelines listed below).

### TECHNICAL DATA:

- |   |             |                                      |         |
|---|-------------|--------------------------------------|---------|
| • Mixing ratio by volume                            | 16 : 16 : 1 | • Air Pressure at cap – HVLP         | 7-9 psi |
| Special Effects Color : Basecoat Stabilizer : UH904 |             | • Air pressure at gun – Conventional | 45 psi  |
| • Viscosity (sprayable) #2 Zahn                     | 15 – 18 sec | • For Metallic and Mica Uniformity   |         |
|   |             | HVLP                                 | 4-6 psi |
|   |             | Conventional                         | 25 psi  |

### MIXING:

Shake then stir Special Effects FPC or Intermix Color and Basecoat Stabilizer thoroughly before mixing. Stir thoroughly and strain before use.

- **Basecoat Stabilizer:** Choose the Basecoat Stabilizer that best fits temperature and painting conditions.

Size of Repair	BCS605 Standard	BCS608 Medium/Slow	BCS610 Hi-Temp
Small spot repairs	75 - 90°F	85 - 100°F	above 110°F
1- or 2-panel repair	70 - 85°F	80 - 100°F	above 100°F
Multi-panel repair	65 - 75°F	75 - 95°F	above 95°F
Complete refinishing	60 - 70°F	70 - 90°F	above 90°F

- **Mixing Special Effects FPC's or Intermix Colors:** Mix 16 parts Special Effects Color to 16 parts Basecoat Stabilizer to 1 part UH904 Hardener.

- Use UH904 Hardener at one ounce per ready-to-spray quart for custom refinishing that require multiple coats of basecoat, special effect coatings, midcoats and various clearcoats.

- **Special Effects Custom Mix Guidelines:**

- It is not recommended to put Special Effects color into any Sherwin-Williams clearcoat.
- Due to their high level of opacity, mixing the following toners with Special Effects colors is not recommended:

U7030	H.S. Monastral Red	U7031	H.S. Bright Red
U7087	Medium Yellow	U7088	Lemon Yellow
U7106	Russet Red	U7124	Lead Free Orange
U7127	Lead Free Nickel Titanate	U7128	Lead Free Bright Yellow
U7140	H.S. Ferrite Yellow		

- **Flexible Parts:** When mixing basecoat for use over plastic or flexible substrates, mix basecoat 1 : 1, then add 1 ounce of ULTRA 7000® Urethane Topcoat Hardener to 1 sprayable quart of ULTRA 7000® Basecoat Color. **Flexible Additive is not required in ULTRA 7000® basecoat when using UH904 Hardener.**

- **Pot life of Basecoat:** 8 hours.

### APPLICATION:

1. Adjust air pressure at the gun to 45 psi for conventional. Use 20 psi for small areas and striping to minimize overspray. Adjust air pressure at the cap to 7-9 psi for HVLP.
2. Apply medium wet coats at a gun distance of 5-7 inches; spray to obtain desired effect, allowing each coat to become hand slick before applying the next coat.
3. Allow appropriate flash time as indicated in the Drying Schedule Chart.
  - **Do not use fisheye additives in Special Effects color. Do not scuff, sand (wet or dry), or solvent clean Special Effects basecoat before application of clearcoat.**
4. Recoat Special Effects midcoat color before 7 days or remove midcoat and basecoat color.

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**DRYING SCHEDULE:**

• Air dry times at 75°F and 50% R.H.:

	<u>BCS605</u>	<u>BCS608</u>	<u>BCS610</u> (above 90°F)
Dust Free	5 mins.	5-10 mins.	10 mins.
Tape Time	20-30 mins.	30 mins.	40 mins.
Recoat Time	20-30 mins.	25-35 mins.	30-40 mins.

**RECOMMENDED CLEARCOATS:**

Special Effects Midcoat may be clearcoated with ULTRA 7000® Clearcoats listed below:

Clearcoat	Recommended Clearcoat Hardener
CC637 – Ultra 7000® Maximum Performance	UH60, UH70 or UH80
CC639 – Ultra 7000® Super Glamour	UH60, UH70 or UH80
CC920 – Ultra 7000® 2.1 VOC Speed Plus	UH924
CC930 – Ultra 7000® Speed-Plus Performance	UH904
CC940 – Ultra 7000® Premium-Plus Performance	UH22, UH33, UH44, or UH55

**RECOMMENDED GROUND COATS:**

- Ultra 7000® Factory Package HS Basecoat Black UB2739
- ULTRA-FILL II® “ULTRA-SHADE”™ Acrylic Urethane Black Sealer S57
- SpectraSeal™ P30B Black with S39 or S40 Sealer Converters
- ULTRA-FILL® II UltraShade™ 2.1 VOC P23B Black with S25 Sealer Converter

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