



VB-12

Ditzler® Big Flake™

VM4401 Big Flake™—Gold
VM4402 Big Flake™—Silver
VM4403 Big Flake™—Green to Purple
VM4404 Big Flake™—Blue to Red
VM4405 Big Flake™—Red to Gold
VM4406 Big Flake™—Gold to Silver

Ditzler® Big Flake™ is offered in silver, gold, and 4 color-shifting versions to create a wide range of basecoat and tri-coat custom color formulations.

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



Compatible Surfaces

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

- DBC Refinish Systems—Follow P-175 *Deltron®* DBC recommendations for proper preparation and compatible primers.
- DBC500 Color Blender—Follow P-176 DBC500 recommendations for proper preparation and compatible primers.
- BC Refinish Systems—Follow EU02 *Global BC* recommendations for proper preparation and compatible primers.
- D895 Color Blender—Follow EU113 *Global BC* recommendations for proper preparation and compatible primers.
- Reference the *Vibrance* Compatibility Chart (VB20) for compatible clears and custom formulating.

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 colors are designed to be applied over properly cleaned, sanded and primed surfaces. See product bulletin P-175 (DBC) or EU02 (BC) for appropriate preparation.



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Directions For Use

Mixing:

(adding VM44xx to a basecoat color or blender)

For a custom formulation you may add a maximum of 2% (by weight) *Ditzler Big Flake* to unreduced color or 4% (by weight) to a ready-to-spray container of DBC, DBC500, BC, or D895. **A table for weights and amounts appears on page 4.** Please follow the instructions found in the clear section of this bulletin for recommended clearcoat film builds.

Reducing:

(basecoat color or blender already containing VM44xx)



or



DBC/DBC500 Reduction w/ VM44XX

Color	:	DT Reducers	+	**DX 57
1		1 to 1 1/2		1.5 oz per RTS quart

BC/D895 Reduction w/ VM44XX

Color	:	D-Thinners	+	**D888
1		1 to 1 1/2		1.5 oz per RTS quart

** DX57 or D888 activator **must** be used in DBC or BC colors containing *Ditzler Big Flake*. When using *Ditzler Big Flake* tri-coat custom colors, DX57 or D888 activator **must** be used in both the ground coat and mid-coat colors.

The Pot life of these mixtures is 2 hours at 70°F (21°C).

Spraygun Set-up:



Apply:	Sufficient number of coats to achieve desired effect
Fluid Tip:	1.2–1.5 mm or equivalent 1.5–1.6 mm or equivalent (for VM4401 Gold and VM4402 Silver)
Air Pressure:	8–10 PSI at the cap for HVLP guns 35–45 PSI at the gun for conventional guns

Drying Times:



Between Coats: 70°F (21°C)	5–10 minutes
Dry Time to Clearcoat: 70°F (21°C)	15 minutes 24 hour maximum to clearcoat
Tape Time: 70°F (21°C)	30–60 minutes with DX57 or D888

Note: Basecoat colors are designed to dry low in gloss. This makes color 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 color is allowed to dry more than 24 hours, it must be *scuffed and new basecoat color applied.*

Striping or Two Toning:

Tape time of DBC and BC is 30–60 minutes @ 70°F (21°C) and 50% relative humidity. All striping, two toning must be completed within 24 hours. If allowed to dry for more than 24 hours, the DBC and BC Colors must be sanded and reapplied. Avoid thick films of basecoat.

Tri-coat Mixing:

5% DX57 or D888 Basecoat Activator must be added to the reduced basecoat prior to spraying in BOTH the ground coat and midcoat.

Ditzler Big Flake can be blended as a midcoat color with DBC500 or D895 Color Blender. In doing so you can achieve more transparency, when combined with varying ground coat colors and create different degrees of custom effects. DBC500 or D895 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 2.5–3 mils of clear (usually 2–4 coats) to cover the basecoat.

Clear with any *Vibrance Collection*® clearcoat or any clear recommended for *Deltron*® DBC (see the *Compatible Clearcoat* section of P-175 for a complete listing) or *Global BC* (see the *Overcoat/Recoat* section of EU002).

Directions For Use

Technical Data:

	With DX57 or D888
Package* VOC Actual	4.68–5.54 lbs/gal (561–664 g/l)
Package* VOC Regulatory (Less Water Less Exempts)	4.68–5.54 lbs/gal (561–664 g/l)
1:1 RTS VOC Regulatory (Less Water Less Exempts)	5.41–6.13 lbs/gal (648–735 g/l)
1:1.5 RTS VOC Regulatory (Less Water Less Exempts)	5.77–6.54 lbs/gal (691–784 g/l)
Total Solids by Volume (RTS)	10–15%
Sq Ft Coverage / US Gal (RTS)	160-241
Dry Film Build Per Coat	0.3–0.5 mils
Wet Film Build Per Coat	1.0–2.0 mils

Package* is *Big Flake* VM44XX + DBC, DBC500, BC, or D895

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 dirty and are harder to cover with clear.
- A fluid tip of 1.5–1.6 mm or equivalent will give the best results with VM4401 Gold and VM4402 Silver (see *Spraygun Set-up* section on previous page).
- When using as a midcoat, VM4401 Gold and VM4402 Silver flakes spray much better in a medium solid clear than a basecoat blender. For example, when used with DCU2082 with DCH2086 Very Slow Activator, the finished product will be much smoother than if you were doing the job with the flake mixed in basecoat.
- The following basecoat colors are recommended for use under *Ditzler Big Flake* to maximize effect:

Big Flake Color		Basecoat Color
VM4401 Gold	over	DBC25622
VM4402 Silver	over	DBC33896
VM4403 Green to Purple		
VM4404 Blue to Red		
VM4405 Red to Gold	over	DBC9700
VM4406 Gold to Silver		

- Adding any of the color shifting *Ditzler Big Flake* products directly to a basecoat color may cause the final color appear darker or dirtier.
- Applying any of the color shifting *Ditzler Big Flake* products as a midcoat may cause the final color 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 color combination to verify what the final appearance will be.

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Mixing Amounts

For a custom formulation, you may add a maximum of 2% (by weight) *Ditzler Big Flake* to unreduced color or 4% (by weight) to a ready-to-spray container of DBC, BC, DBC500 and D895. All amounts shown in the table below are by weight (grams or parts) and not volume (ounces).

Unreduced DBC/500 or Unreduced BC/D895		Reduced DBC/500 or Reduced BC/D895	
VM44xx	VM44xx	VM44xx	VM44xx
Grams or Parts (by weight)	Grams or Parts (by weight)	Grams or Parts (by weight)	Grams or Parts (by weight)
100	2	100	4
150	3	150	6
200	4	200	8
250	5	250	10
300	6	300	12
350	7	350	14
400	8	400	16

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

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