



**Metalflake® Corporation**  
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**APPLICATION GUIDE MIRRA - The Iridescent Flake with a Prismatic Effect**

1. Prepare surface

A. If surface is stripped bare, sand with oscillating sander using #180 grit paper. Wash thoroughly with a metal conditioner.

B. If the existing surface is a factory baked finish in good condition scuff with #400 sand paper and apply a bleeder-sealer after applying primer surfacer. Otherwise, we recommend removing finish down to original surface (a bleeder-sealer should be used over all primers and other existing finishes)

2. Prime with 3 coats of primer-surfacer. Allow 15 minutes drying time between first two coats and 45 minutes after final coat. Sand with #360 grit paper.

3. Apply 3 coats of Black or White Acrylic Lacquer allowing 15 minutes drying time between coats.

4. Mix 2 ounces of Mirra to a quart of reduced (one-to-one) Clear Acrylic lacquer, and apply 3 coats alternating spraying direction with each coat. Use 2 ball bearings in cup and hand agitate constantly to keep flake in suspension. Alternate spray pattern with each coat to avoid streaking.

SPRAY PATTERN:

First coat	Second coat	Third coat
		

Use a Devilbiss #043, #30, or #306 nozzle, or their equivalent, to apply the Mirra (use 25 lbs. at the gun) Allow 10 minutes drying time between each coat.

5. Final Finishing

Option #1. Apply enough Clear Acrylic to allow for sanding without exposing the Mirra coats (14-18 coats suggested.) Allow 10 minutes drying time between coats. After final coat, allow 3 weeks drying time before sanding with #220 grit sand paper using an oscillating sander until all orange peel disappears. All edges and sharp curves must be hand sanded to avoid sanding through to flake. Apply 2 more coats of Clear Acrylic. Allow to dry overnight, then wet-sand with #1000 grit paper, compound with buffing wheel and wax.

Option #2. Apply enough Clear Acrylic to allow for sanding without exposing the flake (14-18 coats suggested) Allow 10 minutes drying time between coat. After final coat allow 3 weeks drying time before sanding with #220 grit sand paper using an oscillating sander until all orange peel disappears. All edges and sharp curves must be hand sanded to avoid sanding through to flake. Apply 3 coats of catalyzed Crysta-Crylor for "Wet Look". 3 coats of catalyzed Polygloss Clear, allowing 1 hour drying time between first two coats and 4 hours between second and third coats. Do not re-coat-can cause wrinkling and/or lifting.