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Mixing and Application Instructions for Cilgen™ Brilliance Colors

Cilgen™ Brilliance Colors are designed to be mixed into Cilgen™ Brilliance LTC Clear, to create translucent colors for various effects in a highly durable, UV, scratch and abrasion resistant coating. The following are instructions to mix the colors and then how to apply the coatings so that you can achieve the best results.

Mixing the colors with Cilgen™ Brilliance LTC Clear:

- The components need to be mixed in a clean container with a cover that will hold at least 2 times the amount that will be mixed.
- The colors are best mixed by weight and so for ease of operation you should have a scale that reads in grams. If a scale is not available approximately 45 drops of the liquid color to 1 oz. of Cilgen™ Brilliance LTC Clear equals a 2% loading.
- Place the mixing container on the scale and add the Cilgen™ LTC Clear first.
- Second add the amount of Cilgen™ Brilliance Color that is desired. **Caution:** adding amounts over 5% of color will result in a reaction that will cause the mix to get warm or even hot with greater concentrations, the mix can also foam and produce ammonia vapors. If adding over 5% of color do so slowly to reduce the reaction.
- A mix of 2%-5% by weight will produce a translucent coating, a mix of 10% by weight or higher will produce a solid color coat. While a higher loading of the liquid color is possible, 2% is our standard recommended loading.
- Blend the mix with a **stirring stick** until the mixture is constant in color. **Caution:** do not seal the lid on the mixing container at this time as it will build pressure. The lid may be loosely placed on the container to allow the pressure to be released. **Do Not Shake the mix to blend.**
- You should only mix the amount that you plan to use. The greater the quantity of the mix the more heat and ammonia vapor that will be produced.
- Filter the mix into your spray gun for application (if you have a high concentration of the color in the mix wait for it to cool before putting it into your spray gun).

Applying the coating:

- It is recommended that you apply a base coat of the Cilgen™ Brilliance LTC Clear, on a clean reflective / polished surface as a thin wet coat. Avoid runs and sags. Allow to dry for a minimum of 10 – 20 minutes but no more than 30 minutes before the next coat, depending on humidity levels (high humidity will cause the coating to cure faster, low humidity will cause it to cure slower).
- Spray the mixed color coating as a thin wet coat. Avoid runs and sags. Allow to dry for a minimum of 10 – 20 minutes but no more than 30 minutes before the next coat.
- When using a 5% mix or less, additional coats of the mixed coating may be required to achieve the desired effect, there must be a minimum of 10 – 20 minutes but no more than 30 minutes between coats. When using a 10% or greater mix you may be able to achieve a solid color in one coat of the color mix. Note: In most cases a 2% mix will require 3 to 4 coats prior to applying the top coat for best color. On textured or sandblasted surfaces a 4% - 5% mix is an option.
- Next apply the Cilgen™ LTC Clear as a top coat. Spray as a thin wet coat. Avoid runs and sags.
- Additional coats of Cilgen™ Brilliance LTC Clear may be applied but there must be a minimum of 10 – 20 minutes but no more than 30 minutes between coats. Note: We recommend that no more than 2 coats of Cilgen™ Brilliance LTC Clear be used for the top coat.

Curing the coatings:

- The coating will dry to the touch in 1 hour, partial cure in 24 hours, and full cure in 7 days. In most applications the parts can be put into service after 24 hours, it is not necessary to wait longer in those applications. Do not use heat to cure this coating.

Clean Up:

- Clean equipment with acetone before the coating dries. Coating that has cured cannot be removed with conventional solvents. Cured coating can be removed with Aircraft Stripper or similar and scrubbing.