

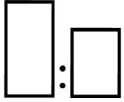
I-180 HYBRID CARRIER

Introducing the I-180 Hybrid Carrier, the first product Durafil's newest line: *CLARITY*.

0% opacity, high technology & dries completely crystal clear. This hybrid product can also be used as a binder; adding up to 500G of additives to a gallon. No carrier coats needed. This product ensures NO bleed through. You can safely scuff over Pearls, Metallics & Colored Flakes. Wet on Wet Technology, air drying in 5 - 45 minutes, with an open window of 24 Hours.

65% Solids, and carriers every additive. Superior flexibility, leveling & flow capabilities. 100% adhesion, guaranteed; will not lift to tape lines. LOW VOC, CALIFORNIA APPROVED.

COMPONENTS



1-180 HYBRID CARRIER	ADDITIVES	ACTIVATOR	REDUCER
	Fine / Ghost Pearl / Micro Flake	I - 180H	I - 180R
	Heavy Metallic / Corse Pearl	I - 180H	I - 180R
	Flake	I - 180H	I - 180R
	Kandy Concentrate	I - 180H	I - 180R

MIX RATIO



MIX RATIO	1-180 HYBRID CARRIER	I-180 HARDENER	I-180 REDUCER
Fine / Ghost Pearl / Micro Flake	4	1	10-15%
Heavy Metallic / Corse Pearl	4	1	10-15%
Flake	4	1	0-10%
Kandy Concentrate	4	1	10-20%
Airbrush	4	1	30%
Airbrush: HIGH DETAIL / MICRONS	4	1	40%

***See appropriate Pearl/Flake/Metallic Manufacturer TDS for amounts per sprayable material

SPRAY PRESSURE AND TIP: CONVENTIONAL & AIRBRUSH



MIX RATIO	PRESSURE	TIP	DISTANCE
Fine / Ghost Pearl / Micro Flake	22 - 35 PSI	1.2 - 1.4	10 - 12 INCHES
Heavy Metallic / Corse Pearl	22 - 35 PSI	1.2 - 1.4	10 - 12 INCHES
Flake	22 - 35 PSI	1.4 - 1.8	10 - 12 INCHES
Kandy Concentrate	22 - 35 PSI	1.2 - 1.4	10 - 12 INCHES
Airbrush	25 PSI	0.3 - 0.5	1 - 6 INCHES
Airbrush: HIGH DETAIL / MICRONS	13 - 18 PSI	0.1 - 0.2	1 - 6 INCHES

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BINDER MIXING & APPLICATION



I-180 Hybrid Carrier	1/2 Pint	1 Pint	1/2 Quart	1 Quart	1 Gallon
Pearls & Mettals	31.25G	47.25G	63.25G	79.25G	500G
I-180R Reducer	20-30%	20-30%	20-30%	20-30%	20-30%

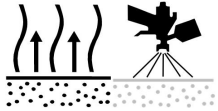
**** Reducer % will be determined by the weight of the additive. Adjust viscosity accordingly.**

Mix 4:1 + additives & reducer. Wet on Wet application for the first two coats. Flash between 1-5 minutes for further coat(s), depending on the tip size during application, and the distance to the substrate.

POT LIFE 2 Hours at 75 F / 20 C



DRY TIME | RECOAT | TAPE TIME



Air Dry at 75F / 20C for 45 Minutes (or up to 24 Hours)

******After 24 hours dry sand/scuff surface with 500 and respray 1 FULL wet-coat.**

Tape Time 45-60 Minutes

Flash Times 2-8 minutes (for multi-coat). No Flash for Airbrush

****Flash will vary depending on reduction and weight of additive. Allow for each coat to get tacky before applying your next.**

APPLICATION FOR ALL ADDITIVES



0.5 To 1 Full Coat:

For Highlights, Ghost Pearls, Shadow Work. Allow for 5-10 Minutes to Air Dry.

**** Application specific for air brush, and touch up guns**

2 - 4 Full Coats:

To Seal and Level

Tape Lines:

Apply 2 full coats. Allow I-180 to dry completely (minimum of 45 minutes).

Apply 4 wet coats of the Durafil C-9500 Turbo-Fil Fast Dry Urethane Clearcoat. Allow for full dry 1.5 hours, or 12 Hours / Overnight (air dry), and cut with 4-600 Grid (wet or dry). Apply 2 wet coats of the Durafil C-9800 Gloss-Fil Luxury Clearcoat. Allow for full dry 2-4 hours, or 12 Hours / Overnight (air dry). Cut with 6 - 800 Grid (wet or dry) and apply two additional coats.

*Repeat dry and cut instruction above.

**** For Show Pieces flow coat up to 15 MILS for your final**

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TECHNICAL TIPS



The technology of the I-180 Hybrid Carrier allows for you to scuff over Pearls, Metallics, and Colored Flake, safely with no carrier coats, or clearcoats. Guaranteed.

To preserve paint for airbrushing, only activate with a few drops once the paint has been added to your gun. This will provide you with about 2 - 3 Hours of pot life in your airbrush. If you are consistently spraying, the pot life is indefinite.

Before applying tape lines to Kandy, it is recommended to spray 2 full coats of the I-180 Hybrid Carrier, and allow to fully cure, to ensure no tracking marks.

When completing an application with Heavy flake, it is recommended to apply two wet coats of the I-180 reduced at 10% to ensure optimum visualization and then follow up with the C-9500 Turbo-Fil Fast Dry Urethane Clearcoat, finished with the C-9800 Gloss-Fil Luxury Urethane Clearcoat.

***Reference Application for dry times, and sand paper recommendations.**