



TECHNICAL DATA GUIDE
STONE-FLECKS™
MULTI-COLOR COATING
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PRODUCT DESCRIPTION

STONE-FLECKS™ is a unique multicolor system, which contains modified polymer particles suspended within a waterbased paint system. This product, when properly applied, duplicates the appearance of a stone or granite surface for use as an architectural finish. The scrubbability, stain, and water resistance of STONE-FLECKS™ exceeds that of most other multicolor finishes and can be used on both traditional interior (foyers/hallways) and specialty applications (countertops). However, this coating is not designed for use in high moisture environments.

Unlike other multicolor finishes, Hawk STONE-FLECKS™ has been specially modified to spray well from the HVLP equipment that is commonly used by our industry, giving the users of this product a distinct advantage over users of other, more common wall-type finishes. When clearcoated with Glas-Tech 9000™ clear or STONE-GARD™ protective topcoat, this system combines the beauty of a multicolor finish, with the unmatched durability and performance of the Glas-Tech 9000™ coating system.

SPECIFICATIONS

COATING TYPE:	Modified Terpolymer/water phase composite
MIX RATIO:	Single component product, no catalyst necessary
REDUCTION:	Product is shipped ready-to-spray using conventional or airless equipment. For use with HVLP spray equipment, adjustments to viscosity may be made with distilled water. Colors vary in viscosity. Depending on your particular HVLP, the average reduction falls between 5-15%, not to exceed 25% of total volume. Reduced material not intended for long term storage and is more susceptible to freezing.
POT LIFE:	Indefinite, in closed container.
INDUCTION TIME:	None, see instructions for proper mixing procedures.
RECOMMENDED FILM THICKNESS:	Typical dry film thicknesses (DFT) range from 4 to 8 mils, depending on desired appearance and surface being coated.
THEORETICAL COVERAGE:	Ranges from 125 to 200 square feet per gallon.
DRY TIMES:	Dry to touch in 3 hours @70 Degrees F. Dry to clearcoat in 30 minutes (STONE-GARD) @70 Degrees F. Dry to clearcoat in 3 hours (other clearcoats) @70 Degrees F. Dry to block sand in 6 to 8 hours @70 Degrees F. Fully cured in 7 days @70 Degrees F.
AVAILABLE COLORS:	Available in 24 popular colors to complement any kitchen, bath, or interior design plan.
FREEZE/THAW HAZARD:	KEEP PRODUCT FROM FREEZING

SURFACE PREPARATION: **COUNTERTOPS**

See the Technical Data Guide for STONE-GARD™ Countertop Surface System.

WALLS

DRYWALL SURFACE

STONE-FLECKS™ may be applied directly over primed drywall. The drywall should be properly patched, sanded and masked, then primed using a standard latex or vinyl primer.

LATEX FLAT OR SEMI-GLOSS SURFACES

In most cases, STONE-FLECKS™ can be applied directly over latex paint. The key is the amount of gloss level of the existing painted surface. If there is minimal gloss the multi-color will bond.

ENAMEL OR GLOSSY PAINTED SURFACES

Glossy surfaces must be scuffed or sanded down to increase adhesion of the multi-color coating. The use of 120-400 grit will cover most situations.

MIXING:

STONE-FLECKS™ contains multi-colored polymer droplets suspended in a water-based material, and as such, any aggressive mechanical agitation, such as machine shaking or electric mixing, will destroy it's multicolor properties. This product should be manually mixed only, using a paint paddle in a gentle circular motion. The most preferable method for mixing the product is a process called boxing, in which the product is poured from one clean container to another, in a back and forth manner, until product uniformity is achieved.

APPLICATION:

As a one-component coating, STONE-FLECKS™ needs no catalyst and is sprayed directly onto the surfaces. There is no induction time. However with HVLP spray systems, some colors may require a reduction of 5-15% with distilled water. Ordinary tap water may be substituted in areas not affected by hard water. All areas immediately surrounding the surface to be multi-colored should be covered with masking paper or plastic to prevent overspray.

STONE-FLECKS™ is very easy to apply and very forgiving. Make sure you have adequate lighting on all surfaces so that you can verify a uniform broadcast of the coating. Adjust your gun settings to allow a 12-24" pattern (depending on the size and scope of the surface you are spraying) and begin applying STONE-FLECKS™. Your distance from the surface to the gun tip should be 12-24". Apply one even overlapping coat horizontally, with the next coat spraying vertically. This will help ensure uniformity of both the film build and the different colors of the coating.

Once you have attained film strength and coverage, your goal is to make sure that the complete surface being sprayed remains uniform in both texture and size of broadcasted color particles. Walk the perimeter and make any final touch-ups.

Note:

The texture, or surface profile, of STONE-FLECKS™ will shrink by approximately 50% after curing.

Note:

The volume of material flow and the spray pattern size control the broadcasting of the multi-color coating. Less volume flow and/or smaller spray patterns tend to "compact" or make smaller the individual colors. This can cause the colors to "blend" together and alter the overall intended color. Unless this is desired, it is recommended the applicator use the color chip standard as a quality control measure.

Note:

While “spider webbing” in some STONE-FLECKSTM colors is normal and designed to imitate real stone characteristics, excessive spider webbing can be controlled by increasing reduction and/or reducing material volume flow.

TROUBLE SHOOTING GUIDE

PROBLEM	SOLUTION(S)
STONE-FLECKSTM material will not flow evenly through the spray gun.	A. Reduce with distilled water. B. Change to next largest needle assembly. C. Increase material flow and/or pattern size. D. Change out to next largest needle assembly.
Uneven individual color broadcasting of STONE-FLECKSTM on surface (one color missing from pattern).	Incrementally open both the volume control knob and/or pattern control ring until color appears.
Color particles are too large and spider webbing occurring.	A. Incrementally close the volume control knob. B. Further reduce the multi-color.
Individual color “spitting” leading to uneven overall broadcasting.	A. Incrementally open pattern control knob. B. Make sure enough material is in the gun cup.

RECOMMENDED SPRAYGUN SETTINGS:

GUN TYPE	AIR CAP	FLUID ASSEMBLY	RECOMMENDED SETTINGS
Graco	1.3 mm (# 3)	1.8 to 2.2 mm (# 4 to # 5)	Air cap flush with fluid nozzle, material control out 4 turns, air control valve 3/4+ open
American Turbine	1.4 mm	1.8 mm	Air cap flush with fluid nozzle, material control out 4 turns, air control valve 3/4+ open
Wagner/Capspray	1.3mm (# 3)	# 4	Air hose should be configured directly through the back of the gun for best results
Croix	1.4 mm	1.8 mm	Air cap flush with fluid nozzle, material control out 4 turns, air control valve 3/4+ open

IMPORTANT NOTE: These settings are dependent on the equipment configurations used. The above recommendations are a baseline only, and will vary depending on hose length, airflow, gun condition, and number of turbine stages. Some economy type or smaller turbines may not be sufficient, and equipment upgrade may be necessary; contact Hawk Research Labs for more information.

CLEAN-UP:

Use Hawk’s SPRAYGUN CLEANER™ to clean out the gun cup, gun interior, and all spray gun parts and surfaces. Be sure to blow out the gun thoroughly as traces of multi-color left in the gun may interfere with your next spraying application.

SAFETY:

This product is designed and intended for industrial use by trained professionals who are familiar with the inherent risks and hazards of the product. Before storing, mixing, or applying this product, read and understand all of the product’s Material Safety Data Sheets. For a copy of the M.S.D.S. Sheets, contact Hawk Research Laboratories at (630) 227-0050. This product may be blended with other products prior to use, and therefore may possess the hazards of all the products blended.

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