



# Application Guide

## 8 things you need to know before you start

1. Always wear latex gloves while handling primed surface.
2. Clean substrate with 60/40 distilled water/Isopropyl solution only & allow to dry thoroughly
3. This is a specialty product - TEST A SMALL SAMPLE of each substrate before proceeding to avoid complications.
4. Use a CLEAN professional paint booth for application
5. Use specific spray gun nozzle sizes listed in each Step below
6. Refer to each step for the proper air pressure
7. Keep room temperature at a constant 70°F
8. High humidity will slow curing times

## Step#1 - Pre Priming

**Note: This is the most critical stage!**

**Step 1a:** Pre-sand substrate surfaces using standard bodywork techniques. \*\*\* Smoother finishes produce better results.\*\*\*

**Step 1b:** Pre-prime substrate surfaces using urethane primer  
**Important!** - Follow manufacturer's instructions for complete drying and finishing allowing all tail solvents to evaporate before proceeding with step #2.

## Step#2 - Base Coat

Follow the mix directions on can.  
Apply using 24-40 psi with 1.2mm - 1.4mm gun tip  
Apply 1 medium wet slick coat, wait 10 to 15 minutes, then apply a second medium wet slick coat.

**NOTE: Allow a minimum of 36 hours at 70°F for tail solvents to completely evaporate before proceeding.**

Force Drying: Allow 2 hours tack dry at 70°F before proceeding to oven.

Metal: 3 to 4 hours at 140°F  
Plastic: 3 to 4 hours at 120°F

*In the event of any bacteria or contaminants present after the drying process, use scuff gel and scuff pad to lightly remove contaminates, then polish, and remove any excess with a good wax & grease remover - Do NOT use alcohol based cleaners or reducers.*

It is not necessary to wet sand the complete surface.



## Step#3 - Applying the Chrome

**Important! Shake contents in SuperChrome 54X**

Apply 2 or 3 coats of SuperChrome - lightly fog on from a distance of 10 inches using a tip size of 0.8mm or 1.0mm at 24-40 PSI of pressure. You have it right if the SuperChrome flashes in 4 to 5 seconds. **Do not apply too many layers of SuperChrome - it will dye back producing poor results.**

Use a lint-free cloth or dry-tack cloth along with pressurized air to wipe away dust or over-spray between each coat. DO NOT USE wax based tack cloth.

Allow 5 to 10 minutes between coats to dry

**NOTE: Allow a minimum of 72 hours at 70°F for chrome to cure properly before proceeding. Longer drying times yield better results.**

**Force Dry in oven:**

Metal: 3 to 4 hours at 140°F  
Plastic: 3 to 4 hours at 120°F

*If SuperChrome does not flash to chrome within 4 to 5 seconds after each coat call for technical assistance. Unused chrome can be poured by into the tin for storage.*

## Step#4 - HydraClear

Follow the mix directions on the can.  
Apply using 24-40 psi with 1.2mm - 1.4mm gun tip.  
Apply one coat of HydraClear . It can tinted to achieve a candy-chrome effect.

Allow to dry for 8 hours at 70°F.  
Force drying: Plastic: 2 to 3 hours at 120°F  
Metal: 2 to 3 hours at 140°F

Use standard polishing techniques to increase brightness before dipping

**Your substrate is now ready for hydrographing**

## Step#5 - Final Coat

Once your graphic has dried apply SuperChrome Clear Coat. Follow the mix directions on can. Apply 2 medium wet coats, allowing 20 minutes between coats, to seal chrome. Allow to dry thoroughly - Minimum of 12 hours at 70°F.

Force Drying:  
Metal: 3 to 4 hours at 140°F  
Plastic: 3 to 4 hours at 120°F

The SuperChrome Clear Coat can be tinted to achieve a candy-chrome effect.