



Extreme Illusion™



Rage Extreme Illusion™

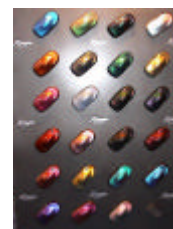
Rage Extreme Illusion™ finishes are based on the revolutionary ChromaFlair® light interference pigments, these are unique pigments that actually change colour depending on the angle from which they are viewed. More than just a subtle variation in shade, the colour undergoes an almost magical transformation in appearance: from a deep, warm red to a blazing, metallic gold, for example; or from cool, luminous silver to smooth, satiny green.

Many variables affect the colour and appearance of the finished paint and the ground coat plays an important role, red, black and dark grey are the most suitable and are chosen depending on the Rage Extreme Illusion™ finish used, typically it requires 3-5 coats of Rage Extreme Illusion™ to achieve maximum affect although more or less coats can be used depending on the desired effect.

Rage Extreme Illusion™ finishes can appear to be different colours to people viewing the exact same area of the car from different angles. Rounded, curved surfaces and sharp angles will highlight the uniqueness of Rage Extreme Illusion™. Rage Extreme Illusion™ basecoats are as easy to apply as our Pearl-Basecoats. Application procedures can vary the appearance of the Rage Extreme Illusion™ basecoats to give novel colour effects. Rage Extreme Illusion™ basecoats must be top coated with 2k Clearcoat.

Available in 8 dramatic colours

CFI-000 Red/Gold	Shifts from red through orange and yellow into green
CFI-060 Silver/Green	Shifts from silver through the full range of greens into purplish blue
CFI-080 Gold/Silver	Shifts from gold to bluish silver
CFI-190 Green/Purple	Shifts from green through blue and red into orange
CFI-230 Cyan/Purple	Shifts from cyan through purple into reddish orange
CFI-280 Blue/Red	Shifts from blue through purple to warm red
CFI-300 Purple/Orange	Shifts from purple through red into orange
CFI-334 Magenta/Gold	Shifts from magenta through red, orange and gold into yellow



Rage Extreme Illusion Colours can also be mixed together or tinted with Rage Extreme Dyes for outstanding exclusive effects!

NOTE: The final colour of these effects will vary depending on the amount of coats applied and the colour of the ground coat.

SUBSTRATES AND PREPARATION

Rage Extreme Illusion™ ground Coats should only be applied over: -

- 2-pack primer/undercoat, hand flatted with P600 or finer grade wet or dry paper, or machine sanded with P320 grade or finer, prior to topcoat application.
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (e.g. with Scotchbrite Ultrafine Grey) and cleaned with W800 wax and grease remover prior to application.

NOTE: On new panels coated in electrocoat it is essential that a 2-pack primer is applied.

GROUND COAT

The ground coat plays an important role, the Illusion effect is most evident over a black ground coat and the colours will look sharper and cleaner however if you are using a black ground coat this will increase the possibility of Illusion colours looking patchy on large flat areas i.e. roofs and sides, we strongly recommend that you apply five coats over black ground coats to prevent this problem, also it is vital that good spray techniques are used to obtain evens coats on the whole job. A dark grey base coat will reduce the chance Illusion looking patchy.

Rage Extreme Illusion colours can go over any colour ground coat for different looks although on white ground coats the colours will be weaker. The colour of the ground coat will vary the amount of coats it will require to obtain the best results. We recommend that you spray a series of test panels first to determine the colour and appearance required.

MIXING

Stir Rage Extreme Illusion™ well, mix 2-parts paint to 1-part R6030 Rage Extreme Basecoat Thinners. Mix well. Rage Extreme Illusion™ is encapsulated metallic platelets.

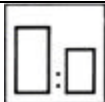










NOTE: Over thinning and/or diluting with R6028 Rage Extreme Base Blender™ will give a darker, coarser appearance with a more subtle colour change compared to normal reduction and application. This effect will diminish and approach normal colour effect as more coats are applies. This allows for novel colour effects.

APPLYING

HVLP guns are recommended to stretch the product's use. Strain the paint into the paint gun. Set the gun fan at 6 inches (Adjust the gun fan by opening the air fan to full and turning in the paint jet until you have a 6 inch fan). Gun distance whilst spraying should be approximately 4-6 inches. Apply 3-5 coats with 75% pattern overlap (with a 6 inch fan you should only move the gun down 2 inches on each pass to achieve a 75% pattern overlap) followed by light drop coats to give an even appearance. Spray the vehicle sides in one continuous pass rather than individual panels to avoid film build up on the edge of panels with could cause a patchy appearance on the finished panel. Allow flash time between coats.

The alternative application method is to apply 4-6 lighter coats to build up the appearance required followed by light drop coats to give an even appearance. Allow flash time between coats. Do not apply full or heavy coats as this can cause a patchy appearance on the finished panel.

NOTE: Due to the many variables in ground coat colours and how many coats are applied the colour cards for these effects are for illustration purposes only, therefore it is essential to spray a test panel first to establish the ground coat colour and amount of coats required to achieve the desired colour effect.

Rage Extreme Ground Coat Colour Process		Rage Extreme Illusion Colour Process		
	Rage Extreme Ground coat Colour R6030 Basecoat Thinners	2 parts 1 parts	Rage Extreme Illusion Colour R6030 Basecoat Thinners	2 parts 1 parts
	Sprayed at low viscosity. Thin by volume only.		Sprayed at low viscosity. Thin by volume only.	
	Fluid Tip: Gravity Fed: 1.4 – 1.8 mm Suction Fed: 1.3 – 1.5 mm Pressure: 2.7 – 3.0 bar (50-60 psi)		Fluid Tip: Gravity Fed: 1.4 – 1.8 mm Suction Fed: 1.3 – 1.5 mm Pressure: 2.7 – 3.0 bar (50-60 psi)	
	Fluid Tip: Gravity Fed: 1.3 – 1.6 mm Suction Fed: 1.3 – 1.6 mm Pressure fed: 0.8-1.0 mm Pressure: 10 psi max (Air cap)		Fluid Tip: Gravity Fed: 1.3 – 1.6 mm Suction Fed: 1.3 – 1.6 mm Pressure fed: 0.8-1.0 mm Pressure: 10 psi max (Air cap)	
	Apply single coats until full coverage is achieved (Normally 2-3 coats)		Single or Double-header coats based on test panel. Depending on the desired final colour it is not necessary for this product to give full coverage.	
	Approx 3 - 5 mins between coats.		Approx 3 - 5 mins between coats.	
	Air Dry at 20°C 10-20 Minutes, until uniformly dry before applying Rage Extreme Illusion coats.		Air Dry at 20°C 10-20 Minutes, until uniformly dry before clearcoating.	
	Apply 3 coats of Rage Extreme R6075 H.S 2k Clearcoat. (See separate Data sheet for full instructions)			
	For an outstanding custom final finish bake Clearcoat and leave over night to fully cure, wet flat with 600 wet and dry or P500 DA disc. Then recoat with Rage 2k Clearcoat.			
	Apply 2 coats of Rage Extreme R6075 H.S 2k Clearcoat. (See separate Data sheet for full instructions)			
	Optimum Times prior to polishing: Air Dry: After 24 Hours. Force Dry: 2 hours after cool down. Sanding: Use 1500 grit wet or finer. Or use 1500 DA or finer. Compounding: Use US Chemicals Coarse compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool polishing pad or a foam pad. Maintain speed of buffer at 1800-3000 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.			

ARTWORK

Rage Extreme Illusion™ colour, are an excellent choice for intercoat artwork paint jobs. Do not tape directly onto this base. If artwork is planned, apply 1 or 2 medium coats of R6028 Rage Extreme Base Blender™. This coat will protect the Rage Extreme Illusion™ base from takeouts and allow clean up of mistakes. Sand with 500-grit wet for improved adhesion. (For more info on R6028 Rage Extreme Base Blender™ see the R6028 Tech Data Sheet)

NOTE: Artwork colours applied over Rage Extreme Illusion™ colour bases can reduce or completely eliminate the colour change effect. Always test any artwork planned on a test panel.

NOTE: R6028 Rage Extreme Base Blender™ is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE R6028 Rage Extreme Base Blender™ AS A BUILD UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS.

CLEAR-COAT

All Rage Extreme Illusion™ colours MUST BE CLEAR COATED. Once a system is chosen, after the base coat, stay with that system. We recommend that you use only Rage clearcoat for best results. **See appropriate tech sheet for more information on clear coat application.**

Technical Tips

Custom painting requires different spraying techniques and you must take the time to learn and understand the different techniques needed.

Rage Extreme Illusion Colours are essentially transparent partials and therefore it is important to have an even application to avoid a patchy appearance in the final finish, ensure that there are no patchy areas before applying clearcoat **(Due to the transparency of the Rage Extreme Illusion pigments large flat areas can display a slightly patchy appearance)** dark ground coats used with light Ecstasy colours will increase the possibility of patchy areas.

Rage Extreme Illusion Colours can be tinted with Rage Extreme Dyes; this will reduce the chance of a patchy appearance on large flat areas and make application easier.

The choice of ground coat will have an effect on the final appearance and colour.

The amount of coats applied and the application method will have a great effect on the final appearance and colour.

A test panel should always be sprayed to ensure that the correct appearance is achieved.

Darker ground coats will increase the colour shift effect; if the ground coats are too light the colour shift will be diminished.

It is important to have even application to avoid a patchy appearance in the final finish, ensure that there are no patchy areas before applying clearcoat, dark ground coats used with light Illusion colours will increase the possibility of patchy areas, therefore ensure that sufficient coats have been applied.

For optimum hold out we recommend that the whole basecoat film should be flashed off between the coats and 3 coats of Rage H.S Clearcoat applied with a flash off between the coats.

NOTE: when blending, you may slightly over thin or mix with R6028 Rage Extreme Base Blender™ for undetectable blends.

NOTE: Do not sand Rage Extreme Illusion™ without recoating, as the scratches on the metallic platelets are permanent. Use R6028 Rage Extreme Base Blender™ for protection if sanding is required.

FLASH OFF TEST – ALL BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED.

Important remarks:

For professional use only.

This data sheet is for information purposes only. The information contained here represents the current state of our knowledge and is intended as a guide to our products and their uses, it is not intended as insurance of certain product properties or of their specific applications.

The warnings displayed on the product labels should be followed. Any industrial property rights should be observed. We guarantee perfect product quality under the terms of our general conditions of sale.

Check all colours and effects before use by spraying a test card prior to application to vehicle, as no responsibility for incorrect colours will be accepted after application.

Refer to relevant Health and Safety Data sheets before use.