

Product Information (PI) Sheet

Product: Crackle Plus

Code(s) :

F5552			
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Description: Crackle Plus is a clear tint base designed to be added to M.L. Campbell solvent-based pigmented finishes to produce a crackle appearance. When crackle coat is to be a deep color, use M.L. Campbell Crackle F5565.

Physical Properties (packaged)	
Weight per Gallon:	7.96 lbs. ± .2lbs
Package Viscosity - #4 Ford Cup:	17 – 27 seconds
% Solids by Weight:	16 - 20
% Solids by Volume:	9.5 – 13.5
Flash Point (PMCC):	44°F or 6°C
Packaged VOC:	769 g/l (6.41 lbs/gallon)
Photo-chemically Reactive:	No

Surface Preparation	
New Work:	Remove any dirt, grease, glue or other construction contamination and sand as required.
Old Work:	Strip old finishes completely and remove all contamination from surface. Make sure surface to be finished is dry and sanded. Finish as new work.

Application Procedure	
Sand substrate as required, to obtain proper adhesion.	
<ol style="list-style-type: none"> 1. Apply non cross linked under-coater such as W35010 Magnalac Primer Under-coater tinted to color that will appear in the cracks. If using MDF, 2 coats of under-coater may be required to fill routed surfaces. Apply crackle mixture. A good crackle mixture is 2 parts Crackle Plus to 1 part pigmented lacquer. This ratio may need to be adjusted. Allow 1hour dry time before next step. 2. Application of Crackle – the film thickness of the base coat and the Crackle will determine the amount of cracking and the actual size of the cracks. A thinner coat will produce many small cracks. A thicker coat will produce wide large cracks. Crackle coat should dry at least 1 hour before next step. Scuff sand Crackle Finish lightly with 320-grit and follow directions below. <ul style="list-style-type: none"> • If not glazing – Apply desired M.L. Campbell topcoat. • If glazing – Apply N22028 Traditional Glaze Base tinted as desired, followed by 1 coat of C10025 Water White Vinyl Sealer @ 2-4 wet mils. Scuff sand using 320-grit before Application of your topcoat. 3. Application of topcoat – apply a mist coat of desired M.L. Campbell topcoat and let dry. Apply finish coat. 	

Catalyzation	
Crackle Plus does NOT require a catalyst. Catalyzed lacquers, which are to be mixed with Crackle Plus, should be catalyzed prior to mixing. If Crackling with catalyzed products, it is recommended to use Water White Vinyl Sealer C10025 as a base coat, which must be crackle coated within 1hour.	

Reduction	
Reduction is not necessary with this product. If reduction is required for certain applications use the C16036 Standard Lacquer Thinner.	

Tinting

The mixture of Crackle Plus and M.L. Campbell Clear and Pigmented Lacquer can be tinted using MLC Colorants. DO NOT tint with Glycol colorants. The tint limitations of the clear or pigmented lacquers apply to crackle mixture.

Equipment & Clean Up

- Use Lacquer thinner to cleanup all equipment.
- Dispose of dirty solvent and cleaning rags in a safe and approved manner.
- Solvent or lacquer soaked rags should be stored in water-filled closed containers prior to disposal.

Packaging/Shipping

Available Units: Gallons.

Shelf Life and Storage

- Store in a cool dry area in the original sealed container.
- Do not store around any source of flames or sparks.
- Spills should be cleaned up with non-sparking tools and an inert absorbent material.

DOT Classification

Flamable Liquid

Red Label

UN 1263

B/L Description

Paint

UN 1263

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PG II

Caution

- **THESE PRODUCTS ARE DESIGNED FOR SHOP APPLICATION AND PROFESSIONAL USE ONLY.**
- Use only after all safety information is understood.
- Refer to the Material Safety Data Sheet (MSDS) for additional information.

Testing

Due to the wide variety of substrates, surface preparation methods, application methods, and environments, customers should test the complete system for adhesion and compatibility under their conditions prior to full-scale application.

Notes

The information, rating, and options stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application that are not known or under our control, M.L. Campbell cannot make any warranties as to the end result. *Thank you for using M.L. Campbell Wood Finishing products.*