

HOUSE OF KOLOR® TECHNICAL MANUAL

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HOUSE OF KOLOR®

TECHNICAL DATA INFORMATION

IMPORTANT NOTE: This document includes information on UCO1 and UFCO1. These products are for sale outside the United States only.

READ ALL INSTRUCTIONS THOROUGHLY BEFORE YOU BEGIN.

Our products are for use by trained professional personnel using proper production automotive spray equipment suitable for the paint to be sprayed. Proper spray booth, air system, respirator and basic spray painting ability are required.

We do not recommend painting in temperatures below 70°F.

Although House of Kolor® is designed with high film build in mind, we do not recommend any finish that exceeds 15 mils in thickness. This would include the sanded OEM finish and the Kustom Paint finish.

NOT INTENDED FOR USE BY THE GENERAL PUBLIC.

For controlled results, House of Kolor® recommends products be used as a "total system." We do not recommend the intermixing of various manufacturer's products. This is only asking for trouble. No professional or amateur should run the risk of a job failure. Custom painting is complicated enough without gambling on untested product compatibility.

Apply only over House of Kolor® primers/sealers and/or properly prepared OEM paint. Do not apply House of Kolor® products over alkyd or synthetic enamels, uncatalyzed acrylic enamel, primers, sealers or topcoats that may not be coated with lacquer. You must control every step of the preparation including the products used for a successful paint job. Any unknowns such as existing primer, old paint, etc. can become the weak link in the custom painter's chain.

IMPORTANT: The data in this manual represent typical values obtained by the methods indicated. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. Unless Valspar agrees otherwise in writing, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. Unless Valspar agrees otherwise in writing, Valspar's only obligation for any defect in this product under any warranty that Valspar provides or under any other legal theory will be to replace the defective product, or to refund its purchase price, at Valspar's option.

CAUTIONS

Read Cautions and Warnings on all product can labels

TECHNICAL DATA

Material Safety Data Sheets available upon request.

TECHNICAL ASSISTANCE

(800) 845-2500

IMPORTANT VOC INFORMATION

The National Rule and SCAQMD Rule 1151 both make distinctions between base coat and mid coat application. The VOC calculations are different depending on which application procedure is chosen. It is important to know whether the system you are using is classified as base coat/clear coat or as a mid coat/multistage system.

All Shimrin® Base coats may be applied as either a base coat or mid coat. Shimrin® Base coats include the following codes: BC, FBC, NE, PBC, PC, SG, MB, KBC, and KF. Kosmic Kolor® Urethane Kandys and Solid Color Base coats may also be applied as a base coat or mid coat. Their codes are: UK, UB, and UFB.

BASE COAT APPLICATION

Applying the above products directly over the sealer, Ko-Seal® II (KS10, KS11, KS12, KS210, KS211, KS212) will classify the products as basecoats. The VOC limit for base coat/clear coat application would apply. Refer to Ko-Seal® II Sealer Recommendation Chart to choose the right sealer color for your application.

Example: KD2000 DTM Primer, KS10 Sealer, Shimrin® Base coat, Clear coat
base coat / clear coat

MID COAT APPLICATION

Applying any Shimrin® or Kosmic Kolor® coat over BC25, BC26, OR ANY Shimrin® Base coat will classify those products as a mid coat. This would apply whether or not a sealer was used. The VOC limit for mid coat/multistage application would apply.

Example: KD2000 DTM Primer, KS10 Sealer, BC26, Shimrin® Base coat, Clear coat
base coat / mid coat / clear coat

VERY IMPORTANT VOC INFORMATION FOR CALIFORNIA USERS

The South Coast Air Quality Management District (Rule 1151) (www.aqmd.gov) and the San Joaquin Valley Air Quality Management District (Rule 4602 and 4612 Phase II) (www.valleyair.org) have made significant changes to their current rules.

The South Coast Air Quality Management District (Rule 1151) rule goes into effect July 1, 2008. Any product manufactured prior to July 1, 2008, can be used through December 31, 2008. This district consists of the following areas:

Los Angeles County
Orange County
Western San Bernardino County
Western Riverside County

The San Joaquin Valley Air Quality Management District (Rule 4602 and 4612 Phase II) goes into effect January 1, 2009. This district consists of the following areas:

San Joaquin County
Stanislaus County
Madera County
Merced County
Fresno County
Kings County
Tulare County
Western Kern County

If you intend to do your custom paint job in any of the above listed areas after the dates stated, you must only use the products listed and follow the directions as outlined in this manual under California Products and application procedures, Appendix A.

MATERIAL AND USAGE RECOMMENDATIONS

PREPARATION

Custom finishing has unusually high product performance requirements that products designed for normal collision repair do not offer. For a durable, long lasting custom paint job, please refer to the below quick reference guide.

	Bare Metal, Body Fillers, Fiberglass & Some Plastics	Original Vehicle Finish	Artwork over Original Vehicle Finish
Step 1	KP or KD Epoxy Primer Plus Activator		
Step 2	KS Ko-Seal® II Plus Hardener & Reducer (Do Not User Over Bare Metal)	KS Ko-Seal® II Plus Hardener & Reducer	
Step 3	Shimrin® Base Coat Plus Reducer	Shimrin® Base Coat Plus Reducer	Shimrin® Base Coat Plus Reducer
Step 4	UK Kandy (Optional) Plus Reducer & Hardener	UK Kandy (Optional) Plus Reducer & Hardener	
Step 5	UC or UFC Clear Plus Reducer & Hardener	UC or UFC Clear Plus Reducer & Hardener	UC or UFC Clear Plus Reducer & Hardener

NOTE:

The key to a durable custom finish that will not chip or crack is the foundation. House of Kolor's KP & KD Epoxy Primers have been designed to offer superior adhesion, flexibility, and protection against body filler bleed through that other conventional urethane primers do not offer. KP & KD Epoxy Primers can be used over the original finish but it is not necessary.

Ko-Seal® II is always recommended when doing custom finishing. They do three things:

1. Improve the adhesion between the substrate and the base coat.
2. Improve color holdout.
3. Make the vehicle one color so fewer coats are required thereby reducing the amount of material needed and reducing the film build.

Due to the UV sensitivity of some of the pigments we use and the extreme film build often associated with custom painting only use House of Kolor® UC & UFC Clears. These clears were designed for the high film build. They offer a hard, flexible finish with a higher UV resistance than other clears designed for collision repair.

If your vehicle has previously been refinished, we recommend removing this to the original finish or to bare metal. Again the key to a durable custom paint job is the foundation. A chain is only as strong as its weakest link.

Please read, understand, and follow this manual before you begin your custom paint job.

BEFORE YOU BEGIN

READ ALL INSTRUCTIONS THOROUGHLY.

We do not recommend painting in temperatures below 70°F.

GENERAL INFORMATION

Poor preparation can cause future topcoat problems. Sand the original finish well. Use our KP2CF, or KD2000 activated Epoxy Primers over bare metal, body work, and for build at deep sanded areas on OEM Finishes.



1. BODY WORK

Prepare vehicle using special custom painting methods.

- A. Before any sanding, use KC10 Wax & Grease Remover to remove any tar, wax, or grease.
- B. Grind away paint and primer in areas requiring body work.
- C. Always be aware that your hands can transfer body oil, so keep a rag between you and the surface to be primed or painted and avoid touching the vehicle with your bare hand.
- D. Use power tools to get close when sanding filler. Then block sand. Keep the block front to rear, but crossing to prevent flat spots.
- E. Always prime with our KP2CF or KD2000 Primers. Allow proper cure time to prevent shrinkage.
- F. Guide coat your primer so when you block sand, your sand scratches and low spots are revealed.

PLEASE REFER TO SANDING GRIT RECOMMENDATIONS ON PAGE 59 FOR FINAL SANDING PRIMERS.

2. PRIMERS

Many bases are susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP2CF or KD2000 Epoxy Primers. **See tech sheets for more information on KP & KD Primers.**

NOTE: OEM (Original Equipment Manufacturer) coatings work well as a base for your paint job.

3. FOR EXISTING FINISHES

Surface should be free of wax, grease and foreign materials. Use KC10 Wax & Grease Remover prior to any sanding. For post-sanding, use our KC20 to remove any sanding residue for final wash.

PLEASE REFER TO THE SANDING RECOMMENDATION CHART ON PAGE 59 FOR FINAL SANDING OF OEM FINISHES.

Apply 1-2 coats of Ko-Seal® II (sealer). Let dry for 1 hour, but no longer than 2 hours before top coating.

NOTE: Do not attempt to apply a custom paint job on an OEM finish that is in excess of 6 mils, as paint failure can result from excessive film build. In other words, if the vehicle has been repainted, it is strongly suggested to either strip it back to the original finish, or better yet, to bare metal.

NOTE: In custom work, sealers should always be used as the ground coat. They improve adhesion, color and gloss holdout, and make the vehicle all one color for quicker hiding with the base coats.



GENERAL INFORMATION

The first steps in any project are very important to the overall success. The primer or foundation of your House of Kolor paint project is this first step. Our products are engineered to work as a complete system. The solvent and resin systems in House of Kolor are dramatically different from regular aftermarket automotive finishes. Often described as "hotter" our products are designed to be used as a system to virtually eliminate shrinkage. House of Kolor is designed to apply numerous coats or layers to achieve a dramatic finish. This is often described as "Looks a Mile Deep". It is critical not to intermix other manufacturer's products in your paint project. KD3000 is a hybrid epoxy two component primer designed to be used as a DTS or Direct to Substrate High Build High Build Surfacer, Medium Build Surfacer/High Build Sealer, or silky smooth sealer. Available in 6 premixed colors which can be intermixed for a wide range of colors. KD3000 is an industry first and undisputedly the best foundation system available. KD3000 has excellent adhesion, corrosion resistance, productive dry times, and ease of sanding. These DTS surfacer/sealers emit very low amounts of Volatile Organic Compounds (VOCs), Hazardous Air Polluting Solvents (HAPS), and contain no isocyanates. The KD3000 Series DTS surfacer/sealers may be applied to the existing OEM finish, bare steel, aluminum, fiberglass, galvanized surfaces, and various plastics. Its tenacious adhesion, hi-build, excellent durability, and water and corrosion resistance and ease of sanding makes it a superior choice for the basis of a long lasting custom paint job.

KD3000 Series Kustom DTS Foundation Surfacer/Sealer:

- Resists cracking
- Prevents plastic filler staining or bleed through
- Multiple colors greatly improves speed and accuracy of contour sanding when used as a Medium Build Surfacer
- Lay Flat application properties greatly reduce surface prep and consumption of abrasives
- Does not stain, shrink, or swell from sand scratches
- Cures as HB Surfacer for contour sanding in under 2 hours at 70°F
- Cures as Sealer for topcoating in under 30 minutes at 70°F

IMPORTANT NOTES

- DO NOT USE ANY ACID BASE PRODUCTS SUCH AS SELF ETCHING PRIMERS, ETC. UNDER THE KD3000 SERIES DTS SURFACER/SEALERS. THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.
- IF YOU FIND IT NECESSARY TO USE A METAL CONDITIONER TO REMOVE RUST, ETC., BE SURE TO THOROUGHLY CLEAN AND NEUTRALIZE THE TREATED AREA FOLLOWING THE CONDITIONER MANUFACTURERS RECOMMENDATIONS, THEN USING OUR KC20 POST SANDING CLEANER WITH A MAROON SCUFF PAD TO INSURE ALL ACID RESIDUE HAS BEEN REMOVED BEFORE PRIMING. IF NOT, THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM
- IN CUSTOM PAINTING, IT IS NOT UNCOMMON TO EXPERIENCE POLYESTER STAINING FROM BOTH BODY FILLERS, GLAZING PUTTIES, AND FIBERGLASS RESINS. THE KD3000 SERIES DTS SURFACER/SEALER IS DESIGNED TO PREVENT THIS STAINING PROBLEM AS LONG AS THE FILLERS/PUTTIES ARE MIXED AND APPLIED PROPERLY, AND THE AFTER SANDING MILLAGE REMAINS AT LEAST 2 MILS.



SUBSTRATE

Properly Prepared:

- Original finish
- Ferrous and non-ferrous metals
- Fiberglass and composites
- Plastics (Pre-test adhesion and compatibility)
- Body Fillers
- Miscellaneous unclassified substrates (Pre-test adhesion and compatibility)



PREPARATION

Surface to be primed should be free of wax, grease, rust, etc. IMPORTANT: Clean with KC10 prior to sanding. Do not apply KD3000 Series DTS surfacer/sealers over uncatalyzed primers. KD3000 Series DTS surfacer/sealers may be applied over properly prepared OEM factory primers and finishes, but for maximum adhesion and corrosion protection it is best to apply KD3000 Series DTS surfacer/sealers directly to the bare substrate.



SANDING THE SUBSTRATE

Bare metal

- Minimum 80P grit DA sandpaper

Body fillers

- Minimum 80P

OEM Finish

- 320P dry or 500 wet



COMPONENTS

- HOK1052015 Color Check Panel. A must have color tool. This innovative pray-out panel consists of 62 KD3000 series color variations. Color styling has never been faster. Simply apply basecoats over panel to achieve an instant library of colors and effects.
- KD3000 – Medium Gray
- KD3001 – Black
- KD3002 – White
- KD3003 – Yellow
- KD3004 – Red
- KD3005 – Blue
- KDA3000 – Activator
- RU310 – Fast Reducer 65°F to 75°F
- RU311 – Medium Reducer 75°F to 85°F
- RU312 – Slow Reducer 85°F to 95°F
- RU313 – Very Slow Reducer 95°F to 100+°F
- RU300 - LV Cool Weather Reducer 70°F to 85°F
- RU301 - LV Warm Weather Reducer 85°F to 100+°F



MIXING RATIO (Visit www.houseofkolor.com to view formulas and mixing tables)

APPLIED AS A HIGH BUILD (HB) SURFACER

Mix four (4) parts KD3000 Series DTS Surfacers/Sealer to one (1) part KDA3000 Activator. **(4:1 by volume)**



APPLIED AS A MEDIUM BUILD (MB) SURFACER OR HIGH BUILD (HB) SEALER

Mix four (4) parts KD3000 Series DTS Surfacers/Sealer to one (1) part KDA3000 Activator to one (1) part RU Reducer. **(4:1:1 by volume)**

APPLIED AS A SEALER

Mix four (4) parts KD3000 Series DTS Surfacers/Sealer to one (1) part KDA3000 Activator to two (2) parts RU Reducer. **(4:1:2 by volume)**

Note: Kosmic Reducer selection should be based on the size of the area to be painted, air movement, and temperature. For example start and run your spray booth prior to checking temperature. Then match the RU reducer for that temperature. KD3000 Series Kustom DTS Foundation Surfacers/Sealer is a catalyzed two component system. Aggressively mix the KD3000 Series DTS surfacer/sealer thoroughly before activating or reducing. Always measure, do not guess. Thoroughly mix components to insure optimal coatings performance; use a paint shaker for best results. No incubation (sweat in) time is required. Shop conditions can vary pot life.



Online
Kwik-Mix

FOR CALIFORNIA 2.1 lbs./gal. (252 g/L)

Reduce with RU300 LV Cool Weather Reducer or RU301 LV Warm Weather Reducer.

POT LIFE

As a surfacer – 45 to 90 minutes (depending on shop conditions)

As a Sealer – 1 to 2 hours (depending on shop conditions)



GUN SET UP

HVLP Gun

Used as a High Build/Medium Build Surfacers/Sealer = 1.7 to 1.8 tips

Used as a High Build/Medium Build Surfacers = 1.7 to 1.8 tips

Used as a Sealer = 1.3 to 1.5 Needle/Nozzle (Depending on the size of object being painted)

Used as a High Build/Medium Build Surfacers = 100% Trigger Pull

Used as a Sealer = 50% to 75% Trigger Pull

Not Recommended for Air Brush Application



APPLICATION

Used as a High Build/Medium Build Surfacers

Strain mixture. Apply 2 to 3 full wet coats with a 50% pattern overlap. Apply an additional 2 full wet coats over polyester fillers and spot and glazing putties. Allow flash time between coats (flashes dull approx. 10 to 15 minutes).



Used as a Sealer

Strain mixture. Apply 1 to 2 Medium Wet Coats with a 50% pattern overlap. Allow flash time between coats (flashes dull, approx. 5 to 15 minutes).

DRY TIME

Used as a High Build /Medium Build Surfacers

At 70°F, allow to cure approx. 90-120 minutes before sanding. If you exceed more than 3 coats, the cure time may be longer. For higher production you can bake the surfacer at 140°F for 30 minutes. Allow the surfacer to flash 15 minutes prior to baking with a 30 minute cool down prior to sanding. Overnight dry time is best.



Used as a Sealer

Sealers are designed to create a chemical bond between the surfacer and the base coat. Allow the sealer to dry 15-30 min. but not to exceed 4 hours prior to top coating. Thoroughly sand sealed surfaces with 500 to 600 wet sand paper if top coating window extends more than 4 hours.

Note: Flash and Dry Times will be longer in cool temperatures, slow air movement or when applied in heavier coats.

GUIDE COAT

Used as a High Build /Medium Build Surfacers

Multiple color choices of KD3000 series greatly improves speed and accuracy when contour sanding. High and low areas become more visible when using different colors of KD for each coat when used as a High Build or Medium Build surfacer. Prior to sanding, apply a Guide Coat of reduced KD3000 in a contrasting color. During the sanding process, the contrasting color of the guide coat will remain in low areas and become a guide telling you how much sanding is required to smooth the KD3000. Remove the guide coat then continue with a few more sanding strokes and move on. Be careful so you don't expose any body filler. If the primer is less than 2 mils after sanding, bleed through of filler is possible. Reapply KD3000 to cut through areas.



FINISH SANDING

Used as a High Build /Medium Build Surfacers

- Initial Block Sanding (Optional, see info below)
 - o 100P to 150P grit dry sandpaper
- Finish Sanding
 - o Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - o Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - o Tight Areas (door jams, etc.) = Maroon scuff pad





FINISH SANDING (Continued)

Block sand wet or dry. IF BODY FILLER IS EXPOSED, RE-PRIME WITH KD3000 TO PREVENT STAINING. May dry sand KD3000 with 100 or 150 grit, then re-prime with 2 or 3 more coats of KD3000. KD3000 may also be wet sanded. Then simply seal coat with the KD3000 mixed as a sealer and apply topcoats. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS.**



NOTE: Do not use alkyd or synthetic sealers or primers with House of Kolor® products as lifting may occur.

NOTE: To prevent bleeding or discoloration of base coats caused by body fillers, at least 2 mils of primer must remain after sanding. (1 coat equals approximately 1 mil when sprayed with production equipment using 4:1 mixing ratio).



CLEAN UP

Clean equipment thoroughly with lacquer thinner, acetone, or urethane reducer (check local regulations).



TECHNICAL DATA

	High Build (4:1) (National Rule)	High Build (4:1) (California Rule) 2.1 lbs./gal. (252 g/L)	Medium Build (4:1:1) (National Rule)	Medium Build (4:1:1) (California Rule) 2.1 lbs./gal. (252 g/L)	Primer Sealer (4:1:2) (National Rule)	Primer Sealer (4:1:2) (California Rule) 2.1 lbs./gal. (252 g/L)
Coatings Category	Primer	Primer	Primer	Primer	Primer Sealer	Primer Sealer
Packaged Density	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)
Packaged VOC	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)
Actual VOC Ready to Spray	1.64 lbs./gal. (197 g/L)	1.64 lbs./gal. (197 g/L)	2.6 lbs./gal. (312 g/L)	1.36 lbs./gal. (163 g/L)	3.28 lbs./gal. (394 g/L)	1.17 lbs./gal. (140 g/L)
Regulatory VOC Ready to Spray less exempt solvents	2.1 lbs./gal. (252 g/L)	2.1 lbs./gal. (252 g/L)	3.18 lbs./gal. (381 g/L)	2.1 lbs./gal. (252 g/L)	3.89 lbs./gal. (467 g/L)	2.1 lbs./gal. (252 g/L)
Total HAPS (g HAPS/L) Packaged	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)
HAPS Ready to Spray	0.91 lbs./gal. (109 g/L)	0.91 lbs./gal. (109 g/L)	2.86 lbs./gal. (343 g/L)	0.91 lbs./gal. (109 g/L)	4.79 lbs./gal. (575 g/L)	0.91 lbs./gal. (109 g/L)
Total Solids by Volume (Ready to Spray)	41.72%	41.72%	34.77%	34.77%	29.80%	29.80%
Wt % Volatiles (Ready to Spray)	46.09%	46.09%	52.19%	54.18%	57.05%	60.16%
Wt % Exempt Compounds (Ready to Spray)	32%	32%	28.37%	42.19%	25.48%	49.74%
Wt % Water (Ready to Spray)	0%	0%	0%	0%	0%	0%
Viscosity						
#2 Signature Zahn @ 77°F	N/A	N/A	15 to 20 Seconds	15 to 20 Seconds	14 to 18 Seconds	14 to 18 Seconds
DIN 4 @ 77°F	25 to 40 Seconds	25 to 40 Seconds	14 to 20 Seconds	14 to 20 Seconds	12 to 16 Seconds	12 to 16 Seconds
Recommended Dry Film Build per Coat	1.3 mils	1.3 mils	1 mil	1 mil	¾ mils	¾ mils
Sq. Ft. Coverage/gal @ 1 mil	669 Sq. Ft.	669 Sq. Ft.	558 Sq. Ft.	558 Sq. Ft.	478 Sq. Ft.	478 Sq. Ft.

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

SS01 House of Kolor Silver Sealer is the only silver sealer in the automotive paint business. Considered a must under all metallic based colors for easy to spray even coverage of metallic basecoats. Fewer topcoats will be necessary for additional savings. Built from a Polyurethane resin system to provide tenacious adhesion and long term color hold out. Engineered to work over House of Kolor's new KD3000 Direct to Substrate colored primer system, KP, KS, KD systems, and OE finishes. SS01 can also be custom tinted with up to 10% of Kandy Koncentrate for an even closer color match under Shimrin2® and original Shimrin® basecoats and Kandy basecoats.

National Rule Compliant Products

VOC= 4.58 lbs./gal. 550 g/L

SCAQMD Rule 1151 Compliant Products

VOC= 2.08 lbs./gal. 250 g/L

NOTE: SS01 SHOULD NOT BE APPLIED OVER BARE METAL SURFACES OF ANY KIND. SS01 MUST BE APPLIED OVER SANDED AND CLEAN PRIMER OR PROPERLY PREPARED AND SANDED PREVIOUSLY PAINTED SURFACES FOR PROPER ADHESION.

SS01 is a high quality two component polyurethane sealer designed to:

- Act as a bond coat between primer and top coats.
- Act as a holdout agent to prevent topcoats from soaking into the primer and reducing gloss.
- Make the object to be painted an appropriate color for faster coverage of top coats.
- Can be applied over properly prepared and sanded previously painted OEM surfaces, KP, or KD Series House of Kolor® Primers for proper adhesion of topcoats.

SS01 is a high quality polyurethane catalyzed sealer designed to be used with all House of Kolor BC, KBC, SG, PBC basecoat products. Choose the appropriate color for the base coat system and color that is going to be applied. Add 10 percent Kandy Koncentrates to SS01 Silver Sealer for a closer match to the base coat or top coat color.

For use under a UKK or UK Kandy we recommend applying 2 coats of a BC basecoat to balance final appearance.



SUBSTRATE

- OEM finish
- KP & KD Epoxy Primers



SANDING THE SUBSTRATE

- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Tight Areas (door jams, etc.) = Maroon scuff pad



PREPARATION

Use only House of Kolor's KP or KD Epoxy Primers over bare metal substrates or metal substrates with body work. **See tech sheet for more information on KP and KD Epoxy Primers.**



COMPONENTS

- SS01 - Silver Sealer
- KU152 - Catalyst
- Optional - KK - Kandy Koncentrates



MIXING SS01 SILVER SEALER

Simply add catalyst and spray, no reduction necessary

- **6** parts SS01 Silver Sealer
- **1** part KU152 Hardener
- **10%** KK Koncentrate optional
- **NOTE:** RU Reducers may be added up to 10% for additional flow and control



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not Recommended



APPLYING SS01 SILVER SEALER

Strain the sealer after mixing. Gun distance while spraying should be approximately 5 to 6 inches.

Apply 1 or 2 medium wet coats with 50% pattern overlap. Walk long objects. Be sure of thorough coverage. Allow flash 10 to 15 minutes between coats.

NOTE: Mottling may occur in areas where SS01 is applied too heavily. To correct this use a drop coat or mist coat which is applied at a slightly lower pressure and quicker pass over these areas.

DRY TIME

Allow to dry 30 minutes to 1 hour but no longer than 4 hours. After 4 hours we recommend sanding with 500/600 sandpaper and reapply SS01 sealer. Seal coats are applied just prior to spraying color and clear. They are not meant to be a stopping point on your project. All dry times are based on 70 degrees. Dry times will vary with weather and shop conditions.

**CLEAN UP**

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

**TECHNICAL DATA**

	National Rule	California Rule
Coatings Category	Component	Component
Packaged Density	10.15 lbs./gal. (1216 g/L)	10.15 lbs./gal. (1216 g/L)
Packaged VOC	0.83 lbs./gal. (99.4 g/L)	0.83 lbs./gal. (99.4 g/L)
Actual VOC RTS less exempt solvents	0.71 lbs./gal. (85.1 g/L)	0.71 lbs./gal. (85.1 g/L)
Regulatory VOC RTS less exempt solvents	1.45 lbs./gal. (173.61 g/L)	1.45 lbs./gal. (173.61 g/L)
Total HAPS (lb. HAPS/Solid Gal.) Packaged	0.2621 lbs./gal. (31.4 g/L solid)	0.2621 lbs./gal. (31.4 g/L solid)
(HAPS) Ready to Spray	0.192 lbs./gal. (23.0 g/L solid)	0.192 lbs./gal. (23.0 g/L solid)
Total % Solids by volume (RTS)	35.51%	35.51%
Weight % Volatiles (RTS)	64.49%	64.49%
Weight % exempt compounds (RTS)	57.47%	57.47%
Weight % water (RTS)	0%	0%
Viscosity (Ready To Spray)		
#2 Signature Zahn @ 77°F	20.8 seconds	20.8 seconds
DIN 4 @ 77°F	16.9 seconds	16.9 seconds
Recommended Dry Film Build per Coat	1.5 mil	1.5 mil
Sq. Ft. Coverage/gal @ 1 mil	536.98 sq ft./gal @ 1 mil	536.98 sq ft./gal @ 1 mil

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



HOUSE of KOLOR
SHIMRIN2®

SHIMRIN2® SOLID BASECOATS

S2-25 JET BLACK / S2-26 BRIGHT WHITE



GENERAL INFORMATION

Shimrin2® is the 2nd generation of the proven Shimrin® Basecoat technology introduced in 1982. Shimrin2® is the next generation of ground-breaking universal basecoats from House of Kolor. Through new innovative polymer chemistry we are able to meet and exceed waterborne with a solvent based system designed for Kustom Painting. S2-25 Jet Black and S2-26 Bright White are Shimrin2® universal basecoats that may be cleared for a final finish, or used as a foundation for Shimrin2® standard basecoats including Kandy Basecoats, and your own Kustom Kreations. The Jetest black and the brightest white are a must-have on every painter's bench.

Shimrin2® remains a solvent base system yet meets all VOC rules coast to coast including California.

IMPORTANT NOTES

- In Custom Painting, Sealers are not an option, they are a must. They have 3 functions:
 - 1) They greatly improve adhesion between the substrate and the base coat.
 - 2) They make the vehicle one color thereby reducing the number of coats of base, saving you money.
 - 3) They greatly improve color hold out and finish quality.



SUBSTRATE

- KD3000 Series DTS Foundation Surfacers Sealers
- KS, KD, KP Series Primers and Sealers
- All House of Kolor Shimrin® Universal Bases
- Properly cured and prepared OEM finishes



PREPARATION

Please be aware that Shimrin® / Shimrin2® bases, Kandy's and Klears can be susceptible to staining or bleeding from polyester body fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD3000 Series or KP Series Primers. It is important to maintain at least a 2 dry mil film thickness of KD3000 Series DTS Foundation Surfacers Sealer or, KP series over all fillers and putties.



SANDING THE SUBSTRATE

For all substrates

- Dry Sanding: FIPA grade = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sanding: FIPA grade = 600P to 800P grit (CAMI grade = 400 to 500 grit)



NOTE: Typically sealers do not need to be sanded. Do not seal until you are ready to apply the paint. This is where your chemical bond begins.



COMPONENTS

- S2-25 Jet Black or S2-26 Bright White Shimrin2®
- RU310 – Fast Reducer 65°F to 75°F
- RU311 – Medium Reducer 75°F to 85°F
- RU312 – Slow Reducer 85°F to 95°F
- RU313 – Very Slow Reducer 95°F to 100+°F
- RU300 - LV Cool Weather Reducer 70°F to 85°F
- RU301 - LV Warm Weather Reducer 85 to 100+°F
- Optional: S2 FX Effect Pacs



MIXING RATIO

National Rule Solid Color 2:1 by volume

- **2** parts Shimrin2® Solid Basecoat (S2-25 or S2-26)
- **1** part RU Reducer (RU310, RU311, RU312, or RU313)

California Rule 2:1 by volume

- **2** parts Shimrin2® Solid Basecoat (S2-25 or S2-26)
- **1** part RU Exempt Reducer (RU301 or RU302)

Optional - Mixing S2 Fx Effect Pacs with solid bases - 3:1:2 by volume

- **3** parts Shimrin2® Solid Basecoat (S2-25 or S2-26)
- **1** part S2-FX Effect Pac
- **2** parts RU Exempt Reducer (RU300 or RU301) or standard RU Reducers (RU310 - RU313)

NOTE: Airbrush Application - reduce to desired strength (for all mixing ratios)



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Apply 2 to 3 medium coats of Shimrin2® (S2-25 or S2-26) with a 50% pattern overlap. Allow each coat to flash dull (Typically 5 to 15 minutes) between coats. If you intend to do artwork over the Jet Black or Bright White, we suggest you allow the base to flash 30 minutes then apply 2 coats of S2-SG100 Intercoat (see tech sheet on S2-SG100) to protect against tape tracking, etc.

**HOUSE of KOLOR**
SHIMRIN2®**SHIMRIN2® SOLID BASECOATS**
S2-25 JET BLACK / S2-26 BRIGHT WHITE

DRY TIME

Allow to flash from 30 minutes up to a max. 4 hours before top coating with USC01 Urethane Show Klear, or other Kosmic Klears (refer to the tech sheet specific to the Klear system you intend to use).



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA



	National Rule	California Rule
Coatings Category	Color Coating	Color Coating
Packaged Density	VARIES	VARIES
Packaged VOC	2.34 lbs./gal. (280 g/L) Max	2.34 lbs./gal. (280 g/L) Max
Actual VOC Ready to Spray	3.05 lbs./gal. (366 g/L) Max	0.89 lbs./gal. (107 g/L) Max
Regulatory VOC Ready to Spray less exempt solvents	5.69 lbs./gal. (683 g/L) Max	3.06 lbs./gal. (367 g/L) Max
Total HAPS (g HAPS/L) Packaged	0.23 lbs./gal. (27 g/L solid) Max	0.23 lbs./gal. (27 g/L solid) Max
HAPS Ready to Spray	12.58 lbs./gal. (1510 g/L solid) Max	0.5 lbs./gal. (60 g/L solid) Max
Total % Solids by Volume (Ready to Spray)	10 - 17	10 - 17
Wt % Volatiles (Ready to Spray)	71 - 78	71 - 78
Wt % Exempt Compounds (Ready to Spray)	40 - 55	66 - 86
Wt % Water (Ready to Spray)	0.0	0.0
Viscosity (Ready to Spray)		
#2 Signature Zahn @ 77°F	14 - 20 seconds	14 - 20 seconds
DIN 4 @ 77°F	14 - 20 seconds	14 - 20 seconds
Recommended Dry Film Build per Coat	0.2 - 0.5	0.2 - 0.5
Sq. Ft. Coverage/gal @ 1 mil	240 - 272 sq. ft./gal. @ 1 mil	240 - 272 sq. ft./gal. @ 1 mil

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

Shimrin2® is the 2nd generation of the proven Shimrin® Basecoat technology introduced in 1982. Shimrin2® is the next generation of ground-breaking universal basecoats from House of Kolor. Through new polymers and innovative chemistry we are able to meet and exceed waterborne with a solvent based system designed for Kustom Painting. S2-00 Trans Nebulae is the beginning of all Shimrin2® effects, making it the heart of the Shimrin2® product system. This diverse component of the S2 FX Karrier Base Series is used to create straight effects without pigment, KBC Kandy basecoats, tri-stage coats and much more. Color styling is a breeze with S2 FX Karrier Bases S2-01 through S2-16. From classic favorites like Galaxy Gray, Solar Gold, and Planet Green, to new trend setting colors like Eclipse Orange, Solarflair Red, Lunar Yellow, and Mayan Magenta. These new FX Karrier bases combined with 40 different S2-FX Effect pacs will have your eyes popping with extreme clarity, Kandy-like micro grind of pigments, and full spectrum of color attributed to advanced manufacturing techniques, innovative chemistry and robust polymer engineering.

Shimrin2® Karrier basecoats remain a solvent base system and is VOC compliant coast to coast including California.

IMPORTANT NOTES

- All Shimrin2® base coats are semi-translucent. It is critical the vehicle or substrate is ground coated with one even color. An excellent ground coat is House of Kolor's SS01 Silver Sealer, KD3000 DTS Foundation Surfacer/Sealers, and S2-25/S2-26. The color of the ground coat will effect the appearance of the base coat.
- We recommend using a ground coat color that is closest to the Shimrin2® base coat color. This will reduce the number of coats of Shimrin2® basecoats required to achieve desired color or effect.
- HOK1052015 Color Check Panel. A must have color tool. This innovative spray-out panel consists of sixty-two KD3000 series color variations. Color styling has never been easier or faster. Simply apply basecoats over panel to achieve an instant library of colors and effects.



SUBSTRATE

- KD3000 Series DTS Foundation Surfacer / Sealer
- SS01 Silver Sealer
- KS, KD, KP Series Primers and Sealers
- All Shimrin® and Shimrin2® Base Coats
- Properly cured and prepared OEM Finishes



PREPARATION

Please be aware that Shimrin® / Shimrin2® bases, Kandy's and Klears can be susceptible to staining or bleeding from polyester body fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD3000 Series or KP Series Primers. It is important to maintain at least a 2 dry mil film thickness of KD3000 Series DTS Foundation Surfacer Sealer or, KP series over all fillers and putties.

GROUND COAT

- Sealer SS01 Silver Sealer or KD3000 series mixed and applied as a sealer

SHIMRIN2® BASE COATS ARE TRANSLUCENT AND THE VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. We suggest using Sealers as a ground coat. Simply select a KD3000 formula close to the Shimrin2® base coat color you intend to use. This will reduce the number of coats of Shimrin2® base coats required to achieve desired color and effect. For the quickest and easiest approach to selecting ground coat, apply basecoat over KD3000 Color Check panel (part # HOK1052015) and select which formula best matches your desired color and effect.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.



COMPONENTS

Shimrin2 FX Karrier Bases	FX Metalume® Series	FX Kosamene® Series	FX Kosmatic Styling Pearl® Series	FX Metajuls® Series	FX Kameleon® Series	FX Kosmic Sparks® Series
S2-00 Trans Nebulae	S2-FX01 Super Fine-SFBC FX	S2-FX21 Brass Pearl FX	S2-FX31 KSP Strikn Gold FX	S2-FX41 MBC Prism FX	S2-FX51 KPF Green to Blue FX	S2-FX61 KDP Sno White FX
S2-01 Solar Gold	S2-FX02 Fine-FBC FX	S2-FX22 Sterling Silver Pearl FX	S2-FX32 KSP Red FX	S2-FX42 MBC Pale Gold FX	S2-FX52 KPF Gold to Green FX	S2-FX62 KDP Gold Rush FX
S2-02 Celestial White	S2-FX03 Medium-BC FX	S2-FX23 Russet Pearl FX	S2-FX33 KSP Violet FX	S2-FX43 MBC Red FX	S2-FX53 KPF Copper Red to Green FX	S2-FX63 KDP Blushing Red FX
S2-03 Galaxy Gray	S2-FX04 Course-CBC FX	S2-FX24 Copper Pearl FX	S2-FX34 KSP Blue FX	S2-FX44 MBC Blue FX	S2-FX54 KPF Sapphire FX	S2-FX64 KDP Copper Penny FX
S2-04 Stratto Blue	S2-FX05 Super Silver-SSBC FX	S2-FX25 Bronze Pearl FX	S2-FX35 KSP Green FX	S2-FX45 MBC Yellow FX	S2-FX55 KPF Aquarius FX	S2-FX65 KDP Summertime Green FX
S2-05 Lapis Blue			S2-FX36 KSP Turquoise FX	S2-FX46 MBC Green FX	S2-FX56 KPF Mayan Eruption FX	S2-FX66 KDP Ocean Blue FX
S2-06 Meteor Maroon			S2-FX37 KSP Magenta FX	S2-FX47 MBC Silver FX		S2-FX67 KDP Turquoise FX
S2-07 Gamma Gold			S2-FX38 KSP Indigo FX			
S2-08 Eclipse Orange			S2-FX39 KSP White FX			
S2-09 Planet Green						
S2-10 Pavo Purple						
S2-11 Mayan Magenta						
S2-12 Zenith Gold						
S2-13 Velocity Violet						
S2-14 Lunar Yellow						
S2-15 Solarflair Red						
S2-16 Re-Entry Red						



COMPONENTS (Continued)

- RU310 – Fast Reducer 65°F to 75°F
- RU311 – Medium Reducer 75°F to 85°F
- RU312 – Slow Reducer 85°F to 95°F
- RU313 – Very Slow Reducer 95°F to 100+°F
- RU300 – LV Cool Weather Reducer 70°F to 85°F
- RU301 – LV Warm Weather Reducer 85 to 100+°F



MIXING RATIO - STANDARD BASECOAT (Visit www.housofkolor.com to view formulas and mixing tables)

National Rule 3:1:2 by volume

- 3 parts Shimrin2® FX Karrier Base
- 1 Part S2-FX Effect Pac
- 2 part RU Reducer (RU310, RU311, RU312, or RU313)



Online
Kwik-Mix

California Rule 3:1:2 by volume

- 3 parts Shimrin2® FX Karrier Base
- 1 Part S2-FX Effect Pac
- 2 part RU Reducer (RU300 or RU301)

MIXING RATIO - KUSTOM KREATOR BASECOAT

Create your own Kustom Kreator Kolors. All Shimrin2® components are intermixable. Combine multiple Karrier Bases, FX Effect Pacs, Kandy Koncentrates (KK), Flakes (F), Dry Pearls (DP), and more.



National Rule

- 2 parts Kustom Kreator Kolor
- 1 part RU Series Reducers (RU310, RU311, RU312, or RU313)

California Rule

- 2 parts Kustom Kreator Kolor
- 1 part RU Series Reducers (RU300 or RU301)

Your only limitation is your imagination with Shimrin2®. All FX Karrier Bases can be intermixed, reduced 2:1, and sprayed as Kolors without effects. If you wish to spray effects, simply use 3 parts S2-00 Trans Nebulae and 1 part S2-FX Effect. S2-00 Trans Nebulae should also be used as a Karrier for Flakes (F Series) and Dry Pearls (DP Series).

GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Apply 2 to 3 medium coats of Shimrin2® Base Coat with a 50% pattern overlap. Allow each coat to flash dull (Typically 5 to 15 minutes) between coats. If you intend to do artwork over the Shimrin2® base coat, we suggest you allow the base coat to flash 15 minutes then apply 2 medium coats of S2-SG100 Intercoat (see tech sheet on S2-SG100) to protect against tape tracking and overspray under the masking tape, etc.



DRY TIME

Allow to flash from 30 minutes up to 4 hours maximum prior to applying klear. House of Kolor USC01 Urethane Show Klear is recommended for maximum durability and protection of your custom paint project. House of Kolor Klears have 3 times the UV blocking capability of regular automotive clear. Do not Intermix other manufacturers' products with House of Kolor.



CLEAN UP

Clean equipment thoroughly with lacquer thinner, acetone, or urethane reducer (check local regulations).





TECHNICAL DATA

	National Rule	California Rule
Coatings Category	Color Coating	Color Coating
Packaged Density	VARIES	VARIES
Packaged VOC	2.34 lbs./gal. (280 g/L) Max	2.34 lbs./gal. (280 g/L) Max
Actual VOC Ready to Spray	3.05 lbs./gal. (366 g/L) Max	0.89 lbs./gal. (107 g/L) Max
Regulatory VOC Ready to Spray less exempt solvents	5.69 lbs./gal. (683 g/L) Max	3.06 lbs./gal. (367 g/L) Max
Total HAPS (g HAPS/L) Packaged	0.23 lbs./gal. (27 g/L solid) Max	0.23 lbs./gal. (27 g/L solid) Max
HAPS Ready to Spray	12.58 lbs./gal. (1510 g/L solid) Max	0.5 lbs./gal. (60 g/L solid) Max
Total % Solids by Volume (Ready to Spray)	10 - 17	10 - 17
Wt % Volatiles (Ready to Spray)	71 - 78	71 - 78
Wt % Exempt Compounds (Ready to Spray)	40 - 55	66 - 86
Wt % Water (Ready to Spray)	0.0	0.0
Viscosity (Ready to Spray)		
#2 Signature Zahn @ 77°F	14 - 20 seconds	14 - 20 seconds
DIN 4 @ 77°F	14 - 20 seconds	14 - 20 seconds
Recommended Dry Film Build per Coat	0.2 - 0.5	0.2 - 0.5
Sq. Ft. Coverage/gal @ 1 mil	240 - 272 sq. ft./gal. @ 1 mil	240 - 272 sq. ft./gal. @ 1 mil

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

Shimrin2® is the 2nd generation of the proven Shimrin® Basecoat technology introduced in 1982. Attributed to advanced manufacturing techniques, innovative chemistry and robust polymer engineering, Shimrin2® Kandy Basecoats (KBC) are the next generation of ground-breaking universal basecoats from House of Kolor. Through innovative chemistry, we are able to meet and exceed waterborne with a solvent-based system designed for Kustom Painting. S2-00 Trans Nebulae is the beginning of all Shimrin2® effects, making it the heart of the Shimrin2® Kandy Basecoat (KBC) system. This diverse component of the S2 FX Karrier Base Series combined with our rich Kandy Koncentrates (KK) and 40 different S2-FX pacs options create extreme clarity, Depth, and Kandy-like appearance in a simple to apply 2 stage Base/Klear system.

Shimrin2® Kandy Basecoats (KBC) remain a solvent base system and is VOC compliant coast to coast including California.

IMPORTANT NOTES

- All Shimrin2® Kandy basecoats are translucent. It is critical the vehicle or substrate is ground coated with one even color. An excellent ground coat is House of Kolor's SS01 Silver Sealer, KD3000 DTS Foundation Surfacer/Sealers, and S2-25/S2-26. The color of the ground coat will effect the appearance of the Kandy basecoat. Darker basecoats or sealers improve spray ability and depth.
- HOK1052015 Color Check Panel. A must have color tool. This innovative spray-out panel consists of sixty-two KD3000 series color variations. Color styling has never been easier or faster. Simply apply basecoats over panel to achieve an instant library of colors and effects.



SUBSTRATE

- KD3000 Series DTS Foundation Surfacer / Sealer
- SS01 Silver Sealer
- KS, KD, KP Series Primers and Sealers
- All Shimrin® and Shimrin2® Base Coats
- Properly cured and prepared OEM Finishes



PREPARATION

Please be aware that Shimrin® / Shimrin2® bases, Kandy's and Klears can be susceptible to staining or bleeding from polyester body fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD3000 Series or KP Series Primers. It is important to maintain at least a 2 dry mil film thickness of KD3000 Series DTS Foundation Surfacer Sealer or, KP series over all fillers and putties.

GROUND COAT

- Seal with SS01 Silver Sealer, KD3000 series sealers, S2-25 Jet Black or S2-26 Bright White.

SHIMRIN2® BASE COATS ARE TRANSLUCENT AND THE VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.



COMPONENTS

Shimrin2® FX Karrier Base

- S2-00 Trans Nebulae

Shimrin2® FX Effect Pacs

FX Metalume® Series

S2-FX01 Super Fine-SFBC FX

S2-FX02 Fine-FBC FX

S2-FX03 Medium-BC FX

S2-FX04 Course-CBC FX

S2-FX05 Super Silver-SSBC FX

FX Kosamene® Series

S2-FX21 Brass Pearl FX

S2-FX22 Sterling Silver Pearl FX

S2-FX23 Russet Pearl FX

S2-FX24 Copper Pearl FX

S2-FX25 Bronze Pearl FX

FX Kosmatic Styling Pearl® Series

S2-FX31 KSP Striken Gold FX

S2-FX32 KSP Red FX

S2-FX33 KSP Violet FX

S2-FX34 KSP Blue FX

S2-FX35 KSP Green FX

S2-FX36 KSP Turquoise FX

S2-FX37 KSP Magenta FX

S2-FX38 KSP Indigo FX

S2-FX39 KSP White FX

FX Metajuls® Series

S2-FX41 MBC Prism FX

S2-FX42 MBC Pale Gold FX

S2-FX43 MBC Red FX

S2-FX44 MBC Blue FX

S2-FX45 MBC Yellow FX

S2-FX46 MBC Green FX

S2-FX47 MBC Silver FX

FX Kameleon® Series

S2-FX51 KPF Green to Blue FX

S2-FX52 KPF Gold to Green FX

S2-FX53 KPF Copper Red to Green FX

S2-FX54 KPF Sapphire FX

S2-FX55 KPF Aquarius FX

S2-FX56 KPF Mayan Eruption FX

FX Kosmic Sparks® Series

S2-FX61 KDP Sno White FX

S2-FX62 KDP Gold Rush FX

S2-FX63 KDP Blushing Red FX

S2-FX64 KDP Copper Penny FX

S2-FX65 KDP Summertime Green FX

S2-FX66 KDP Ocean Blue FX

S2-FX67 KDP Turquoise FX

KK Kandy Koncentrates

KK01 Brandywine

KK02 Lime Gold

KK03 Wild Cherry

KK04 Oriental Blue

KK05 Cobalt Blue

KK06 Burgundy

KK07 Root Beer

KK08 Tangerine

KK09 Organic Green

KK10 Purple

KK11 Apple Red

KK12 Pagan Gold

KK13 Purple

KK14 Spanish Gold

KK15 Teal

KK16 Magenta

KK18 Pink

KK22 Voodoo Violet

RU Series Reducers

RU310 – Fast Reducer 65°F to 75°F

RU311 – Medium Reducer 75°F to 85°F

RU312 – Slow Reducer 85°F to 95°F

RU313 – Very Slow Reducer 95°F to 100+°F

RU300 – LV Cool Weather Reducer 70°F to 85°F

RU301 – LV Warm Weather Reducer 85 to 100+°F



MIXING RATIO - STANDARD KANDY BASECOAT (KBC) (Visit www.housofkolor.com to view formulas and mixing tables)

National Rule (8 : 1 : 1/2 : 50%)

- 8 parts S2-00 Trans Nebulae
- 1 part KK Kandy Koncentrates
- 1/2 part S2-FX Effect Pac
- After you have assembled Kandy Basecoat mixture, Reduce **50%** with RU Series Reducers RU310, RU311, RU312, RU313 (2 parts Kandy Basecoat mixture to 1 part RU Series Reducer, or 2:1)



Online
Kwik-Mix

California Rule (8 : 1 : 1/2 : 50%)

- 8 parts S2-00 Trans Nebulae
- 1 part KK Kandy Koncentrates
- 1/2 part S2-FX Effect Pac
- After you have assembled Kandy Basecoat mixture, Reduce **50%** with RU Series Reducers RU300 or RU301 (2 parts Kandy Basecoat mixture to 1 part RU Series Reducer, or 2:1)

MIXING RATIO - KUSTOM KREATOR BASECOAT

Create your own Kustom Kreator Kandy Basecoat Colors. All Shimrin2® components are intermixable. Combine multiple Karrier Bases, FX Effect Pacs, Kandy Koncentrates (KK), Flakes (F), Dry Pearls (DP), and more.



Combine other Karrier Base colors with S2-00 to create personalized color trends. Tint Kandy Koncentrates with other Kandy Koncentrates, mix several S2-FX pacs together. Once complete, throw a few pinches of flake or dry pearls into the mix for that extra bling!

We recommend that you stay within the boundaries below.

- 8 parts S2-00 Trans Nebulae or combination of Karrier Bases
- 1 part KK-Kandy Koncentrate or combination of KK's
- 1/2 part S2-FX Effect Pac or combination of FX Effect Pacs
- After you have assembled Kustom Kreator Kandy Basecoat mixture, Reduce **50%** with RU Series Reducers - RU-300 or RU301 for California Rule Compliant, or RU310, RU311, RU312, or RU313 for National Rule Compliant (**2 parts Kustom Kreator Kandy Basecoat mixture to 1 part RU series reducer – 2:1**)

GUN SET UP

- HVLG Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Apply 3 to 4 medium coats of Shimrin2® Kandy Basecoat with a 75% pattern overlap. Allow each coat to flash dull (Typically 5 to 15 minutes) between coats. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. If you intend to do artwork over the Shimrin2® Kandy Basecoat, we suggest you allow the basecoat to flash 15 minutes then apply 2 medium coats of S2-SG100 Intercoat (see tech sheet on S2-SG100) to protect against tape tracking and overspray under the masking tape, etc.



DRY TIME

Allow to flash from 30 minutes up to 4 hours maximum prior to applying klear. House of Kolor USC01 Urethane Show Klear is recommended for maximum durability and protection of your custom paint project. House of Kolor Klears have 3 times the UV blocking capability of regular automotive clear. Do not Intermix other manufacturers' products with House of Kolor.



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA

	National Rule	California Rule
Coatings Category	Color Coating	Color Coating
Actual VOC Ready to Spray	2.87 lbs./gal. (344 g/L)	0.7 lbs./gal. (84 g/L)
Regulatory VOC Ready to Spray less exempt solvents	4.94 lbs./gal. (587 g/L)	2.44 lbs./gal. (292 g/L)
HAPS Ready to Spray	14.49 lbs./gal. (1736 g/L solid)	0.65 lbs./gal. (78 g/L solid)
Total % Solids by Volume (Ready to Spray)	10	10
Wt % Volatiles (Ready to Spray)	88	88
Wt % Exempt Compounds (Ready to Spray)	55	85.4





HOUSE of KOLOR
SHIMRIN2®

SHIMRIN2®
KANDY BASECOAT (KBC) SYSTEM



	National Rule	California Rule
Wt % Water (Ready to Spray)	0.0	0.0
Viscosity (Ready to Spray)		
#2 Signature Zahn @ 77°F	17.8 seconds	17.8 seconds
DIN 4 @ 77°F	16.1 seconds	16.1 seconds
Recommended Dry Film Build per Coat	1 mil	1 mil
Sq. Ft. Coverage/gal @ 1 mil	160.4 sq. ft./gal. @ 1 mil	160.4 sq. ft./gal. @ 1 mil

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

UKK01 Urethane Kandy Karrier takes House of Kolor into the 21st century with state of the art polymer technology to produce a solvent based custom paint system that is VOC compliant coast to coast. UKK01 can be applied as a medium solids Kandy (34% solids) or as a low solids Kandy (29% solids). Simply reduce and catalyze the UKK01 and then add 2 to 4 ounces of any of House of Kolor's KK Kandy Concentrates to a ready to spray quart of UKK01 Urethane Kandy Karrier to produce the same vibrant Kandy Kolors as our current UK Kandy's.

IMPORTANT NOTES

- We have designed specific Catalysts and Reducers to work with each of our urethane products. It is extremely important that you DO NOT attempt to use KU100, KU150 or KU151 in the UKK01 product, it will not work. ONLY USE KU152 CATALYST.
- KU152 is moisture sensitive and will not keep for long periods once opened. Keep the container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for ease of reopening.
- UKK01 Urethane Kandy Karrier is new technology and its mixing ratio is different from all of our other Urethane Kandy's and Klears. Please be mindful of this. DO NOT OVER CATALYZE. (4 parts UKK01, 1 part KU152 catalyst, 1 or 2 parts RU reducer).
- Over Spray from any catalyzed products may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.



SUBSTRATE

- All House of Kolor Shimrin2® and Shimrin® Base Coats and Klears. (**NOTE:** Please refer to individual product tech sheets for proper system applications)
- Properly cured and prepared OEM finishes



PREPARATION

Please be aware that Shimrin / Shimrin2® bases, Kandy's and Klears can be susceptible to staining or bleeding from polyester body fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD3000 DTS Foundation Surfacers Sealer, or KP Series.



SANDING THE SUBSTRATE

- All House of Kolor Klear Coats
- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 600P to 800P grit (CAMI grade = 400 to 500 grit)
- Scuff Pad

NOTE: DO NOT Sand directly on Shimrin® Base Coats. Sanding pearls and metallics will damage them causing darkening of the pearls and metallics. If you find a need to sand, apply 2 coats of S2-SG100 Intercoat over the base coat to protect them.

- OEM Finishes
- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 600P to 800P grit (CAMI grade = 400 to 500 grit)
- Scuff Pad



COMPONENTS

- UKK01 - Urethane Kandy Karrier
- KU152 - Kosmic Catalyst
- KK - Kandy Concentrates
- RU310 - Fast Reducer 65°F to 75°F
- RU311 - Medium Reducer 75°F to 85°F
- RU312 - Slow Reducer 85°F to 95°F
- RU313 - Very Slow Reducer 95°F to 100+°F
- RU300 - LV Cool Weather Reducer 70°F to 85°F
- RU301 - LV Warm Weather Reducer 85 to 100+°F
- AX02 - Kosmic Kicker (Optional)
- USC01 - Kosmic Urethane Show Klear



MIXING RATIO

For Low Solids Kandy (National Rule) 3.89 lbs./gal. (467 g/L) - 4:1:2 by volume

- 4 parts UKK01 Urethane Kandy Karrier
- 1 part KU152 Catalyst
- 2 parts RU Reducer
- Add KK Concentrates to desired strength (2-4 oz. per ready to spray quart of UKK01 is recommended)

For Medium Solids Kandy (National Rule) 3.12 lbs./gal. (374 g/L) - 4:1:1 by volume

- 4 parts UKK01 Urethane Kandy Karrier
- 1 part KU152 Catalyst
- 1 part RU Reducer
- Add KK Concentrates to desired strength (2-4 oz. per ready to spray quart of UKK01 is recommended)

For Low Solids Kandy (California Rule) 2.08 lbs./gal. (249 g/L) - 4:1:2 by volume

- 4 parts UKK01 Urethane Kandy Karrier
- 1 part KU152 Catalyst
- 2 parts RU300 or RU301 LV Reducer
- Add KK Concentrates to desired strength (2-4 oz. per ready to spray quart of UKK01 is recommended)



MIXING RATIO (Continued)

For Medium Solids Kandy (California Rule) 1.98 lbs./gal. (238 g/L) - 4:1:1 by volume

- 4 parts UKK01 Urethane Kandy Karrier
- 1 part KU152 Catalyst
- 1 part RU300 or RU301 LV Reducer
- Add KK Koncentrates to desired strength (2-4 oz. per ready to spray quart of UKK01 is recommended)

Optional: AX02 Kosmic Kicker accelerator may be added to decrease dry times in production environments. Add up to 5% AX02 to ready to spray UKK01 mixture.

Pot Life: 90 minutes depending on shop conditions. The addition of AX02 will shorten pot life to 60 minutes approx.

NOTE: Blending Solvents - never combine fast and slow solvents. In cool weather, combine RU300 with RU310 or RU311. In hot weather, combine RU301 with RU312 or RU313.

GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.2 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not recommended

APPLICATION

Start with low solid mixture. Apply 1 medium coat with a 75% pattern overlap and allow to flash 10 - 15 minutes then apply 2 more coats at a 75% pattern overlap as medium wet coats. Finish with Medium solid mixture. The final coats should be sprayed at a 50% pattern overlap as medium wet coats. (for a total of 4 to 6 coats) allowing to flash 10 - 20 minutes. Shop conditions, air flow, and reducer used will vary flash times. A good rule of thumb is to monitor the finish, allow each coat to go out of string before applying the next coat. (DO NOT rush your recoat time between coats. You could experience solvent popping.) All Kandy finishes must be klear coated. After 20 to 30 minutes begin applying 2 to 3 coats of UCS01 Urethane Show Klear for maximum UV protection (Always refer to the appropriate tech sheets on the top coat klear you intend using).

NOTE: lighter colored basecoats require maximum Kandy coats (6 coats).

KANDY APPLICATION TECHNIQUES

The application of "Kandy Type" finishes are among the most demanding of all finishes applied. Great attention must be paid in spray gun settings, number of coats and basic spray gun techniques. The following steps, when observed, provide consistent results.

Setting up the Spray Gun

- Know the equipment
- Check spray gun pattern, it must be consistent. (See Diagram One)
- Turn fluid knob in, to restrict trigger pull and reduce amount of Kandy delivered. This must be done for the first two to three coats to avoid streaking. A 75% pattern overlap is mandatory.

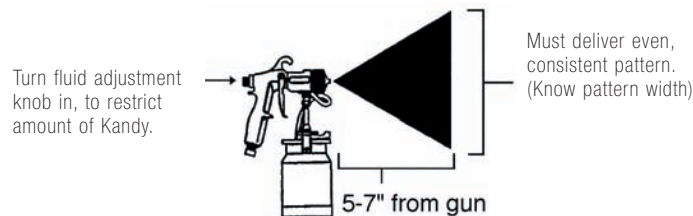


Diagram One

Application - The First 2 to 3 Coats

- Apply Kandy with recommended pattern overlap. (See Diagram Two)
- Spray gun should be 4 to 6 inches from surface.
- Do not apply Kandy panel to panel, spray entire length of object.
- Spray in straight lines, do not follow body lines. (See Diagram Three)

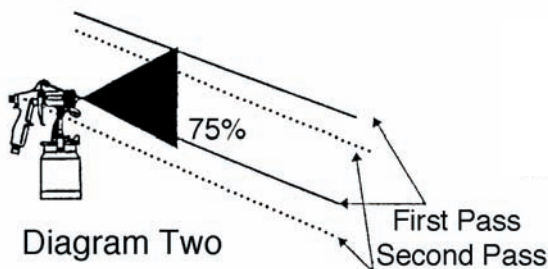


Diagram Two

Spray in straight lines



Diagram Three





APPLICATION (Continued)

Application - Final Coats

- Adjust fluid knob for a larger pattern 5-7" apply additional 2 to 3 coats with 50% overlap.
- Allow each coat to go out of tack before applying the next coat.
- Apply 2 to 3 coats of USC01 Urethane Show Klear, or other Kosmic Klears. Allow final coat of Kandy to go out of tack (20 to 30 minutes) then apply 2-3 coats of USC01 Urethane Show Klear or other House of Kolor Kosmic Klears.



DRY TIME

- Air dry at 70°F = 24 hours
- Air dry at 70°F with AX02 added at 5% of mix = 4 - 6 hours
- Force dry at 140°F = Allow the finish to flash 30 minutes, bake time should be 1 hour with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, and flash time between coats, etc., it is not unusual for the finish to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.



TECHNICAL DATA

	VOC (National Rule)	VOC (National Rule)	VOC (California Rule)	VOC (California Rule)
Coatings Category	Component	Component	Component	Component
Mixing Ratio	4-1-1	4-1-2	4-1-1	4-1-2
Packaged Density	9.46 lbs./gal. (1135 g/L)	9.46 lbs./gal. (1135 g/L)	9.46 lbs./gal. (1135 g/L)	9.46 lbs./gal. (1135 g/L)
Packaged VOC	2.36 lbs./gal. (283 g/L)	2.36 lbs./gal. (283 g/L)	2.36 lbs./gal. (283 g/L)	2.36 lbs./gal. (283 g/L)
Actual VOC Ready To Spray less exempt solvents	2.33 lbs./gal. (280 g/L)	3.06 lbs./gal. (367 g/L)	1.26 lbs./gal. (151 g/L)	1.21 lbs./gal. (145 g/L)
Regulatory VOC Ready To Spray less exempt solvents	3.12 lbs./gal. (374 g/L)	3.89 lbs./gal. (467 g/L)	2.08 lbs./gal. (249 g/L)	2.25 lbs./gal. (270 g/L)
Total HAPS (lb HAPS/Solid Gal Packaged)	0.04 lbs./gal. (4.8 g/L)	0.04 lbs./gal. (4.8 g/L)	0.04 lbs./gal. (4.8 g/L)	0.04 lbs./gal. (4.8 g/L)
HAPS Ready To Spray	2.03 lbs./gal. (244 g/L)	4.03 lbs./gal. (484 g/L)	0.08 lbs./gal. (9.6 g/L)	0.13 lbs./gal. (15.6 g/L)
Total % Solids by Volume Ready To Spray	33.78 %	28.94 %	33.78 %	28.96 %
Weight % Volatiles Ready To Spray	65.43 %	69.51 %	67.24 %	72.22%
Weight % Exempt compounds Ready To Spray	40.06 %	35.33 %	55.11 %	61.27 %
Weight % Water	0 %	0 %	0 %	0 %
Viscosity Ready to Spray				
#2 Signature Zahn @ 77 Degrees	12 – 15 Seconds	11 – 14 Seconds	12 – 15 Seconds	11 – 14 Seconds
DIN 4 @ 77 Degrees	<13 Seconds	<13 Seconds	<13 Seconds	<13 Seconds
Recommended Dry Film Build Per Coat				
Sq. Ft. Coverage/Gal at 1 mil.	542 Sq. Ft.	465 Sq. Ft.	542 Sq. Ft.	465 Sq. Ft.

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

S2-SG100 Intercoat is an important tool for the custom painter. It is designed to be applied over a given base color, prior to taped art work or air brush art. This allows for easy removal of mis-tapes or air brush errors without damage to base color. We recommend KC20 as the only clean up solvent. The intercoat is also applied over art work to preserve blending and fogging of various colors before applying kandy or klear topcoats. S2-SG100 is a safety layer, allowing you to pause and continue your project later. S2-SG100 is not a build up klear or a top coat klear. Limit applied coats to 4, however, if used as a carrier for base coat kandy's. Used as a carrier for pearls or flakes when reduction from standard 2:1 goes to 1:1, more coats are acceptable. S2-SG100 is also used to reduce strength of base coats for blending colors or for checking touch ups before top coat klears are applied. Considered a must over Marblizer® before kandy or klear to guarantee adhesion. S2-SG100 Intercoat, as you can see, is an important workhorse for the painter!

S2-SG100 is coast to coast VOC compliant, including California.

Important note: Do not use S2-SG100 as a top coat klear! Do not exceed 4 coats, only 3-4 coats with sufficient flash between coats is all that is required to fill tape-out lines.



SUBSTRATE

- All Shimrin® and Shimrin2® basecoats
- MB Marblizer® Series
- Properly cured top coat klears and OEM finishes (artwork only)



PREPARATION

Prior to applying S2-SG100 Intercoat, it is advised to lightly tack surface with a fully open tack cloth, or perform minor cleanup with KC20 Post Sanding Cleaner.

Important note: Please be aware that Shimrin® / Shimrin2® bases, Kandy's and Klears can be susceptible to staining or bleeding from polyester body fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD3000 Series or KP Series Primers. It is important to maintain at least a 2 dry mil film thickness of KD3000 Series DTS Foundation Surfacers Sealer or, KP series over all fillers and putties.



COMPONENTS

- S2-SG100 - Intercoat
- RU310 – Fast Reducer 65°F to 75°F
- RU311 – Medium Reducer 75°F to 85°F
- RU312 – Slow Reducer 85°F to 95°F
- RU313 – Very Slow Reducer 95°F to 100+°F
- RU300 - LV Cool Weather Reducer 70°F to 85°F
- RU301 - LV Warm Weather Reducer 85 to 100+°F



OPTIONAL COMPONENTS

- Dry Pearls (DP)
- Flake (F)
- Kandy Koncentrates (KK)

Important note: S2-00 Trans Nebulae FX Karrier Basecoat is highly recommended for use as a karrier base for Dry Pearls (DP), Flake (F). S2-00 contains special resins that greatly improve orientation and control.



MIXING RATIO

National Rule 2:1 by volume

- 2 parts Shimrin2® S2-SG100 Intercoat
- 1 part RU Reducer (RU310, RU311, RU312, or RU313)

California Rule 2:1 by volume

- 2 parts Shimrin2® S2-SG100 Intercoat
- 1 part RU LV Reducer (RU300 or RU301)

NOTE: Airbrush Application - reduce to desired viscosity or strength of added effects (for all mixing ratios)

Important note: Maximum recommended over reduction is 1 part S2-SG100 to 1 part reducer. This ratio is used when Kandy Koncentrates (KK), Pearls (DP), and Flake (F) are mixed with S2-SG100.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Follow gun manufacturer's recommendations



APPLICATION

Apply 1 to 2 medium coats of Shimrin2® S2-SG100 Intercoat with a 50% pattern overlap. Allow each coat to flash dull (Typically 5 to 15 minutes) between coats. Additional coats may be applied if build is required to fill tape-out lines. We suggest you allow the Intercoat to flash 30-60 minutes before doing tape outs, etc over the S2-SG100 product.



FINISH SANDING

Typically, S2-SG100 does not require sanding or scuffing as long as it hasn't sat more than 4 hours prior to top coating. In the event it will have to sit beyond 4 hours such as when performing artwork, it should be sanded. The S2-SG100 can be sanded after 1 hour dry time. Recommended grit is 500 wet or dry. You can also use a gray scuff pad..





DRY TIME

Allow to flash from 30 minutes up to a max. 4 hours before top coating. After 4 hours, wet sand with 500 and re-spray S2-SG100.



KLEAR COATING

DO NOT USE S2-SG100 AS A TOPCOAT KLEAR. S2-SG100 must be top coated with USC01 Urethane Show Klear, or any House of Kolor Kosmic Klears.

CLEAN UP

Clean equipment thoroughly with lacquer thinner, acetone, or urethane reducer (check local regulations).



KUSTOM TECH TIPS

TOUCH UP & BLEND - S2-SG100 Intercoat may also be used to blend Shimrin2® and Shimrin® Pearl and Metallic Base Coats. Apply 1 medium coat of S2-SG100 beyond the blend point. Metallics will not darken as they normally would at the blend. S2-SG100 may also be added directly to Shimrin2® and Shimrin® Bases for undetectable blends on touch ups.

KANDYS - For maximum durability we recommend the new Shimrin2® UKK01 Kandy Karrier with KK Kandy Koncentrates. S2-SG100 Intercoat may be used to make low solid Kandys by mixing any of our Kandy Koncentrates (KK) with S2-SG100. Excellent when multiple Kandy tape outs are required under urethane topcoats. Perfect for small parts or graphics when speed is a factor. Reduce S2-SG100 1:1 with RU series reducer then add Kandy Koncentrate until desired color and strength is achieved. **See tech sheet for more information on using Kandy Koncentrates.**

PEARLS & FLAKE - Although S2-SG100 may be used to make Pearls, we recommend the use of S2-00 Trans Nebulae FX Karrier Basecoat for this application. **When using S2-SG100, mix 1:1 with RU series reducer then begin to add dry pearls or Flake until desired concentration is achieved.** Do not add too much pearl or flake as clouding, mottling, streaking and bunching from too much pearl can occur. Pearl and Flake platelets must have room to sparkle. Overcrowding reduces their effect and increases the chance of mottling and streaking.

TECHNICAL DATA



	National Rule	California Rule
Coatings Category	Component	Component
Packaged Density	8.91 lbs./gal. (1069.2 g/L)	8.91 lbs./gal. (1069.2 g/L)
Packaged VOC	2.32 lbs./gal. (278 g/L)	2.32 lbs./gal. (278 g/L)
Actual VOC RTS	2.91 lbs./gal. (349.2 g/L)	0.75 lbs./gal. (90 g/L)
Regulatory VOC RTS less exempt solvents	5.55 lbs./gal. (666.11 g/L)	3.23 lbs./gal. (387 g/L)
Total HAPS (lb. HAPS/Solid Gal.) Packaged	0.015 lbs./gal. (1.8 g/L) solid	0.015 lbs./gal. (1.8 g/L) solid
(HAPS) Ready to Spray	10.17 lbs./gal. (1220 g/L) solid	0.25 lbs./gal. (30 g/L) solid
Total % Solids by volume (RTS)	13.31%	13.31%
Weight % Volatiles (RTS)	84.79%	86.54%
Weight % exempt compounds (RTS)	50.17%	81.60%
Weight % water (RTS)	0%	0%
Viscosity (Ready To Spray)		
#2 Signature Zahn @ 77°F	18.4 seconds	18.4 seconds
DIN 4 @ 77°F	17.2 seconds	17.2 seconds
Recommended Dry Film Build per Coat	0.5 mil	0.5 mil
Sq. Ft. Coverage/gal @ 1 mil	213.5 sq ft./gal @ 1 mil	213.5 sq ft./gal @ 1 mil

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

Simply stated, USC01 Kosmic Urethane Show Klear is the finest Klear House of Kolor has ever produced. Using state of the art polymer technology, we have developed a klear with excellent chemical, fuel, and water resistance, as well as the highest UV protection in the industry. As with all House of Kolor Klear products USC01 has three times the UV blocking capability when compared to standard automotive clear products. This is especially important when finishing Kandy's, Basecoats, and specialty products. USC01 is a medium solids Klear offering users excellent flow out, gloss, D.O.I. (Distinctness of Image) and sprays at over 40% volume of solids. USC01 can be used on all size vehicles from large trucks to compact cars, resulting in the show-ready finish that House of Kolor users crave. Cut, Buff, and Polishing has never been easier or faster. USC01 Kosmic Urethane Show Klear is the ideal klear coat for you and your pursuit of excellence.

USC01 Kosmic Show Klear meets all VOC rules and regulations, Coast to Coast, including California.

IMPORTANT NOTES

ONLY USE KU152 CATALYST WITH USC01 KLEAR.

- KU152 is moisture sensitive and will not keep for long periods once opened. Keep the container tightly sealed. Clean the catalyst containers pour spout by wiping the threads with reducer for ease of reopening.
- USC01 Kosmic Show Klear is new technology and it's mixing ratio is different from all of our other klears. Please be mindful of this. DO NOT OVER CATALYZE. (3 parts Klear, 1 part KU152 catalyst, 1 part RU reducer)
- Over Spray from any catalyzed products may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.



SUBSTRATE

- All House of Kolor Products
- **NOTE:** Please refer to individual product tech sheets for proper system applications
- Properly cured and prepared OEM finishes



PREPARATION

Please be aware that Shimrin® / Shimrin2® bases, Kandy's and Klears can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD3000 Series DTS Foundation Surfacer Sealers, or KP series.



SANDING SUBSTRATE

- UK's and Shimrin® / Shimrin2® Base Coats (See tech sheets on UK Kandy's and Shimrin® / Shimrin2® Base Coats)
- OEM Finishes
- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 600P to 800P grit (CAMI grade = 400 to 500 grit)
- Scuff Pad



COMPONENTS

- USC01 - Kosmic Urethane Show Klear
- KU152 - Kosmic Exempt Catalyst
- RU310 - Fast Reducer 65°F to 75°F
- RU311 - Medium Reducer 75°F to 85°F
- RU312 - Slow Reducer 85°F to 95°F
- RU313 - Very Slow Reducer 95°F to 100+°F
- RU300 - LV Cool Weather Reducer 70°F to 85°F
- RU301 - LV Warm Weather Reducer 85 to 100+°F
- AX02 - Kosmic Kicker (Optional)



MIXING RATIO

For 2.35 lbs./gal. (282 g/L) VOC (National Rule) - (3:1:1 by volume)

- **3** parts USC01 Klear
- **1** part KU152 Catalyst
- **1** part RU310, 311, 312, 313 Reducers

For 1.58 lbs./gal. (190 g/L) VOC (California Rule) - (3:1:1 by volume)

- **3** parts USC01 Klear
- **1** part KU152 Catalyst
- **½** part RU300 or RU301 LV Reducer
- **½** part RU310, 311, 312, 313 Reducer

For 1.10 lbs./gal. (132 g/L) VOC (Earthsense) - (3:1:1 by volume)

- **3** parts USC01 Klear
- **1** part KU152 Catalyst
- **1** part RU300 or RU301 Exempt Reducer

AX02 Kosmic Kicker - optional for all of the above mixing ratios - use only when finishing small parts or when productivity is required

- Add up to 5% AX02 to mixed and ready to spray USC01

USC01 MIXED KLEAR (RTS)	KOSMIC KICKER
8 oz.	0.4 oz.
16 oz.	0.8 oz.
32 oz.	1.6 oz.
64 oz.	3.2 oz.
96 oz.	4.8 oz.
128 oz.	6.4 oz.



Pot Life: 90 minutes depending on shop conditions. The addition of AX02 will shorten pot life to 60 minutes or less based on conditions.

NOTE: For extra flow out, add up to 5% of RU Reducer per mixed quart of klear



GUN SET UP

- HVLG Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Air Brush = Not recommended



APPLICATION

Apply 1 medium coat and allow to flash 10 - 15 minutes then 2 to 3 medium wet coats allowing to flash 10 - 20 minutes. Shop conditions, air flow, and reducer used will vary flash times. A good rule of thumb is to monitor the finish, allow each coat to go out of tack (no strings) before applying the next coat. USC01 is very forgiving and will not react with itself when waiting longer between coats. The minimum of out-of-tack to a maximum of 1 hour is recommended between coats for premium appearance and adhesion.

NOTE: When applying USC01 directly over UK Kandy's, the first coat should be applied medium wet.

DRY TIME

- Air dry at 70°F = 24 hours
- Air dry at 70°F with AX02 added at 5% of mix = 4 hours
- Force dry at 140°F = Allow the finish to flash 30 minutes, bake time should be 1 hour with 1 hour cool down.



NOTE: Based upon weather conditions, number of coats, solvent speed, and flash time between coats, etc., it is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.

FINISH SANDING

IF NOT FLOW COATING, GO TO STEP FINISHING AND POLISHING

After clear coats have been cured overnight (12-24 hours), color sand wet (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue doesn't bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 or warm water.

NOTE: Avoid touching the vehicle with your bare hands as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE CLEAR AND RUIN ALL YOU'VE DONE. Look for colored water, this will indicate you sanded through the clear.



RECOAT (FLOW COATING)

RE-MASKING THE VEHICLE AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using 2-4 ounces of extra RU reducer per mixed quart of clear. The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1 to 2 wet coats. Allow flash time between coats.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles.

FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- In a 70°F shop, allow 4-6 hours if using AX02. Buffing within 24 hours is recommended when using AX02.
- **See tech sheet for information on Polishing & Finishing**

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA

Coatings Category	Clear Coat					
	2.35 lbs./gal. (282 g/L) VOC (National Rule)		2.1 lbs./gal. (252 g/L) VOC (California Rule)		1.10 lbs./gal. (132 g/L) VOC (EarthSense)	
	RU Reducers	Using AX02 @ 5%	RU Exempt Reducers	Using AX02 @ 5%	RU Exempt Reducers	Using AX02 @ 5%
Packaged Density	9.79 lbs./gal. (1175 g/L)	--	9.79 lbs./gal. (1175 g/L)	--	9.79 lbs./gal. (1175 g/L)	--
Packaged VOC	0.75 lbs./gal. (90 g/L)	--	0.75 lbs./gal. (90 g/L)	--	0.75 lbs./gal. (90 g/L)	--
Actual VOC RTS less exempt solvents	1.78 lbs./gal. (214 g/L)	1.76 lbs./gal. (211 g/L)	1.14 lbs./gal. (137 g/L)	1.33 lbs./gal. (159 g/L)	0.49 lbs./gal. (59 g/L)	0.68 lbs./gal. (82 g/L)
Regulatory VOC RTS less exempt solvents	2.35 lbs./gal. (282 g/L)	2.32 lbs./gal. (278 g/L)	1.69 lbs./gal. (203 g/L)	1.88 lbs./gal. (226 g/L)	0.84 lbs./gal. (101 g/L)	1.10 lbs./gal. (132 g/L)
Total HAPS (g HAPS/Solid L) Packaged	0.04 lbs./gal. (4.8 g/L)	--	0.04 lbs./gal. (4.8 g/L)	--	0.04 lbs./gal. (4.8 g/L)	--
(HAPS) Ready to Spray	2.03 lbs./gal. (244 g/L)	1.7 lbs./gal. (204 g/L)	1.06 lbs./gal. (127 g/L)	1.05 lbs./gal. (126 g/L)	0.08 lbs./gal. (9.6 g/L)	0.07 lbs./gal. (8.4 g/L)
Total % Solids by volume (RTS)	40.54%		40.54%		40.54%	
Weight % Volatiles (RTS)	59.2%	59.09%	60.58%	60.05%	61.87%	61.37%
Weight % exempt compounds (RTS)	40.14%	40.21%	48.85%	46.21%	57.0%	54.54%
Weight % water (RTS)	0%	0%	0%	0%	0%	0%





TECHNICAL DATA (Continued)

Viscosity (Ready to Spray)			
#2 Signature Zahn @ 77 degrees	12 to 16 seconds	12 to 16 seconds	12 to 16 seconds
DIN 4 @ 77 degrees	12 to 16 seconds	12 to 16 seconds	12 to 16 seconds
Recommended dry film build per coat	1 mil	1 mil	1 mil
Sq. Ft. coverage/gal. at 1 mil	650.3 Sq. Ft.	650.3 Sq. Ft.	650.3 Sq. Ft.

HEATH AND SAFETY

IMPORTANT: The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

AX02 Kosmic Kicker is an accelerator for all House of Kolor Urethane products. AX02 can be used to reduce dry times on small parts that need to be handled sooner to increase production. A good example of this products usefulness would be for a motorcycle project where the coats of Kandy and Klear could be accelerated for quicker sanding and addition of artwork later that day. AX02 is not a cure all for a cold shop and should not be used on larger projects such as a complete car.

IMPORTANT NOTES

- AX02 will shorten all working times including pot life, flash time, recoat and through cure.



COMPONENTS

- AX02 - Kosmic Kicker
- USC01 - Kosmic Urethane Show Klear
- UKK01 - Urethane Kandy Karrier
- UC35 - Kosmic Acrylic Urethane Klear
- UFC35 - Kosmic Urethane Flo Klear
- UK - Kandys
- UB/UFB - Kosmic Kolor Urethanes
- USG100 - Barrier Klear



MIXING RATIO

MIXED URETHANE	KOSMIC KICKER
8 oz.	0.4 oz.
16 oz.	0.8 oz.
32 oz.	1.6 oz.
64 oz.	3.2 oz.
96 oz.	4.8 oz.
128 oz.	6.4 oz.



Pot Life: The addition of AX02 will shorten pot life to 60 minutes approx.



APPLICATION

Shop conditions, air flow, and reducer used will vary flash times. A good rule of thumb is to monitor the finish, allow each coat to go out of string before applying the next coat. (DO NOT rush your recoat time between coats. You could experience solvent popping.)



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA

Coatings Category	Component
Packaged Density	6.89 lbs./gal. (827 g/L)
Packaged VOC	6.79 lbs./gal. (814 g/L)
Total HAPS (lb. HAPS/Solid Gal.) Packaged	0 lbs./gal. (0 g/L solid)
Total % Solids by Volume	0.5 - 1.5%
Weight % Volatiles	98 - 99
Weight % exempt compounds	98 - 99
Weight % water	0%

HEATH AND SAFETY

IMPORTANT: The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

KP2CF CHROMATE FREE KWIKURE EPOXY PRIMER



GENERAL INFORMATION

KP2CF is a hi-solids, activated, Chromate Free Epoxy Sandable Primer. KP2CF primer may be applied to the existing OEM finish, bare steel, aluminum, fiberglass, and galvanized surfaces. Its tenacious adhesion, hi-build, excellent durability, water and corrosion resistance, and ease of sanding make it a logical choice for the basis of a long lasting paint job. KP2CF Epoxy Primer:

- resists cracking for years and years
- cures for sanding and finishing in 12-24 hours at 70°F.
- prevents plastic filler staining or bleed through
- will not stain, shrink, or swell from sand scratches

KP2CF Epoxy Primer is the first step to a great long lasting custom finish.



1. SUBSTRATE

- OEM finish
- Body fillers
- Bare steel
- Bare aluminum
- Bare fiberglass
- Galvanized surfaces



2. PREPARATION

Read "TECH PREP" thoroughly before you begin painting. Surface to be primed should be free of wax, grease, rust, etc. Clean with KC10 prior to sanding.

Do not apply KP2CF over uncatalyzed primers. KP2CF may be applied over properly prepared OEM factory primers and finishes, but for maximum adhesion and corrosion protection it is best to apply KP2CF directly to the bare substrate. Ko-Seal® II may be applied over properly prepared previously painted surfaces. **See Ko-Seal® II Tech Sheet for application information.**

NOTE: PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR BARE METAL AND OLD FINISH SANDING.

NOTE: DO NOT USE ANY ACID BASE PRODUCTS SUCH AS SELF ETCHING PRIMER, ETC. UNDER THE KP2CF PRIMER. THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.

NOTE: IF YOU FIND IT NECESSARY TO USE A METAL CONDITIONER TO REMOVE RUST, ETC., BE SURE TO THOROUGHLY CLEAN AND NEUTRALIZE THE TREATED AREA FOLLOWING THE CONDITIONER MANUFACTURERS RECOMMENDATIONS, USING OUR KC20 POST SANDING CLEANER WITH A MAROON SCUFF PAD TO INSURE ALL ACID RESIDUE HAS BEEN REMOVED BEFORE PRIMING. IF NOT, THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.



3. SANDING

Stripping the old finish

- Minimum 80P grit DA sandpaper



Bare metal

- Minimum 80P grit DA sandpaper

Body fillers

- Minimum 40P grit UNDER the areas being filled
- 80P grit over the body filler

OEM Finish

- 80P to 180P grit DA Sandpaper



4. COMPONENTS

- KP2CF part A (Yellow Primer)
- KP2CF part B (Blue Activator)
- RU310 (Fast) or RU311 (Medium) Reducer



5. MIXING KP2CF EPOXY PRIMER

- 1 part KP2CFA (Yellow)
- 1 part KP2CFB (Blue)
- Up to 10% RU Reducer (optional)

KP2CF Epoxy Primer is a two part system. Aggressively mix KP2CF Part A Primer and KP2CF Part B Activator thoroughly before mixing the two parts together. Add up to 10% RU reducer for improved sprayability and flow out. A 10% reduction will give approximately 1 mil dry film thickness per coat. Always measure, do not guess.

Stir mixed components well to ensure a thorough cure, use a paint shaker for best results. No incubation time is needed. Pot life is 3 hours at 70°F. Shop conditions can vary pot life.



6. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.5 to 1.8
(Depending on the size of object being painted)
- Trigger Pull = Full
- Air Brush = Not Recommended

NOTE: Most gun manufacturers make inexpensive primer guns that can be dedicated for primer surfacer use only.



7. APPLYING KP2CF EPOXY PRIMER

Strain mixed primer into gun. Apply 2-3 wet coats with 50% pattern overlap. Apply 2 extra coats over body work. Allow flash time between coats (flashes dull).

KP2CF FLASH TEST - - Allow Primer to dry dull before next coat is applied. Usually 5-10 minutes.

NOTE: KP2CF PREVENTS BLEED THROUGH OF STAINS IF MILLAGE IS 2 MILS (AFTER SANDING) OR ABOVE. APPROXIMATE BUILD IS 1 MIL PER COAT WITH 10% REDUCTION USING A PRIMER GUN.

8. GUIDE COAT

Prior to sanding, apply a Guide Coat. During the sanding process, the contrasting color of the guide coat will remain in pits and scratches and become a guide telling you how much sanding is required to smooth the KP2CF. Remove the guide coat and a few more sanding strokes and move on. Be careful so you don't expose any body filler. If the primer is less than 2 mils after sanding, bleed through of filler is possible.



9. SANDING

- Initial Block Sanding (optional, see info below)
 - 100P to 150P grit dry sandpaper
- Finish Sanding
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Tight Areas (door jams, etc.) = Maroon scuff pad

Block sand wet or dry. IF BODY FILLER IS EXPOSED, RE-PRIME WITH KP2CF TO PREVENT STAINING. May dry sand KP2CF with 100 or 150 grit, then re-prime with 2 or 3 more coats of KP2CF. KP2CF may also be wet sanded. Then simply seal coat with our Ko-Seal® II and apply topcoats.

PLEASE REFER TO SANDING GRIT RECOMMENDATIONS.

NOTE: Do not use alkyd or synthetic sealers or primers with House of Kolor® products as lifting may occur.

NOTE: To prevent bleeding or discoloration of base coats caused by body fillers, at least 2 mils of primer must remain after sanding. (1 coat equals approximately 1 mil when sprayed with production equipment using 10% reduction, and a 50% pattern overlap).



10. DRY TIME

Allow dry time. We recommend 12-24 hours before sanding and finishing when 3 coats of KP2CF is used at 70°F. Longer dry times are needed if more than 3 coats are applied. KP2CF may also be force dried at 140°F for 45 minutes for faster sanding. After finish sanding, the vehicle is ready for Ko-Seal® II, followed by base coats and topcoats.



11. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

NOTE: KP2CF has tenacious adhesion and it is highly recommended the needle and fluid tip be removed and thoroughly cleaned. This will assure the gun will work properly when used the next time.



GENERAL INFORMATION

KD2000 Direct to Metal Epoxy Primer was formulated with a hybrid of epoxy and acrylic polymers, which provide excellent adhesion, good corrosion resistance, productive dry times, and ease of sanding. These primers emit very low amounts of Volatile Organic Compounds (VOCs), Hazardous Air Polluting Solvents (HAPS), and contain no isocyanates.

KD2000 may be applied to the existing OEM finish, bare steel, aluminum, fiberglass, and galvanized surfaces. Its tenacious adhesion, hi-build, excellent durability, and water and corrosion resistance make it a logical choice for the basis of a long lasting paint job. KD2000 Epoxy Primer:

- resists cracking for years and years
- cures for sanding and finishing in 3 hours at 70°F.
- prevents plastic filler staining or bleed through
- will not stain, shrink, or swell from sand scratches

KD2000 Direct to Metal Epoxy Primer is the first step to a great long lasting custom finish.



1. SUBSTRATE

- OEM finish
- Body fillers
- Bare steel
- Bare aluminum
- Bare fiberglass
- Galvanized surfaces



2. PREPARATION

Read "TECH PREP" thoroughly before you begin painting. Prepare vehicle using normal methods for acrylic lacquer or urethane. Surface to be primed should be free of wax, grease, rust, etc. Clean with KC10 prior to sanding. Do not apply KD2000 over uncatalyzed primers. KD2000 may be applied over properly prepared OEM factory primers and finishes, but for maximum adhesion and corrosion protection it is best to apply KD2000 directly to the bare substrate. Ko-Seal® II may be applied over properly prepared previously painted surfaces. **See Ko-Seal® II Tech Sheet for application information.**

NOTE: PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR BARE METAL AND OLD FINISH SANDING.

NOTE: DO NOT USE ANY ACID BASE PRODUCTS SUCH AS SELF ETCHING PRIMER, ETC. UNDER THE KD2000 PRIMER. THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.

NOTE: IF YOU FIND IT NECESSARY TO USE A METAL CONDITIONER TO REMOVE RUST, ETC., BE SURE TO THOROUGHLY CLEAN AND NEUTRALIZE THE TREATED AREA FOLLOWING THE CONDITIONER MANUFACTURERS RECOMMENDATIONS, THEN USING OUR KC20 POST SANDING CLEANER WITH A MAROON SCUFF PAD TO INSURE ALL ACID RESIDUE HAS BEEN REMOVED BEFORE PRIMING. IF NOT, THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.



3. SANDING

Striping the old finish

- Minimum 80P grit DA sandpaper



Bare metal

- Minimum 80P grit DA sandpaper

Body fillers

- Minimum 40P grit UNDER the areas being filled
- 80P grit over the body filler

OEM Finish

- 80P to 180P grit DA Sandpaper



4. COMPONENTS

- KD2000 (Primer)
- KDA2000 (Activator)
- RU310 (Fast), RU311 (Medium) Reducer, or RU300 Exempt Reducer



5. MIXING KD2000 EPOXY PRIMER

- 4 part KD2000 (Primer)
- 1 part KDA2000 (Activator)
- Up to 10% RU Reducer (optional)

KD2000 Epoxy Primer is a two part system. Aggressively mix KD2000 Primer thoroughly before mixing the two parts together. Add up to 10% RU reducer for improved sprayability and flow out. A 10% reduction will give approximately 1 mil dry film thickness per coat. Always measure, do not guess.

Stir mixed components well to ensure a thorough cure, use a paint shaker for best results. No incubation time is needed. Pot life is 2-3 hours at 70°F. Shop conditions can vary pot life.



6. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.5 to 1.8
(Depending on the size of object being painted)
- Trigger Pull = Full
- Air Brush = Not Recommended



7. APPLYING KD2000 EPOXY PRIMER

Strain mixed primer into gun. Apply 2-3 wet coats with 50% pattern overlap. Apply 2 extra coats over body work. Allow flash time between coats (flashes dull).

KD2000 FLASH TEST - - Allow Primer to dry dull before next coat is applied. Usually 5-10 minutes.

NOTE: KD2000 PREVENTS BLEED THROUGH OF STAINS IF MILLAGE IS 2 MILS AFTER SANDING OR ABOVE. APPROXIMATE BUILD IS 1 MIL PER COAT WITH 10% REDUCTION USING A PRIMER GUN.

8. GUIDE COAT

Prior to sanding, apply a Guide Coat. During the sanding process, the contrasting color of the guide coat will remain in pits and scratches and become a guide telling you how much sanding is required to smooth the KD2000. Remove the guide coat and a few more sanding strokes and move on. Be careful so you don't expose any body filler. If the primer is less than 2 mils after sanding, bleed through of filler is possible.



9. SANDING

- Initial Block Sanding (Optional, see info below)
 - 100P to 150P grit dry sandpaper
- Finish Sanding
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Tight Areas (door jams, etc.) = Maroon scuff pad

Block sand wet or dry. IF BODY FILLER IS EXPOSED, RE-PRIME WITH KD2000 TO PREVENT STAINING. May dry sand KD2000 with 100 or 150 grit, then re-prime with 2 or 3 more coats of KD2000. KD2000 may also be wet sanded. Then simply seal coat with our Ko-Seal® II and apply topcoats.

PLEASE REFER TO SANDING GRIT RECOMMENDATIONS.

NOTE: Do not use alkyd or synthetic sealers or primers with House of Kolor® products as lifting may occur.

NOTE: To prevent bleeding or discoloration of base coats caused by body fillers, at least 2 mils of primer must remain after sanding. (1 coat equals approximately 1 mil when sprayed with production equipment using 10% reduction).



10. DRY TIME

Allow dry time. We recommend 3-6 hours before sanding and finishing when 3 coats of KD2000 is used at 70°F. Longer dry times are needed if more than 3 coats are applied. KD2000 may also be force dried at 140°F for 45 minutes for faster sanding. After finish sanding, the vehicle is now ready for Ko-Seal® II, followed by base coats and topcoats.



11. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

KS KO-SEAL® II PRIMER SEALER

GENERAL INFORMATION

Ko-Seal® II is a two component acrylic urethane primer sealer. Ko-Seal® II has two series of products: one series meeting the VOC requirements for National Rule and one series meeting the VOC requirements for SCAQMD Rule 1151.



National Rule Compliant Products

VOC= 4.58 lbs./gal. 550 g/L
KS10 White Primer Sealer
KS11 Black Primer Sealer
KS12 Metallic Primer Sealer

SCAQMD Rule 1151 Compliant Products

VOC= 2.08 lbs./gal. 250 g/L
KS210 White Primer Sealer
KS211 Black Primer Sealer
KS212 Metallic Primer Sealer

NOTE: KO-SEAL® II CAN NOT BE APPLIED OVER BARE METAL SURFACES OF ANY KIND. KO-SEAL® II MUST BE APPLIED OVER SANDED AND CLEAN PRIMER OR PROPERLY PREPARED AND SANDED PREVIOUSLY PAINTED SURFACES FOR PROPER ADHESION.

NOTE: Ko-Seal® II may be used as a ground coat color for our Shimrin® bases. After Ko-Seal® II has dried for one hour, topcoat with Shimrin® bases per the appropriate tech sheet. Ko-Seal® II may be tinted up to 5% by volume with any KK Kandy concentrate to achieve hundreds of different color combinations.

Ko-Seal® II is a high quality sealer designed to:

- Act as a bond coat between primer and top coats.
- Act as a holdout agent to prevent topcoats from soaking into the primer and reducing gloss.
- Make the object to be painted an appropriate color for faster coverage of top coats.
- Can be applied over properly prepared and sanded previously painted OEM surfaces, KP-, or KD-Series House of Kolor® Primers for proper adhesion of topcoats.

Ko-Seal® II is a high quality acrylic urethane catalyzed primer sealer designed to be used with either our Kustom Kolor® Acrylic Lacquer or Kosmic Kolor® Urethane Enamel systems. Ko-Seal® II is an excellent ground coat for base coat application. Choose the appropriate color for the base coat system and color that is going to be applied. Ko-Seal® II (KS11 / KS211) black and (KS10 / KS210) white colors may be intermixed for various shades of gray, also KK Koncentrates can be added to both (KS10 / KS210) white and (KS12 / KS212) silver for a closer match to the base coat or top coat color.

See Ko-Seal® II Color Reference Chart for proper color selection.

1. SUBSTRATE

- OEM finish
- KP & KD Epoxy Primers



2. PREPARATION

Read "TECH PREP" thoroughly before you begin painting. Use only House of Kolor®'s KP or KD Epoxy Primers over bare metal substrates or metal substrates with body work. **See tech sheet for more information on KP and KD Epoxy Primers.**



3. SANDING THE SUBSTRATE

- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Tight Areas (door jams, etc.) = Maroon scuff pad



4. COMPONENTS

- KS Ko-Seal® II
- KU150 Catalyst
- RU310 (fast), RU311 (medium), RU300 (exempt) urethane reducer



5. MIXING KO-SEAL® II

- 4 parts Ko-Seal® II
- 1 part KU150 Catalyst
- 1 part RU- reducer



FOR KS10, KS11, and KS12:

Mix (by volume) 4 parts Ko-Seal® II to 1 part KU150 Exempt Catalyst, to 1 part Kosmic Reducer to remain at 4.58 VOC. Use a reducer best suited to your shop conditions. **See tech sheet for more information on reducers.** Mix well and strain into gun. Pot life 1 hour.

FOR KS210, KS211 and KS212:

Mix (by volume) 4 parts Ko-Seal® II to 1 part KU150 Exempt Catalyst, to 1 part RU300 VOC Exempt Reducer, to remain at 2.08 VOC. Substituting RU310, RU311 or RU312 will give a 3.5 VOC product. **See tech sheet for more information on reducers.** Mix well and strain into gun. Pot life 1 hour.

6. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not Recommended



7. APPLYING KO-SEAL® II

Strain the sealer into the paint gun. Gun distance while spraying should be approximately 5 to 6 inches.

Apply 1 or 2 medium wet coats with 50% pattern overlap. Walk long objects. Be sure of thorough coverage. Allow flash time between coats.

KO-SEAL® II FLASH TEST - ALLOW TO FLASH DULL BETWEEN COATS. USUALLY 5 TO 10 MINUTES.



8. DRY TIME

Allow to dry 1 hour but no longer than 2 hours. After 2 hours we recommend scuffing with a maroon scuff pad. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS.** (Dry time may vary with weather and shop conditions).

NOTE: If 4-6 hours dry time has elapsed, wet sand and reseal surface for positive adhesion of topcoats.



9. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



SEALER REFERENCE CHART

		RECOMMENDED SEALER		
BASECOAT SYSTEM	CODE	KS10 OR KS210 WHITE	KS11 OR KS211 BLACK	KS12 OR KS212 METALLIC
SHIMRIN® DESIGNER PEARLS	PBC30 THRU PBC68	•	•	
SHIMRIN® BLACK PEARLS	PBC100 THRU PBC107		•	
UNIVERSAL PEARLS	PC'S AND P'S	•	•	
SHIMRIN® GRAPHIC KOLORS	SG'S	•		
SHIMRIN® NEONS	NE'S	•		•
SHIMRIN® KANDY BASECOATS	KBC'S		•	•
SHIMRIN® GLAMOUR METALLICS	BC'S	•	•	•
SHIMRIN® FINE METALLICS	FBC'S	•	•	•
SHIMRIN® METALLIC BASES	MBC'S		•	•
SOLID COLORS	BC25 BLACK		•	
SOLID COLORS	BC26 WHITE	•		
SOLID COLORS	UB04 / UFB04 JET SET BLACK		•	
SOLID COLORS	UB05 / UFB05 BRITE WHITE	•		
SOLID COLORS	UFB06 KOSMOS RED	•		
KANDYS	UK'S AND KK'S			•
KAMELEON® KOLORS	KF'S		•	
MARBLIZER®	MB'S		•	
FLAKES	F'S / MF'S / UMFS		•	
KOSMIC LONG-GLO	KLGS	•		
DRY PEARLS	DR'S / DP'S	•	•	
ICE PEARLS	IP'S	•	•	•
KAMELEON® PEARLS	KPF'S		•	
KOSMIC PEARLS	KDP'S	•	•	
KAMELEON® OPALS	KOP'S	•		

NOTE: Sealers may be intermixed to create unique colors.

NOTE: Small amounts of KK Kandy Koncentrates can help tint the White and Metallic Silver Sealers to closely match the desired basecoat.

BC & FBC SHIMRIN® METALLIC COLOR BASES

GENERAL INFORMATION

Shimrin® Metallic Color Bases (BC & FBC) are universal base coats that may simply be cleared for a final finish, or used as a base coat for Kandys. Due to their unique chemistry make-up, they may be top coated with either acrylic lacquer or urethane enamel. Once a system is chosen (acrylic lacquer or urethane enamel) use only products within that system. Intermixing of these two systems, after the base coat, is not recommended. For example: If Shimrin® Base is top coated with an acrylic lacquer Kandy, it must also be cleared with an acrylic lacquer clear.



1. SUBSTRATE

- Ko-Seal® II
- SG100 Intercoat Clear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KP & KD epoxy primers.



3. GROUND COAT

- Sealer (Ko-Seal® II)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Ko-Seal® II Sealers are commonly used and recommended as the ground coat for BC and FBC Metallic Bases. Use Ko-Seal® II sealer for faster coverage of base coats. When using sealer, allow flash time. **See tech sheet for information on Ko-Seal® II application.**

NOTE: *Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.*



4. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100, Cured Top Coat Clears & OEM Finishes (artwork only)
- Dry Sandpaper = 280P to 320P grit
(CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit
(FEPA grade 600P to 800P grit)
- Maroon scuff pad



5. COMPONENTS

- BC, FBC Shimrin® base coat
- RU310 (fast), RU311 (medium) urethane reducer
- Air Brush application: RU311 (medium), RU312 (slow)



6. MIXING SHIMRIN® BASES (BC & FBC)

- 2 parts Shimrin® base coat
- 1 part RU series reducer
- Air Brush application: 1 part Shimrin® base, 1 part RU-reducer



Stir Shimrin® Base well. Reduce 50% (2 parts paint to 1 part reducer). Mix well and reduce only with RU310 or RU311 reducer, based on booth temperature. **IMPORTANT NOTE: No catalyst is used in Shimrin® bases.** REDUCE ONLY WITH OUR KOSMIC REDUCERS. Use the reducer best suited to your shop temperature. **See tech sheet for more information on RU reducers.** **Note:** *For Air Brush application reduce 100% (1 part paint to 1 part RU311 reducer).*

When blending, you may slightly over-reduce Shimrin® Bases or mix them with SG100 Intercoat Clear for undetectable blends.

NOTE: *Splitting or cracking is possible when using other companies' reducers or by using a reducer that is too slow for your shop conditions.*

7. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush: Follow gun manufacturer's recommendations



8. APPLYING SHIMRIN® BASES

After reducing, strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 2-3 **MEDIUM** coats with 50% pattern overlap. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. Again, **MEDIUM** coats work best. Allow flash time between coats.

NOTE: *DO NOT APPLY HEAVY WET COATS OF BC & FBC BASES AND EXPECT THEM TO FLOW; THIS WILL TYPICALLY RESULT IN WRINKLING AND SPLITTING. They behave very much like lacquer, so apply medium coats only and avoid heavy build. Do not dry spray or lack of adhesion is possible. Apply medium coats, 50% pattern overlap. Flash dull between coats.*

NOTE: *3 coats of Shimrin® BC or FBC Bases equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge.)*



9. DRY TIME

Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 4 hours). Topcoat within 4 hours or apply SG100 Intercoat Clear (see step 10).

SHIMRIN® FLASH TEST - ALL SHIMRIN® BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED.

Monitor closely for maximum merging of coats.



10. ARTWORK & INTERCOAT CLEAR (optional)

Shimrin® Bases, with their low solids, are an excellent choice for artwork paint jobs. DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, apply 1 or 2 medium coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT CLEAR.** **See tech sheet for more information on SG100 Intercoat Clear.**

NOTE: *DO NOT SAND SHIMRIN® METALLIC BASES DIRECTLY. Apply SG100 Intercoat Clear for base coat protection if sanding is required. If you directly sand the Shimrin® metallic, you must re-base. NOTE: SG100 Intercoat Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE SG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will remove base coats. Use KC20 Post Sanding Cleaner for cleanup.*

11. KANDY COAT (optional)

Shimrin® BC and FBC Bases may be Candied with either acrylic lacquer or urethane enamel. Remember if you Kandy with acrylic lacquer, you must also clear with acrylic lacquer. (If you Kandy with urethane enamel, you must also clear with urethane enamel). See appropriate tech sheets for Kandy application. For artwork, our Kandy Koncentrates may be mixed with SG100 Intercoat Clear for Kandy graphics. See KK & SG100 tech sheets for more information.

12. CLEAR COAT

ALL SHIMRIN® BC AND FBC BASES MUST BE CLEAR-COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

ADDITIONAL INFORMATION

Shimrin® BC and FBC Bases may be intermixed for hundreds of color combinations. BC and FBC Bases may also be mixed with other Shimrin®s, including the Designer Pearls, Neons, and Graphic Kolors. The possibilities are endless. Create your own one-of-a-kind custom finish.

Shimrin® Pearl and Metallic Bases may also be added, in small amounts (no more than 25%), directly to the Cosmic Kolor® Kandys to ease touch-ups or for additional creative effects. Simply catalyze and reduce by volume as usual.

13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).





GENERAL INFORMATION

Shimrin® MBC Metajuls™ Metallic Bases are our most brilliant metallic basecoats that feature exceptional sparkle and brightness. Metajuls™ are available in four unique colors and three flake particle sizes. Pale Gold, Platinum, and Black Diamond are excellent choices for Kandy finishes, while the Prism Effect produces an amazing rainbow effect. When used as a basecoat, MBC01 creates bright dazzling Kandy colors, while MBC03 can create dark rich Kandy colors. MBC02 is a medium color used to slightly darken Kandy colors. All three make Kandys with exceptional sparkle in sunlight. They may also be used for a final finish. Due to their unique chemistry make-up, they may be top coated with either acrylic lacquer or urethane enamel. Once a system is chosen (acrylic lacquer or urethane enamel) use only products within that system. Intermixing of these two systems, after the base coat, is not recommended. For example: If Shimrin® Base is top coated with an acrylic lacquer Kandy, it must also be cleared with an acrylic lacquer clear.

When ordering MBC Metajuls™ Metallic Bases, please use the following codes to specify the particle size and color:

Code	Description
MBC01FF	Fine Pale Gold
MBC02FF	Fine Platinum
MBC03FF	Fine Black Diamond

MBC01	Standard Pale Gold
MBC02	Standard Platinum
MBC03	Standard Black Diamond

Code	Description
MBC01CF	Coarse Pale Gold
MBC02CF	Coarse Platinum
MBC03CF	Coarse Black Diamond

MBC04	Prism Effect (Note: Prism Effect is lost when applied under kandies, but a unique halo effect is created that adds an illusion of depth)
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NOTE: MBC Standard and Coarse particle sizes are not recommended for Air Brush use.



1. SUBSTRATE

- Ko-Seal® II
- All Shimrin® Bases
- SG100 Intercoat Clear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct to Metal Epoxy Primer. **See tech sheets for more information on KP & KD primers.**



3. GROUND COAT

- Sealer (Ko-Seal® II)
- BC, FBC Shimrin® base coat

MBC's must have a proper Base to achieve their maximum effect. Our Ko-Seal® II's work extremely well as a base.

A: MBC01 Pale Gold will work over KS12 or KS212 Silver Sealer; however for the perfect base sealer: To 24 oz. of mixed KS12 add 1 oz. of KK14 Spanish Gold Koncentrate, also a mix of BC01 and BC02 will match the MBC01 for an excellent base.

B: MBC02 Platinum works over KS12 or KS212 but to closer match the Platinum, add some KS211 or KS11 Black Sealer. For a beautiful darker Kandy apply 3 coats of MBC02 over KS11 or BC25. Try this, apply KS12 or KS212, let dry one hour. Apply 1-2 coats SG100, let dry 30 minutes (or until dry). Then do art tapeouts, tutone or blend over sealer base using 1-2 medium coats of BC25 Black or any contrasting base color. Now apply 3 coats of MBC02 over both base colors. Allow dry time, lightly wipe with a white or grey scuff pad, air and tack. Then apply the Kandy kolor of your choice; way kool!

C: MBC03 Black Diamond; simply apply 3 coats over KS11 or KS211 Black Sealer, or BC25 Black will work also. Many other darker base colors also add creativity; try BC10 Pavo Purple as a base under MBC03 and follow with Kandy or simply clear.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout and gloss retention.



4. SANDING THE SUBSTRATE

- Refer to tech data sheet on Ko-Seal® II and SG100.



5. COMPONENTS

- MBC Metajuls™ base coat
- RU310 (fast), RU311 (medium) urethane reducer
- Air Brush application: RU311 (medium), RU312 (slow)



6. MIXING SHIMRIN® BASES (MBC METAJULS™)

- 2 parts MBC Metajuls™ base coat
- 1 part RU series reducer
- Air Brush application: 1 part MBC, 1 part RU-reducer

Stir Shimrin® Base well. Reduce 50% (2 parts paint to 1 part reducer). Mix well and reduce only with RU310 or RU311 reducer, based on booth temperature. **IMPORTANT NOTE: No catalyst is used in Shimrin® bases.** REDUCE ONLY WITH OUR KOSMIC REDUCERS. Use the reducer best suited to your shop temperature. **See tech sheet for more information on RU reducers.** **Note:** For Air Brush application reduce 100% (1 part paint to 1 part RU311 reducer)

When blending, you may slightly over-reduce Shimrin® Bases or mix them with SG100 Intercoat Clear for undetectable blends.

NOTE: Splitting or cracking is possible when using other companies' reducers or by using a reducer that is too slow for your shop conditions.



7. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle
 - Fine & Medium Metajuls™ = 1.3 to 1.5 (Depending on the size of object being painted)
 - Coarse Metajuls™ = 1.6 to 1.8 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush: Follow gun manufacturer's recommendations



8. APPLYING SHIMRIN® BASES (MBC METAJULS™)

After reducing, strain the paint into the paint gun. Use a coarse strainer or none at all. Strainers are not used with larger flake. Gun distance while spraying should be approximately 4-6 inches, depending on gun used and gun adjustments. Apply 3 **MEDIUM** coats with 75% pattern overlap. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. Again, **MEDIUM** coats work best. Allow flash time between coats.

SHIMRIN® FLASH TEST - ALL SHIMRIN® BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED. Monitor closely for maximum merging of coats.

NOTE: DO NOT APPLY HEAVY WET COATS OF MBC BASES AND EXPECT THEM TO FLOW. They behave very much like lacquer, so apply medium coats only and avoid heavy build. Do not dry spray or lack of adhesion is possible. Apply medium coats, 75% pattern overlap. Flash dull between coats.

NOTE: Splitting and cracking may occur when painting too fast without allowing proper dry time or by spraying on the base too wet and heavy.

NOTE: 3 coats of Shimrin® MBC Bases equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge.) Also true of Shimrin®s. This is the easiest flake to use ever.

9. DRY TIME

Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 4 hours). Topcoat within 4 hours or apply SG100 Intercoat Clear (see step 10).

SHIMRIN® FLASH TEST - ALL SHIMRIN® BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED. Monitor closely for maximum merging of coats.



NOTES

10. ARTWORK & INTERCOAT CLEAR (optional)

Shimrin® Bases, with their low solids, are an excellent choice for artwork paint jobs. DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, allow to dry, lightly wipe with a white or grey scuff pad to knock down standing flakes while blowing with air (**Except MBC04 Prism Effect, where flake particles could be damaged**). Apply 1 or 2 medium coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SCO1 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **NOTE: DO NOT SAND SHIMRIN® METALLIC BASES DIRECTLY. Apply SG100 Intercoat Clear for base coat protection if sanding is required. If you directly sand the Shimrin® metallic, you may put permanent scratches in the flake, a white or grey scuff pad will do no harm if wiped lightly. Wet or dry. NOTE: SG100 Intercoat Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE SG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will remove base coats. Use KC20 Post Sanding Cleaner for cleanup. As always, avoid touching finish with bare skin which may transfer oil.**

11. KANDY COAT (optional)

Shimrin® MBC Metajul™ Bases may be Candied with either acrylic lacquer or urethane enamel. Remember if you Kandy with acrylic lacquer, you must also clear with acrylic lacquer. (If you Kandy with urethane enamel, you must also clear with urethane enamel). See appropriate tech sheets for Kandy application.

This step produces awesome Kandy jobs. When viewed in the sunlight, the sparkle of these very unique metallics is outstanding. For artwork, our Kandy Concentrates may be mixed with SG100 Intercoat Clear for Kandy graphics. See KK & SG100 tech sheets for more information.

12. CLEAR COAT

ALL SHIMRIN® MBC METAJUL™ BASES MUST BE CLEAR-COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

ADDITIONAL INFORMATION

Shimrin® MBC Metajuls™ Bases may be intermixed for hundreds of color combinations. MBC Bases may also be mixed with other Shimrin®s, including the Designer Pearls, Neons, Graphic Kolors, and Kandy Koncentrates. The possibilities are endless. Create your own one-of-a-kind custom finish.

13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).





GENERAL INFORMATION

Shimrin® Designer Pearls (PBC) are universal base coats that may simply be cleared for a final finish, or used as a base coat for Kandys or other Pearls. Due to their unique chemistry make-up, they may be top coated with either acrylic lacquer or urethane enamel. Once a system is chosen (acrylic lacquer or urethane enamel) use only products within that system. Intermixing of these two systems, after the base coat, is not recommended. For example: If Shimrin® Pearl is top coated with an acrylic lacquer Kandy, it must also be cleared with an acrylic lacquer clear.



1. SUBSTRATE

- Ko-Seal® II
- SG100 Intercoat Clear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Shimrin® Pearl bases are susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



3. GROUND COAT

- Sealer (Ko-Seal® II)
 - Shimrin® Solid Color Bases (BC25, BC26, SG, NE)
- VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF PEARL BASE COAT. Use BC26, KS10 or KS210 as a ground coat for white or light colored pearls (as shown on our Kustom Coatings color card). The color of the ground coat will vary the final pearl color. This is an excellent place for creativity. You may also use any of our Kosmic Kolor® Shimrin® Bases, Graphic Kolors or Neons, for the ground coat. Follow label instructions. Allow flash time on each coat of ground color.

NOTE: House of Kolor® sealers may also be used as a ground coat.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.



4. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100, Cured Top Coat Clears & OEM Finishes (artwork only)
- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad



5. COMPONENTS

- PBC Shimrin® Designer Pearl base coat
- RU310 (fast), RU311 (medium) urethane reducer,
- Air Brush application: RU311 (medium) RU312 (slow)



6. MIXING SHIMRIN® DESIGNER PEARLS (PBC)

- 2 parts Shimrin® PBC Designer Pearl base coat
- 1 part RU- reducer
- Air Brush Application: 1 part Shimrin® base, 1 part RU-reducer

NOTE: All Shimrin® Designer Pearls can be mixed at 2 parts PBC to 1 part Reducer, but a 1 to 1 ratio is recommended for ease of control, especially with lighter shaded PBC's.

Stir Shimrin® Pearl well. Reduce 100% (1 parts paint to 1 part reducer). Mix well. **REDUCE ONLY WITH OUR KOSMIC REDUCERS.** Use the reducer best suited to your shop temperature. Shimrin® Designer Pearls are formulated to self-orient the pearl platelets and freeze them into position so no mottling occurs when top coated. **See tech sheet for more information on reducers.** When blending, you may slightly over-reduce Shimrin® Designer Pearls or mix them with SG100 Intercoat Clear for undetectable blends.

NOTE: Even though Shimrin® Designer Pearls are the easiest to apply, equipment, spray technique and air pressure can affect the pearl distribution. A full trigger pull is normally not recommended. Leave the fan wide but reduce the material sprayed with the spray gun's trigger restrictor or material control knob.

NOTE: Splitting or cracking is possible when using other companies' reducers or by using a reducer that is too slow for your shop conditions.



7. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Follow gun manufacturer's recommendations



8. APPLYING SHIMRIN® DESIGNER PEARLS (PBC)

Strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 2-3 medium coats with 75% pattern overlap to achieve coverage, color, and effect. Walk long objects. Avoid dry spraying, as loss of adhesion or mottling is possible with pearls. Again, medium coats work best. Allow flash time between coats. **NOTE:** Splitting, wrinkling, or cracking may occur when painting too fast without allowing proper flash time or by applying the base too wet and heavy.



9. DRY TIME

Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 4 hours). Topcoat within 4 hours or apply SG100 Intercoat Clear (see step 10).

SHIMRIN® FLASH TEST - ALL SHIMRIN® BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED.

Monitor closely for maximum merging of coats.

NOTE: Do not sand Shimrin® Pearls without re-basing as the scratches on the pearl platelets are permanent. Use SG100 for protection if sanding is required or artwork is planned.

NOTE: 3 coats of Shimrin® Graphic Kolor or Designer Pearl Base Coat equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge) as with all Shimrin® Basecoats.

10. ARTWORK & INTERCOAT CLEAR (optional)

Shimrin® Bases, with their low solids, are an excellent choice for artwork paint jobs. **DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT.** If artwork is planned, apply 1 or 2 medium coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. Plus you can use a grey scuff pad or 600 grit wet when SG100 is used. **See tech sheet for more information on SG100 Intercoat Clear.**

NOTE: SG100 Intercoat Clear is designed to protect the base coats for artwork tape-outs and blends only. **DO NOT USE SG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS.**

CAUTION: Shimrin® Base coats can be removed by final wash solvents. Use water or KC20 Post Sanding Cleaner for cleanup. RU, UFC, UC & UK Urethane – Kandys, Klears & Reducers are chemically designed to merge with the Shimrin® Basecoats – "Use No others" Avoid Problems. Other companies' products simply do not work with House of Kolor's system.

11. KANDY COAT (optional)

Shimrin® Designer Pearls may be Candied with either acrylic lacquer or urethane enamel. Remember if you Kandy with acrylic lacquer, you must also clear with acrylic lacquer. (If you Kandy with urethane enamel, you must also clear with urethane enamel). **See tech sheet for Kandy application.** Our Kandy Concentrates may be mixed with SG100 Intercoat Clear for base coat Kandys or for graphics. **See tech sheet for more information.**

12. CLEAR COAT

ALL SHIMRIN® GRAPHIC KOLORS MUST BE CLEAR-COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. **See tech sheets for more information on clear coat application.**

ADDITIONAL INFORMATION

Shimrin® Designer Pearls may be intermixed for hundreds of color combinations. The Pearls may also be mixed with other Shimrin®s, including the Neons, Graphic Kolors BC & FBC Metallic Base Coats. The possibilities are endless. Create your own one-of-a-kind custom finish. Shimrin® Pearl and Metallic Bases may also be added, in small amounts (no more than 25%), directly to the Kosmic Kolor® Kandys to ease touch-ups or for additional creative effects. Simply catalyze and reduce by volume as usual.

13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



NOTES



GENERAL INFORMATION

Shimrin® Neons (NE) are universal base coats must be cleared for a final finish. Due to their unique chemistry make-up, they may be top coated with either acrylic lacquer or urethane enamel. Once a system is chosen (acrylic lacquer or urethane enamel) use only products within that system. For example: If Neon is top coated with an acrylic lacquer Kandy, it must also be cleared with an acrylic lacquer clear.

IMPORTANT NOTE: USE WITH DISCRETION! Neons have limited colorfastness in the sun. Neons are not recommended for overall refinishing or where long life is a requirement. Neons are designed for high visual impact on race cars, boats, cycles, etc., where colorfastness is not the priority, but eye-grabbing brightness is.



1. SUBSTRATE

- KS10, KS210 White Ko-Seal® II
- BC26 White Base
- SG100 Intercoat Clear (artwork only)



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Shimrin® Neons are susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



3. GROUND COAT

- KS10, KS210 White Ko-Seal® II
- BC26 White Base

UNIFORM COVERAGE OF SEALER IS REQUIRED BEFORE APPLICATION OF BASE COAT. We recommend using Ko-Seal® II KS10 or KS210 White under the Neons. Follow label instructions. Allow flash time on sealer. **See tech sheets for more information on Ko-Seal® II and primers.**

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding.

4. WHITE BASE COAT BC26

Use our Kosmic Kolor® Shimrin® BC26 White, or Ko-Seal® II KS10 or KS210 as a base coat for all Neons. This will give the Neons maximum brightness. Apply 2-3 medium coats of BC26 or KS10 or KS210 with 50% pattern overlap. Allow flash time between coats. Maintain thorough coverage.

NOTE: An OEM white or jelcoat may also be sanded with 400-500 grit wet and used as a base for Neons. Do individual testing to be sure of compatibility.

NOTE: Do not apply over other companies' paint products. Lifting or splitting may occur when Neon is applied over other companies' bases. Neons need a white base for brightness, but other base colors can be used for special effects. Life of the Neons can be greatly increased by tinting the white base with a Neon or SG Graphic Kolor to make a pastel base close to the Neon topcoat color (try mixing 50% BC26 and 50% Neon). Do individual testing as some brilliance may be lost.



5. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100, Cured Top Coat Clears & OEM Finishes (artwork only)
- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad



6. COMPONENTS

- NE Shimrin® base coat
- RU310 (fast), RU311 (medium) urethane reducer,
- Air Brush application: RU311 (medium) RU312 (slow)



7. MIXING SHIMRIN® NEON (NE)

- 2 parts NE Shimrin® base coat
- 1 part RU- reducer
- Air Brush Application: 1 part Shimrin® base, 1 part RU-reducer



7. MIXING SHIMRIN® NEON (NE) (continued)

Shake or stir Neon well. Reduce 50% (2 parts paint to 1 part reducer). Mix well. Some painters add SG100 to the Neons for extra control. Maximum recommended addition of SG100 is 25% by volume. Over-reduction adds control as well.

REDUCE ONLY WITH OUR KOSMIC REDUCERS. Use the reducer best suited to your shop temperature. No booth - use the next fastest reducer. **See tech sheet for more information on reducers.**

NOTE: Some painters add small amounts (usually 1 to 2 %) of BC26 to beginning coats to eliminate streaks and blotches. Also, the life of the Neons will improve by tinting the BC26 base with one of our Neons or Shimrin® Graphic Kolors (use a color closest to the Neon color - 50% BC26 to 50% Neon).

NOTE: Splitting or cracking is possible when using other companies' reducers or by using a reducer that is too slow for your shop conditions.

NOTE: Neons may be intermixed for additional neon colors. Do individual testing.



8. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.0 to 1.3 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Follow gun manufacturer's recommendations



9. APPLYING SHIMRIN® NEONS (NE)

Strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches or less. Apply 2-4 medium coats with 75% pattern overlap. Walk long objects. Allow flash time between coats. Neons will dry dull, as will all Shimrin®s. Do not spray with a full trigger pull as this may cause blotching. Leave fan wide. Spray close, helps prevent blotching.

NOTE: When using NE502 Pink or NE511 Rose, if color is sprayed on too heavy or applied with too many coats, it can start to turn orange. Bring color on more slowly when using these colors and restrict trigger pull or material sprayed.

NOTE: Too much Neon will diminish the base, thus changing the tone and brightness of the Neon. If the base is squelched from too many coats of Neon, add BC26 to the Neon and recoat; then finish with pure reduced Neon. This is particularly prone to happen with NE502 Pink and NE511 Rose, but can occur with other Neons as well. Restrict material control on the gun, not the fan, work within 6-inch gun distance; pattern 5 to 6 inches with 75% pattern overlap. Apply 2 to 3 coats. Pay attention to the color building.

NOTE: DO NOT APPLY HEAVY WET COATS OF NE BASES AND EXPECT THEM TO FLOW; THIS WILL TYPICALLY RESULT IN WRINKLING AND SPLITTING.

NOTE: 3 coats of Neon equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge).



10. DRY TIME

Allow dry time before clear is applied (usually about 30 to 60 minutes and not longer than 4 hours). **DO NOT DRY NEONS OUTSIDE IN THE SUN!** The first 5 hours of sun are the most critical and care must be taken to prevent sun fade or discoloration at these early stages.

NOTE: Taping on Neons may discolor the Neon, and washing in sunlight may water spot or discolor the Neons.

11. ARTWORK & INTERCOAT CLEAR (optional)

Shimrin® Neons, with their low solids, are an excellent choice for artwork paint jobs. DO NOT TAPE DIRECTLY ONTO THE NEON BASE COAT. If artwork is planned, apply 1 or 2 medium coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Neon Base from tape marks and allow clean up of mistakes. **See tech sheet for more information on SG100 Intercoat Clear.**

12. PC, DP, DR PEARL COAT (optional)

The strength of the Neons may be enhanced by top coating with any of our Dry Pearls. Read and follow label instructions.

13. CLEAR COAT

ALL NEONS MUST BE CLEAR-COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. Use UC01 Kosmic Klear®, UFC01 Flo-Klear, UFC19 Kosmic Klear®, UFC35 Flo-Klear, or UC35 Kosmic Klear® for urethane enamel topcoats; and Kosmic Kolor® SC01 Sunscreen Clear for acrylic lacquer topcoats. These clears contain extra sun filters for longer life of the Neons and will give you considerable longer life than other company's products. **See tech sheets for more information on clear coat application.**

ADDITIONAL INFORMATION

Shimrin® Designer Pearls, Neons, Graphic Kolors, BC & FBC Metallics may be intermixed (or added in small amounts) for hundreds of additional creative effects. The possibilities are endless. Create your own one-of-a-kind custom finish. FOR EXTENDED LIFE, COVER OR SHIELD THE NEONS FROM THE SUN WHENEVER POSSIBLE. AVOID CONSTANT DAY TO DAY SUN EXPOSURE.

Do individual testing, for there is no guarantee! Neons are made with dyes and will fade in time based on sun exposure. House of Kolor® urethane clears contain 2 times more UV absorbers than standard clears. Thus reducing sun fade!

14. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).





GENERAL INFORMATION

Shimrin® Graphic Kolors (SG) are universal base coats that may simply be cleared for a final finish, or used as a base coat for KBC Base Coat Kandys or Pearls. Due to their unique chemistry make-up, they may be top coated with either acrylic lacquer or urethane enamel. Once a system is chosen (acrylic lacquer or urethane enamel) use only products within that system. Intermixing of these two systems, after the base coat, is not recommended. For example: If Shimrin® Base is top coated with an acrylic lacquer Kandy, it must also be cleared with an acrylic lacquer clear.



1. SUBSTRATE

- Ko-Seal® II
- SG100 Intercoat Clear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Shimrin® bases are susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



3. GROUND COAT

- KS10, KS210 Sealer for light shaded bases
- KS11, KS211 Sealer for dark shaded bases
- BC25, BC26 under artwork only

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Sealers are commonly used as a ground coat for Shimrin® Solid Color Bases. Use a House of Kolor® sealer closest to the base color for faster coverage of base coats. When using sealer, allow flash time. **See tech sheet for information on sealers.**

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding.



4. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100, Cured Top Coat Clears & OEM Finishes (artwork only)
- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad



5. COMPONENTS

- Shimrin® base coat
- RU310 (fast), RU311 (medium) urethane reducer,
- Air Brush application: RU311 (medium) RU312 (slow)



6. MIXING SHIMRIN® GRAPHIC KOLOR (SG) & SOLID COLORS (BC25 & BC26)

- 2 parts Shimrin® base coat
- 1 part RU- reducer
- Air Brush Application: 1 part Shimrin® base, 1 part RU-reducer

Stir Shimrin® Graphic Kolor well. Reduce 50% (2 parts paint to 1 part reducer). Mix well. REDUCE ONLY WITH OUR KOSMIC REDUCERS. Use the reducer best suited to your shop temperature. **See tech sheet for more information on reducers.**

NOTE: Splitting or cracking is possible when using other companies' reducers or by using a reducer that is too slow for your shop conditions

Note: For Air Brush application reduce 100% (1 part paint to 1 part RU-reducer)



7. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Follow gun manufacturer's recommendations



8. APPLYING SHIMRIN® GRAPHIC KOLOR (SG) & SOLID COLORS (BC25 & BC26)

Strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 2-3 medium coats with 50% pattern overlap. Walk long objects. Allow flash time between coats. Shimrin® Graphic Kolors will dry dull. Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 4 hours). Artwork may usually be taped after 1 hour of dry time. Dry time may vary based on shop and weather conditions.

SHIMRIN® FLASH TEST - ALL SHIMRIN® BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED.

Monitor closely for maximum merging of coats.

NOTE: DO NOT APPLY HEAVY WET COATS OF BC & SG BASES AND EXPECT THEM TO FLOW; THIS WILL TYPICALLY RESULT IN WRINKLING AND SPLITTING.

NOTE: 3 coats of Shimrin® Graphic Kolor equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge).

9. ARTWORK & INTERCOAT CLEAR (optional)

Shimrin® Graphic Kolors, with their low solids, are an excellent choice for artwork paint jobs. If artwork is planned, you may tape directly onto the base or apply 1 or 2 medium coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Shimrin® Base from mistapes. **See tech sheet for more information on SG100 Intercoat Clear.**

NOTE: Use of SG100 Intercoat Clear is not as critical on Shimrin® Graphic Kolors as it is on the Designer Pearls, Metallics and Neons. However, if mistapes occur, it is easy to remove them when Intercoat Clear is used.

NOTE: SG100 Intercoat Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE SG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS.

CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will remove base coats. Use water or our KC20 for cleanup.

10. CLEAR COAT

ALL SHIMRIN® GRAPHIC KOLORS MUST BE CLEAR-COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. Always use House of Kolor® clears. We have high amounts of UV Absorber, 2 times more than others for long life of your paint job. **See appropriate tech sheets for more information on clear coat application.**

ADDITIONAL INFORMATION

Shimrin® Graphic Kolors are designed to reduce paint build-up. They feature fast coverage, high pigmentation and low solids. Graphic Kolors are solid colors, but a ground coat will change their tone. The reds and yellows are bright and clean. The maroon and violet are deep and rich. The blues are pure, without green cast. You must spray these colors to believe them (the color card does not do them justice). As with other Shimrin®'s, they may be blended into hundreds of color combinations. All Shimrin® Bases may be intermixed for various combinations. The possibilities are endless. Create your own one-of-a-kind custom finish.



11. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

GENERAL INFORMATION

Marblizer® Artistic Bases offer you an exciting new paint finish. A wide range of effects can be achieved using this unique coating, from a deep marble appearance to a snake skin appearance. Many other effects are open to the innovative painter. Use two colors for increased depth or apply Kandys for awesome effects. Marblizer®s are Universal Base Coats that may simply be cleared for a final finish, or used as a base coat for Kandys. Due to their unique chemistry make-up, they may be top-coated with either acrylic lacquer or urethane enamel. Once a system is chosen (acrylic lacquer or urethane enamel) use only products within that system. Intermixing of these two systems, after base coat, is not recommended. For example, if Marblizer® is top-coated with urethane enamel Kandy, it must also be cleared with urethane enamel clear.

NOTE: IF CATALYZED URETHANES ARE TO BE APPLIED OVER MARBLIZER®S, YOU MUST FIRST APPLY 2 COATS OF SG100. THIS IS A MUST TO PREVENT DELAMINATION.

1. SUBSTRATE

- Ko-Seal® II
- All Shimrin® Base Coats
- SG100 Intercoat Clear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Marblizer® Kolors are very susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins, and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct to Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



3. GROUND COAT

- Sealer (Ko-Seal® II)
- Shimrin® Bases

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF MARBLIZER® ARTISTIC BASE COAT. Sealer may be used as a ground coat. Use a House of Kolor® sealer such as our Ko-Seal® II (available in three colors). Allow flash time on sealer. **See tech sheets for more information on Sealers.**

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.

You may also use any of our Kosmic Kolor® Shimrin® Bases: Designer Pearls, Graphic Kolors, Neons, Metallics, etc. for the ground coat. The color of the ground coat will vary the final color. This is an excellent place for creativity. Allow flash time on each coat of ground color. **See tech sheets for application instructions.**



4. BASE COAT

Marblizer® must be applied over a base color. The most dramatic effect is achieved using a House of Kolor® black base such as our KS11, KS211 Black Sealer, BC25 Black Base, PBC43, or PBC100 Black Pearl. Other base colors work also. We recommend doing your own testing before using other House of Kolor® base colors. Always spray a test panel! Let base color dry 15 to 60 minutes, but no longer than 4 hours, before applying Marblizer®.

5. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- Shimrin® Base Coats (see tech pages on BC, FBC, PBC, etc.)



6. MIXING

- Marblizer® (MB) Ready to Spray

Marblizer® is ready to spray. No mixing required. Stir Marblizer® well. Strain into gun. Apply only to an area you will be able to lay Saran™ Wrap or plastic sheeting onto within minutes and remove to achieve the marble look. Too long a wait and Marblizer® will dry and consequently must be reapplied. You only have seconds, so on small items, precut the Saran™ Wrap or plastic sheeting and do one item at a time.



7. MB00 NEUTRAL MARBLIZER®

Add any dry pearl, one ounce per quart to MB00 to create many new colors. Kameleon® Dry Kolor Change Pearls, as well as Ice Pearls and Mini Flakes, create outstanding marble effects. See our "Art of Marblizing" DVD for more information.

NOTE: Do not attempt to mix Shimrin® bases into the Marblizer®. The will cause the mix to react by turning it into something similar to cottage cheese. Only mix dry products into the Marblizer®.

8. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 75% to Full
- Air Brush = Follow gun manufacturer's recommendations



9. APPLYING MARBLIZER®

Apply Marblizer® using a 50% pattern overlap. Gun distance 6 inches. APPLY ONE COAT ONLY. Don't apply to more area than you can apply the Saran™ Wrap or plastic sheeting to before the Marblizer® dries.

NOTE: Allow Marblizer® 20 to 60 seconds dry time, depending on shop conditions, before applying Saran™ Wrap or plastic sheeting.

NOTE: Other materials may be used to achieve various effect, such as freezer wrap, bubble pack, sponge, tin foil, newspaper, plastic car covers, plastic garbage bags, etc. For additional depth, try another Marblizer® color over the first. Simply wait 15 to 30 minutes and apply another Marblizer®, lay on Saran™ Wrap, being sure to wipe your hand firmly over the entire area you wish to marblize, remove the Saran™ Wrap.

MARBLIZER® FLASH TEST - MARBLIZER® BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED. Monitor closely for maximum merging of coats.



10. DRY TIME

FOR LACQUER TOP COATS:

After you have achieved your desired artistic effects, allow Marblizer® to dry 30 to 60 minutes at 70°F, before applying lacquer Kandy or clear topcoats.

FOR URETHANE TOP COATS:

After you have achieved your desired artistic effects, allow Marblizer® to dry 30 to 60 minutes at 70°F, then apply SG100 Intercoat Clear **prior to application of the Urethane, or delamination of coatings from the MB is very probable. This step is considered a Must!**



SG100 Intercoat Clear - Apply 1 or 2 coats of SG100 thinned 50% (2 to 1), if artwork is planned or for adhesion. Allow 15 to 60 minutes dry time for the SG100, and then begin urethane Kandy or clear top coats. **See tech sheet for more information on SG100.**

NOTE: YOU MUST APPLY SG100 OVER THE MARBLIZER® FOR URETHANE TOP COATS. Under no circumstances should this step be overlooked as delamination of your urethane from the Marblizer® is eminent.

11. KANDY COAT (Optional)

Marblizer®s may be Candied with either acrylic lacquer or urethane enamel. Remember if you Kandy with acrylic lacquer, you must also clear with acrylic lacquer. (If you Kandy with urethane enamel, you must also clear with urethane enamel). For more information consult Kustom Painting Secrets (book or DVD). **See tech sheets for Kandy application.**

12. CLEAR COAT

MARBLIZER® MUST BE CLEAR-COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. Always use House of Kolor® clears. **See tech sheets for more information on clear coat application.**

13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).





GENERAL INFORMATION

Kandy Base Coats are a mixture of Kandy and select Pearls into a Shimrin® Universal Base Coat that mimics a Kandy finish. They feature low build, fewer coats, are easy to apply, and touch ups are easier than ever. Available in the same great 20 colors as our regular Kandys. Due to their unique chemistry make-up, they may be top coated with either acrylic lacquer or urethane enamel. Once a system is chosen (acrylic lacquer or urethane enamel) use only products within that system. Inter-mixing of these two systems, after the base coat, is not recommended.

IMPORTANT INFORMATION ABOUT KBC'S

The following KBC's have a tendency to bleed through art work applied over them. Always use our Bleed Check Sealer SBS10 before any artwork is applied. **See tech sheet for more information on Bleed Check Sealer.** A catalyzed clear coat will NOT stop their tendency to bleed. Multiple applications of clear (2 or more) and careful monitoring of dry times reduces pigment migration into the clear coats.

The KBC colors that are considered heavy bleeders are: KBC03, KBC05, KBC06, KBC10, and KBC13.

IMPORTANT INFORMATION ABOUT KBC18 KANDY BASECOAT PINK

KBC18 Kandy Basecoat Pink has limited light fastness and should only be used on projects that have limited exposure to sunlight.

Use with discretion. KBC18 is recommended for show vehicles only.



1. SUBSTRATE

- Ko-Seal® II
- All Shimrin® Base Coats



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® Kandy Basecoats can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, please refer to the tech pages on KP2CF or KD2000 Epoxy Primer Surfacers.

NOTE: Many KBC's are bleeders. Therefore, you must apply 2 coats of UC01 Clear or UC35 Kosmic Klear® and allow to dry for 12 hours OR you must apply 2 coats of UFC35 Flo-Klear or UFC19 Urethane Komply Klear® II and allow to dry for 24 hours. Wet sand (PLEASE REFER TO SANDING GRIT RECOMMENDATIONS ON FOR URETHANE CLEARS). Use fast reducer in Shimrin® Basecoats, allow dry time between coats.



3. GROUND COAT

- Sealer (Ko-Seal® II)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Sealers may be used as a ground coat. Check out our Ko-Seal® II Sealers, including KS12 Silver Metallic.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.

4. BASE COLOR

Use KS10, KS210, KS11, KS211, KS12 or KS212 Sealers, BC25 Black, BC26 White, or any of our prescribed Shimrin® bases as shown in our color book as a base color. The color of this base coat will vary the final Kandy color. Lighter bases may show blotching. Follow label instructions. Allow flash time on each coat of color. Don't use a full trigger pull, adjust your gun to a 5" or 6" pattern, 5" to 6" from the gun, and apply using a 75% pattern overlap.



5. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100 = Maroon Scuff Pad



6. MIXING

Stir Shimrin® Base well. Reduce 50% (2 parts paint to 1 part reducer). Mix well and reduce only with RU310, or RU311 reducer, based on booth temperature.

IMPORTANT NOTE: No catalyst is used in Shimrin® bases.

REDUCE ONLY WITH OUR KOSMIC REDUCERS. Use the reducer best suited to your shop temperature. **See tech sheet for more information on RU reducers.**

Note: For Air Brush application reduce 100% (1 part paint to 1 part RU311 Medium / RU312 Slow Reducer).

When blending, you may slightly over-reduce Shimrin® Bases or mix them with SG100 Intercoat Clear for undetectable blends.

7. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)



7. GUN SET UP (continued)

- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Air Brush = Follow gun manufacturer's recommendations.



8. APPLYING SHIMRIN® KANDY BASECOATS

After reducing, strain the paint into the paint gun. Gun distance while spraying should be approximately 4 to 6 inches. Apply 3 to 4 medium coats with a 75% pattern overlap. Walk long objects. Avoid dry spraying, as loss of

adhesion is possible. Again, medium coats work best. Allow flash time between coats. Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 4 hours). Topcoat within 4 hours or apply SG100 Intercoat Clear (see step 6).

SHIMRIN® FLASH TEST - ALL SHIMRIN® BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED. Monitor closely for maximum merging of coats.

NOTE: DO NOT APPLY HEAVY WET COATS OF KBC BASES AND EXPECT THEM TO FLOW, THIS WILL TYPICALLY RESULT IN WRINKLING AND SPLITTING. They behave very much like lacquer, so apply medium coats only and avoid heavy build. Do not dry spray or lack of adhesion is possible. Apply medium coats, 75% pattern overlap. Flash dull between coats.

NOTE: 3 coats of Shimrin® KBC Bases equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge.)

9. ARTWORK & CLEARS (optional)

Shimrin® Kandy Basecoats are an excellent choice for artwork paint jobs. If artwork is planned: after the last coat of Kandy Base Coat has flashed, apply 2 to 3 medium coats of UC01, UC35, UFC19 or UFC35 Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Shimrin® Base from tape marks and mistakes.

IMPORTANT INFORMATION ABOUT KBC'S

The following KBC's have a tendency to bleed through art work applied over them. Always use our Bleed Check Sealer SBS10 before any artwork is applied. **See tech sheet for more information on Bleed Check Sealer.** A catalyzed clear coat will NOT stop their tendency to bleed. **The KBC products are: KBC03, KBC05, KBC06, KBC10, and KBC13.**

For all other KBC's to prevent bleeding of colors applied over Kandy Base Coats, use one of our catalyzed Kosmic or Komply Klears. Let dry 12 hours if UC01 or UC35 is used OR let dry 24 hours if UFC19 or UFC35 is used. Wet sand (PLEASE REFER TO SANDING GRIT RECOMMENDATIONS ON PAGE 59 FOR URETHANE CLEARS) and then proceed with artwork.

10. CLEAR COAT

ALL SHIMRIN® KANDY BASECOATS MUST BE CLEAR COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. Always use House of Kolor® clears. **See tech sheets for more information on clear coat application.**

ADDITIONAL INFORMATION

Shimrin® Kandy Basecoats may be intermixed for hundreds of color combinations. The possibilities are endless. Create your own one-of-a-kind custom finish.



11. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

NOTE: KBC's may be intermixed for many one-of-a-kind combinations.

GENERAL INFORMATION

Kameleon® Kolor is a revolutionary new base coat that actually changes color depending on the angle from which it is viewed. Kameleon® Kolor undergoes broad color changes, for example, from a medium green to a deep purple or from a bright gold to a luminous silver. The Kameleon® Kolor base coat can appear to be different colors to people viewing the exact same area of the car from different angles. Rounded, curved surfaces and sharp angles will highlight the uniqueness of Kameleon® Kolor. Kameleon® Kolor base coats are as easy to apply as our Shimrin® Designer Pearl base coats. Application procedures can vary the appearance of the Kameleon® Kolor base coats to give novel color effects. Kameleon® Kolor base coats must be top coated with either urethane enamel or acrylic lacquer.



1. SUBSTRATE

- KS11, KS211 Black Ko-Seal® II
- BC25 Black Shimrin® Base Coat



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Kameleon® Kolors are very susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins, and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct to Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



3. GROUND COAT

- KS11, KS211 Black Ko-Seal® II
- BC25 Black Shimrin® Base Coat

Use BC25 or KS11 or KS211 for a ground coat as shown in the color card. The color of the ground coat will vary the amount of coats it will require to obtain the best results. We do not recommend using a white base coat since many coats will be necessary to achieve coverage. If BC25 cannot be used, use PBC100 or PBC43.



4. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100 = Maroon scuff pad



5. COMPONENTS

- KF Kameleon® base coat
- RU310 (fast), RU311 (medium) urethane reducer,
- Air Brush Application = 1 part Shimrin® base, 1 part RU-reducer



6. MIXING KAMELEON® KOLORS

- 2 parts Shimrin® base coat
- 1 part RU series reducer



Stir Kameleon® Kolor well. Reduce 50% (2 parts paint to 1 part reducer). Mix well. REDUCE ONLY WITH OUR KOSMIC REDUCERS. Use the reducer best suited for your shop temperature. **See tech sheet for more information on RU reducers.** Kameleon® Kolor is encapsulated metallic platelets, which are very easy to apply.

NOTE: Over-reducing and/or diluting with SG100 will give a darker, coarser appearance with a more subtle color change compared to normal reduction and application. This effect will diminish and approach normal color effect as more coats are applied. This allows for more novel effects.

7. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.0 to 1.3
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Follow gun manufacturer's recommendations



8. APPLYING KAMELEON® KOLORS

Strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches or less. Apply 3 coats with 75% pattern overlap. Avoid dry spraying as molting or loss of adhesion is possible. Allow flash time between coats. Wetter coats with a 75% overlap prevent molting and streaking.

NOTE: DO NOT APPLY HEAVY WET COATS OF KF KAMELEON® BASES AND EXPECT THEM TO FLOW; THIS WILL TYPICALLY RESULT IN WRINKLING AND SPLITTING. *They behave very much like a lacquer, so apply medium coats only and avoid heavy build. Do not dry spray or lack of adhesion is possible. Apply medium coats, 75% overlap. Flash dull between coats.*



8. APPLYING KAMELEON® KOLORS (continued)

NOTE: 3 coats of KF Kameleon® Bases equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge.)

NOTE: When blending, you may slightly over-reduce Kameleon® or mix SG100 for undetectable blends.

NOTE: Do not sand Kameleon® without re-basing as the scratches on the metallic platelets are permanent. Use SG100 for protection if sanding is required.



9. DRY TIME

KAMELEON® FLASH TEST - ALL BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED.

Allow dry time before clear or artwork is applied, usually 15 - 60 minutes and not longer than 4 hours.



10. ARTWORK & INTERCOAT CLEAR (optional)

KAMELEON® KOLOR Bases, with their low solids, are an excellent choice for artwork paint jobs. DO NOT TAPE DIRECTLY ONTO THIS BASE. If artwork is planned, apply 1 or 2 medium coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Kameleon® Base from tape marks and allow cleanup of mistakes. Sand wet for improved adhesion (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR SG100 and URETHANE CLEAR**). **See tech sheet for more information on SG100 Intercoat Clear.**

NOTE: Artwork colors applied over Kameleon® Kolor bases can reduce or completely eliminate the color change effect. Always test any planned artwork on a test panel.

NOTE: SG100 Intercoat Clear is designed to protect the base coats for artwork tape outs and blends only. DO NOT USE SG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS.

CAUTION: Kameleon® Kolors can be removed by final wash solvents. Use water or KC20 Post Sanding Cleaner for cleanup.

11. CLEAR COAT

ALL KAMELEON® KOLORS MUST BE CLEAR COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. Use only House of Kolor® clears for best results. **See appropriate tech sheets for more information on clear coat application.**

12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).





GENERAL INFORMATION

The Kosmic Krome® Effect Base represents the application of revolutionary aluminum flake chemistry. Due to the unique nature of these pigments it is very easy to experience inconsistencies in the final appearance. The method of application is more technically challenging than conventional products and the preparation, substrate, and application process must be followed to the letter. The final result can be a beautiful and interesting finish that, when combined with other House of Kolor® products, will extend your creative palette for years to come.



1. SUBSTRATE

- Ko-Seal® II
- SG100 Intercoat Clear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)

2. PREPARATION

Read "TECH PREP" thoroughly before you begin painting. Please be aware that Kosmic Krome® Effect Bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, please refer to the tech pages on KP & KD epoxy primers.



3. GROUND COAT

- Sealer (Ko-Seal® II)
- VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Ko-Seal® II Sealers are commonly used and recommended as the ground coat for Kosmic Krome® Effect Bases. When using sealer, allow flash time. **See tech sheet for information on Ko-Seal® II application.**
- NOTE:** Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.



4. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100, Cured Top Coat Clears & OEM Finishes (artwork only)
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon Scuff Pad



5. COMPONENTS

- | | |
|------|-----------------|
| MC01 | ALUMINUM EFFECT |
| MC02 | COPPER EFFECT |
| MC03 | BRONZE EFFECT |
| MC04 | GOLD EFFECT |



6. MIXING KOSMIC KROME® EFFECT BASE (MC)

The Kosmic Krome® Effect Bases are packaged ready to spray. The Kosmic Krome® Effect Bases should be shaken gently for 5 minutes prior to use.



7. GUN SET UP

- HVLP Gun = 1.2 to 1.4 Fluid tip
- Gravity Feed Gun = 1.2 to 1.4 Fluid tip
- Mini Gravity Feed Gun = 0.8 to 1.0 Fluid tip
- Air Brush = 0.2 to 0.5 Fluid tip

Adjust any gun set up to achieve a fine spray, consistent fan, and be sure to spray within the distance that will provide the most even application. This is usually only 6-8 inches for a "Full" size gun and may be 4-6 inches for a "Mini" style gun. Always do a test panel, with the complete system, to test your application, spray gun function, effect, and your art plans, BEFORE you spray your project.



8. APPLICATION

For the colors MC01, MC02, MC03, & MC04, apply 2-3 light "mist", but not "dry", coats using a 75% pattern overlap when spraying. An example set up would be 1.3 fluid tip open 40-50% with a medium transverse speed. Allow to flash 5-10 minutes between coats.



9. DRY TIME

For the colors MC01, MC02, MC03, MC04, allow 15-60 minutes to dry and not longer than 12 hours before applying House of Kolor® Clearcoats.

10. ARTWORK & INTERCOAT CLEAR (optional)

The Kosmic Krome® Effect Bases, with their low solids, are an excellent choice for artwork paint jobs. **DO NOT TAPE DIRECTLY ONTO THE KOSMIC KROME® EFFECT BASES.** If artwork is planned, apply 1 or 2 medium coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Kosmic Krome® Effect Bases from the tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING OF INTERCOAT CLEAR. See tech sheet for more information on SG100 Intercoat Clear.**

NOTE: DO NOT SAND The Kosmic Krome® Effect Bases DIRECTLY. Apply SG100 Intercoat Clear for base coat protection if sanding is required. If you directly sand the Kosmic Krome® Effect Bases, you must re-base. **NOTE:** SG100 Intercoat Clear is designed to protect the base coats for artwork tape-outs and blends only. **DO NOT USE SG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS. CAUTION: The Kosmic Krome® Effect Bases do not have any chemical resistance until cleared. Final wash solvents will remove base coats. Use KC20 Post Sanding Cleaner for cleanup.**



11. KANDY COAT (optional)

The Kosmic Krome® Effect Bases may be Candied with either acrylic lacquer or urethane enamel. Remember if you Kandy with acrylic lacquer, you must also clear with acrylic lacquer. (If you Kandy with urethane enamel, you must also clear with urethane enamel.) See appropriate tech sheets for Kandy application. For artwork, our Kandy Concentrates may be mixed with SG100 Intercoat Clear for Kandy graphics. See KK & SG100 tech sheets for more information.



12. CLEAR COAT

The Kosmic Krome® Effect Bases MUST BE CLEAR COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.



13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations)

MC00 KOSMIC KROME® MIRROR REFLECTIVE EFFECT BASE

The Kosmic Krome® Mirror Reflective Effect Base represents the application of revolutionary aluminum flake chemistry. Due to the unique nature of these pigments it is very easy to experience inconsistencies in the final appearance. The method of application is more technically challenging than conventional products and the preparation, substrate, and application process must be followed to the letter. The final result can be a beautiful and interesting finish that, when combined with other House of Kolor® products, will extend your creative palette for years to come.



WARNING:

- Substrates other than recommended will "absorb" the MC00 base and it will appear grey and inconsistent.
- The use of sanding with grits not recommended, as it will result in a different appearance.
- Any variation of the surface will be magnified and may ruin the project.
- Rough paper towels or solvent-based cleaners will ruin your project when using MC00.
- Do not use competitive clears, bases, or primers.
- Assure that your spray gun is functioning properly. It is critical that application be even.
- Open the tack cloth completely and air dry for at least an hour to reduce stickiness. A sticky residue transfer will ruin a project.
- Always do a test panel, with the complete system, to test your application, spray gun function, effect, and your art plans, BEFORE you spray your project.
- Plan your artwork to apply this product last. This will maximize the "metal" effect.
- Do not apply SG100 directly to MC00. When performing artwork over the MC00 first coat MC00 with the appropriate House of Kolor® Clear, allow the clear to dry, sand, and continue.
- The Kosmic Krome® Mirror Reflective Effect Base is intended for artwork only and may be difficult to apply evenly on larger areas.
- Do not "oversell" your customers. The Kosmic Krome® Mirror Reflective Effect Base, even when applied correctly, will not match the shine, hardness, and reflectivity, of an actual plated surface.

PART #	DESCRIPTION
MC00	MIRROR REFLECTIVE EFFECT

1. SUBSTRATE

In order for Kosmic Krome® Mirror Reflective Effect Base to show the maximum effect, the substrate must be a fully dry, very smooth, 2K Urethane surface. House of Kolor® Clear coats UC35, UFC35, UFC19, UC01, UFC01, and UCC01 are the only recommended surfaces for this product. The smoothness of the substrate will determine the appearance of the metal effect bases. Any scratch from sanding, wiping, or tacking will show through when MC00 is applied.



2. GROUND COAT

The actual color of the ground coat is not important; any color can work. The Kosmic Krome® Mirror Reflective Effect Base is commonly sprayed over black, however, for a "ghosted" metal look try different ground colors. This adds to the creative possibilities. The stability and smoothness of dry 2K Urethane is what is important. Prepare the 2K Urethane as illustrated below.



3. PREPARATION

To get the maximum reflective effect, we recommend the MC00 be applied directly to a surface that has been color sanded, polished, and cleaned with KC20 and a soft towel. This procedure is required for the complete visual effect of these products, however; ONLY in this situation do we recommend this process. It is known that this process will diminish the integrity of the system. However, if the effect this product offers with what is required for your art plan, there is no replacement for the visual possibilities of this system.



4. COMPONENTS

The Kosmic Krome® Mirror Reflective Effect Base is provided and ready to spray.



5. MIXING KOSMIC KROME® BASE (MC00)

The Kosmic Krome® Mirror Reflective Effect Base should be shaken gently for 5 minutes prior to use.



6. GUN SET UP

- HVLP Gun = 1.2 to 1.4 Fluid tip
- Gravity Feed Gun = 1.2 to 1.4 Fluid tip
- Mini Gravity Feed Gun = 0.8 to 1.0 Fluid tip
- Air Brush = 0.2 to 0.5 Fluid tip



Adjust any gun set up to achieve a fine spray, consistent fan, and be sure to spray within the distance that will provide the most even application. This is usually only 6-8 inches for a "Full" size gun and may be 4-6 inches for a "Mini" style gun. Always do a test panel, with the complete system, to test your application, spray gun function, effect, and your art plans, BEFORE you spray your project.

7. APPLYING KOSMIC KROME® BASE (MC00)

Apply as little Kosmic Krome® Mirror Reflective Effect Base as is needed to achieve the desired effect. An example set up would be 1.3 fluid tip open 10-15% with a medium to fast transverse speed. Usually this will be 1-2 thin coats. Over application, including a "wet" type coat, will result in a total loss of effect. The reflective qualities of MC00 will not become visible until flash dry has occurred.



8. KANDY COAT (optional)

The Kosmic Krome® Effect Bases may be Candied with either acrylic lacquer or urethane enamel. Remember if you Kandy with acrylic lacquer, you must also clear with acrylic lacquer. (If you Kandy with urethane enamel, you must also clear with urethane enamel.) See appropriate tech sheets for Kandy application. For artwork, our Kandy Concentrates may be mixed with SG100 Intercoat Clear for Kandy graphics. See KK & SG100 tech sheets for more information.



9. DRY TIME

Allow MC00 to dry for at least 12 hours at 70°F before applying House of Kolor® Clearcoats. Up to 24 hour is OK; however, be careful to keep the job clean as aggressive tacking, wiping, or handling can ruin the finish by scratching or smudging the MC00.



12. CLEAR COAT

When clearcoating the Kosmic Krome® Effect Base, special care must be taken to preserve the unique reflective qualities. Only use House of Kolor® clearcoats as they are designed for the performance requirements associated with custom painting. Apply UC35, UFC35, UCC01, UC01, UFC01, or UFC19 directly to the Kosmic Krome® color. Apply the first coat, with the appropriate catalyst/reducer combination, with a fine mist. Apply only enough clear to achieve flow in a thin flowing coat. Allow the clear coat to dry 12-24 hours. This is very important, as too wet a coat can cause a loss of effect. After 24 hours, lightly sand and re-clear.



Note: The excessive build of true Kandy paint work requires a very stable foundation. With the special process approved for the use of these "metal" finishes comes a compromise in total system performance. The House of Kolor® Urethane, or Kandy Concentrate, Kandy colors will look great when applied over the Kosmic Krome® Mirror Reflective Effect Base; however, select the process and product sequence in an order that will minimize the amount of material that is applied over the Kosmic Krome® Mirror Reflective Effect Base.

Note: Do not apply SG100 directly to MC00. When performing artwork over the MC00, coat MC00 with the appropriate House of Kolor® Clear first. Allow the clear to dry, sand, and continue.

ADDITIONAL INFORMATION

- Substrates other than recommended will "absorb" the Kosmic Krome® Mirror Reflective Effect Base and it will appear grey and inconsistent.
- Sanding with grits not recommended will result in a different appearance.
- Any variation of the surface will be magnified and may ruin the project.
- Rough paper towels or solvent-based cleaners will ruin your project when using MC00.
- Do not use competitive clears, bases, or primers.
- Assure that your spray gun is functioning properly. It is critical that application be even.
- Open the tack cloth completely and air dry for at least an hour to reduce stickiness. A sticky residue transfer will ruin a project.
- Always do a test panel, with the complete system, to test your application, spray gun function, effect, and your art plans, BEFORE you spray your project.
- Plan your artwork to in order to apply this product last to maximize the "metal" effect.
- Do not apply SG100 directly to MC00. When performing artwork over the MC00 first coat MC00 with the appropriate House of Kolor® Clear, allow the clear to dry, sand, and continue.
- The Kosmic Krome® Mirror Reflective Effect Base is intended for artwork only and may be difficult to apply evenly on larger areas.
- Do not "oversell" your customers. The Kosmic Krome® Mirror Effect Base, even when applied correctly, will not match the shine, hardness, and reflectivity, of an actual plated surface.



13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations)

NOTES



GENERAL INFORMATION

Kosmic Kolor® Urethane Enamel single stage solid colors may be applied over any of our Shimrin® Universal Base Coats and Sealers. Use only Kosmic Reducers for best results. Do not mix other companies products with House of Kolor®'s products, as many have proven to be incompatible. This includes other companies' primers, sealers, reducers and clears.

IMPORTANT NOTE

Use only our Kosmic Reducers. Carefully choose the correct reducer based on your spray booth temperature with fan running. If no spray booth is available, use a faster dry reducer. Kosmic Reducers have very noticeable differences in dry times. For additional flow, add more reducer of the same speed or mix with a slower reducer. **See tech sheet for more information on Kosmic Reducers.**

IMPORTANT NOTE: Kosmic Urethane Enamels used in some VOC restricted areas must be top coated with our UC or UFC Klears to meet current VOC regulation.



1. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



2. GROUND COAT

- Sealer (Ko-Seal® II)
- For UB04, UFB04 Jet Set Black = KS11 or KS211 (Ko-Seal® II)
- For UB05, UFB05 Brite White = KS10 or KS210 (Ko-Seal® II)
- For UFB06 Kosmos Red = KS10 or KS210 (Ko-Seal® II)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Sealers may be used and recommended as a ground coat. Use House of Kolor® Ko-Seal® II (available in three colors). Use a sealer closest to the base color for faster coverage of base coats. Follow label instructions. Allow flash time on the sealer. **See tech sheet for information on Ko-Seal® II.**

NOTE: *Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding.*



3. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- OEM Finishes
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon Scuff Pad



4. COMPONENTS

- Kosmic Urethane Enamel
- RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) urethane reducer
- KU100, KU150 Exempt or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush application = Not recommended



5. MIXING KOSMIC KOLOR® URETHANE ENAMELS

- 2 parts Kosmic Kolor® Urethane Enamel
- 1 part KU100 Catalyst or KU150 Exempt Hi Temp Catalyst
- 1 part RU- reducer
- Air Brush Application = Not recommended

NOTE: For extra flow, add an additional 3 to 6 oz. RU-reducer per mixed quart.

NOTE: To increase gloss, depth and jetness to UB04 and UFB04 black. Mix equal amounts of clear to the black (UB04 use UC35) (UFB04 use UFC35) in the last coat prior to reducer or catalyst.



6. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not recommended



7. APPLYING UB & UFB KOSMIC KOLOR® URETHANE ENAMELS

Strain the paint into paint gun. Apply 1 medium coat. Allow flash time (see "URETHANE FLASH TEST" below). Follow with 1 to 2 wet coats, 50% pattern overlap. Gun distance while spraying should be approximately 6 inches.



7. APPLYING UB & UFB KOSMIC KOLOR® URETHANE ENAMELS (continued)

Walk long objects. Allow flash time between coats. HVLP guns work best held close.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED. (When using the flash test, always touch a new spot). Monitor closely for maximum merging of coats.

NOTE: Too long a dry time between coats may cause lifting. If finish feels dry, allow 12 hours at 70°F before re-coating. Scuff with maroon scuff pad to remove gloss or lightly wet sand with 500 or 600 wet.

NOTE: Over spray from any catalyzed topcoat material such as our UB04, UB05, UK Kandys, and UC or UFC Clears, may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.



8. DRY TIME

- Air dry at 70°F = 24 hours
- Force dry at 140°F = 30 minutes flash time, 1 hours bake, with 1 hour cool down.



9. FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**

NOTE: After 60 days, the vehicle may be waxed. We recommend using a quality non-abrasive Carnauba wax.



10. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

GENERAL INFORMATION

Kosmic Kolor® Urethane Enamel Kandys may be applied over any of our Shimrin® Universal Base Coats. Use only Kosmic Reducers. Do not mix other companies products with House of Kolor®'s products, as many have proven to be incompatible. This includes other companies' primers, sealers, base coats, reducers and clears.

IMPORTANT NOTE

Use only our Kosmic Reducers. Carefully choose the correct reducer based on your spray booth temperature with fan running. If no spray booth is available, use a faster dry reducer. Kosmic Reducers have very noticeable differences in dry times. For additional flow, add more reducer of the same speed or mix with a slower reducer. **See tech sheet for more information on Kosmic Reducers.**

IMPORTANT INFORMATION ABOUT UK'S

The following UK's have a tendency to bleed through artwork applied over them. Always use our Bleed Check Sealer SBS10 before any artwork is applied. **See tech sheet for more information on Bleed Check Sealer.** A catalyzed clear coat will NOT stop their tendency to bleed. However, if multiple applications of clear (2 or more) and proper flash time between coats is observed, the leaching of color into the clear is reduced.

The UK products that have a tendency to bleed are: UK03, UK05, UK06, UK10, and UK13.

IMPORTANT INFORMATION ABOUT UK18 KANDY PINK

UK18 Kandy Pink has limited light fastness and should only be used on products that have limited exposure to sunlight. Use with discretion. UK18 is recommended for show vehicles.



1. PREPARATION

Read "TECH REP" thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



2. GROUND COAT

- Sealer (Ko-Seal® II)
- Shimrin® Bases

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Sealers may be used as a ground coat. Use House of Kolor® Ko-Seal® II (available in three colors). Use a sealer closest to the base color for faster coverage of base coats. Follow label instructions. Allow flash time on sealer. **See tech sheets for more information on Ko-Seal® II.**

NOTE: *Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. You may also use any of our Kosmic Kolor® Shimrin® Bases: Designer Pearls, Graphic Kolors, Neons, Metallics, etc., for the ground coat. The color of the ground coat will vary the final color. This is an excellent place for creativity. Follow labels instructions. Allow flash time on each coat of ground color. See appropriate tech sheets for application instructions.*



3. BASE COAT

You may use any of our Shimrin® Bases under the Kosmic Kolor® urethane enamels. Follow label instructions. Allow flash time on each coat of base color. **See individual tech sheets for specific instructions.**

4. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- OEM Finishes
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon Scuff Pad



5. COMPONENTS

- Kosmic Urethane Enamel
- KU100, KU150 Exempt, or KU151 Exempt Hi Temp Flo-Catalyst
- RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) Urethane Reducer
- Air Brush application = Not recommended



6. MIXING KOSMIC KOLOR® URETHANE ENAMELS

- 2 parts Kosmic Kolor® Urethane
- 1 part RU- reducer
- 1 part KU100 Catalyst, KU150 or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush Application = Not recommended

NOTE: For extra flow and material control, add an additional 2 to 4 oz. RU-reducer per mixed quart.



7. GUN SET UP

- Conventional Gun = 55 to 65 PSI
- HVLG Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)



7. GUN SET UP (Continued)

- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Air Brush Application = Not recommended.



8. APPLYING UK KOSMIC KOLOR® URETHANE ENAMEL KANDYS

Kosmic Kandys may be applied over any of our Shimrin® bases or Kosmic Solid Colors. Always spray a test panel before committing to the job.

NOTE: KU100, KU150 & KU151 Catalysts are moisture sensitive and will not keep for long periods once opened. When doing small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Strain the paint into the paint gun. Apply 5 to 6 coats to achieve proper color. Start with 3 medium wet coats first, with 75% spray overlap. Finish with 2 to 3 full wet coats with 50% spray pattern overlap. Gun distance while spraying should be approximately 6 inches. Walk long objects. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.

NOTE: Too long a dry time between coats may cause lifting. If finish feels dry, allow 12 hours at 70°F before re-coating. Scuff with maroon scuff pad to remove gloss or lightly wet sand with 500 or 600 wet. Use caution as too aggressive sanding can cause light and dark spots in the candy.

NOTE: Color strength will vary based on base color, number of Kandy coats, type and number of clear coats, and spray technique. LIGHTER BASE COLORS REQUIRE MAXIMUM NUMBER OF KANDY COATS FOR LONGEVITY. A base color tinted near the Kandy color eases application and improves longevity.



9. KANDY APPLICATION TECHNIQUES

The application of "Kandy Type" finishes are among the most demanding of all finishes applied. Great attention must be paid in spray gun settings, number of coats and basic spray gun techniques. The following steps, when observed, provide consistent results.

Setting up the Spray Gun

- Know the equipment
- Check spray gun pattern, it must be consistent. (See Diagram One)
- Turn fluid knob in, to restrict trigger pull and reducer amount of Kandy delivered. This must be done for the first two to three coats to avoid streaking. A 75% pattern overlap is mandatory.

Turn fluid adjustment knob in, to restrict amount of Kandy.

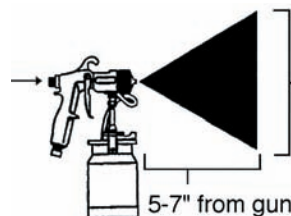
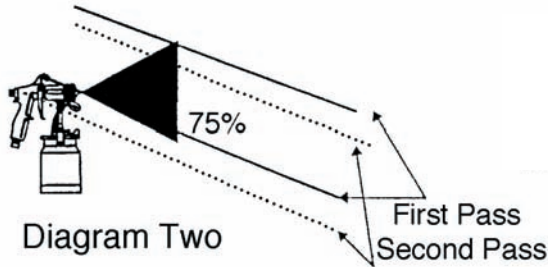


Diagram One

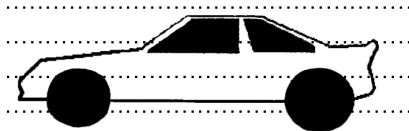
9. KANDY APPLICATION TECHNIQUES (Continued)

Application - The First 2 to 3 Coats

- Apply Kandy with recommended pattern overlap. (See Diagram Two)
- Spray gun should be 4 to 6 inches from surface.
- Do not apply Kandy panel to panel, spray entire length of object.
- Spray in straight lines, do not follow body lines. (See Diagram Three)



Spray in straight lines.



Application - Final Coats

- Adjust fluid knob for a larger pattern 5-7" apply additional 2 to 3 coats with 50% overlap.
- Allow each coat to stop "stringing" before applying next coat. Do not allow coats to completely dry to touch between coats.
- Apply 2 to 3 coats of UC or UFC urethane top coat clear, allowing Kandy only enough time to stop "stringing". Do not allow Kandy to completely dry before clearing or wrinkling and lifting is likely to occur.

NOTE: Do not use SG100 Intercoat Clear. This is a base coat material. Use our Catalyzed UC or UFC Clear only.



10. DRY TIME

- Air dry at 70°F = 24 hours
- Force dry at 140°F = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, etc. It is not unusual for the Kandy job to remain soft for extended periods of time. This does not mean the finish is uncured, it indicates the finish is holding solvents and will need additional time to fully harden.



11. FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**

After 60 days, the vehicle may be waxed. We recommend using a quality non-abrasive Carnauba wax.



12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

NOTES

GENERAL INFORMATION

Kandy Koncentrates are used to enrich any of our Kosmic Kolor® Urethane Enamel Kandys or Kustom Kolor® Acrylic Lacquer Kandys. Kandy Koncentrates:

- Get you through the tough stuff fast, saving time and material.
- Are perfect for motorcycles or small parts when speed is a factor.
- Are great for touch ups.
- Tint UK Kandys, base coats, and sealers for additional colors. Example: Add a small amount of KK09 Organic Green Kandy Koncentrate to UK02 Lime Gold Kandy to make a beautiful Lime Green Kandy.
- Strengthen Kandys for faster coverage on frames, door jambs, under trunk and hood areas, etc. Topcoats can literally be cut in half with Kandy Koncentrates. Not generally recommended for exterior on over all Kandy completes.
- May be added to SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats), for multi-colored Kandy tape outs with minimal build. Dries fast, so many colors may be applied in one day.
- Have long term shelf life. Use factory packaged Kandys for overall refinishing and for maximum longevity.

IMPORTANT NOTE

KK Kandy Koncentrates are additives and cannot be applied as packaged. They must be intermixed with either our sealers, bases, UK Kandy's, or clears.

For best results we recommend that you use only House of Kolor® products when mixing.

IMPORTANT INFORMATION ABOUT KK'S

The following KK's have a tendency to bleed through art work applied over them. Always use our USG100 Intercoat Barrier Klear before any artwork is applied. See tech sheet for more information on USG100. Follow label instructions. A catalyzed clear coat will NOT stop their tendency to bleed. However, if multiple applications of clear (2 or more) and proper flash time between coats is observed, the leaching of color into the clear is reduced, if not eliminated. Do individual testing.

The KK products that have a tendency to bleed are: KK03, KK05, KK06, KK10, and KK13.

IMPORTANT INFORMATION ABOUT KK18 KANDY PINK

KK18 Kandy Koncentrate Pink has limited light fastness and should only be used on products that have limited exposure to sunlight. Use with discretion. KK18 is recommended for show vehicles.



1. MIXING & APPLYING KANDY KONCENTRATES

To approximate our UK Kandy's, follow the mixing ratios below:

To Duplicate UK Kandy Kolor	Kosmic Klear	RU310, 311, 312, or 313 Reducers	KU150 or KU151 Exempt Catalyst	KK Koncentrate Kolor	KK Ratio (in ounces)
UK01	32 oz.	16 oz.	16 oz.	KK01	10 oz.
UK02	32 oz.	16 oz.	16 oz.	KK02	7 oz.
UK03	32 oz.	16 oz.	16 oz.	KK03	10 oz.
UK04	32 oz.	16 oz.	16 oz.	KK04	10 oz.
UK05	32 oz.	16 oz.	16 oz.	KK05	13 oz.
UK06	32 oz.	16 oz.	16 oz.	KK06	11 oz.
UK07	32 oz.	16 oz.	16 oz.	KK07	6 oz.
UK08	32 oz.	16 oz.	16 oz.	KK08	3 oz.
UK09	32 oz.	16 oz.	16 oz.	KK09	7 oz.
UK10	32 oz.	16 oz.	16 oz.	KK10	20 oz.
UK11	32 oz.	16 oz.	16 oz.	KK11	8 oz.
UK12	32 oz.	16 oz.	16 oz.	KK12	9 oz.
UK13	32 oz.	16 oz.	16 oz.	KK13	7 oz.
UK14	32 oz.	16 oz.	16 oz.	KK14	12 oz.
UK15	32 oz.	16 oz.	16 oz.	KK15	16 oz.
UK16	32 oz.	16 oz.	16 oz.	KK16	10 oz.
UK17	32 oz.	16 oz.	16 oz.	KK17	4 oz.
UK18	32 oz.	16 oz.	16 oz.	KK18	4 oz.
UK19	32 oz.	16 oz.	16 oz.	KK19	9 oz.
UK20	32 oz.	16 oz.	16 oz.	KK20	10 oz.

To Intensify UK Kandy's:

When mixing with Kosmic Kandys, reduce and catalyze, making 1 quart. Then begin adding Kandy Koncentrate in half ounce increments. Usually by viewing the stir stick, the degree of intensity can be determined. Color should appear rich to achieve color density in 3-4 coats. **See tech sheet for Kandy and appropriate clear tech sheets for mixing and application instructions.**

Mixing With SG100 For Artwork:

When mixing with SG100 Intercoat Clear, simply reduce and begin adding Kandy Koncentrate in half ounce increments. DO NOT APPLY MORE THAN 4 COATS OF SG100. Not recommended for overall paint application and is not designed for hi-build. **See tech sheet for mixing and application instructions.**

NOTE: Generally, a 1 to 1 reduction prior to addition of Kandy Koncentrate is common. Air Brush artists often will mix up to 20% KK Koncentrates to ready to spray SG100.

SG100 INTERCOAT CLEAR



GENERAL INFORMATION

SG100 Intercoat Clear is designed as a protective intermediate clearcoat for artwork tape outs on Shimrin® Base Coats. USE ONLY WHEN TOP COATING WITH URETHANE ENAMEL. SG100 Intercoat Clear prevents the tape from marking or pulling the metallic and splitting when top coated, provided only a minimum of medium coats has been applied. Do your art tape outs, spray, and remove tape as soon as possible to reduce tape marks and adhesive tracks.

SG100 Intercoat Clear may be used to blend Shimrin® Pearl and Metallic Base Coats, to mix Pearl and Kandy Koncentrates, and to cut the Shimrin® Base for touch-ups and blends.

IMPORTANT NOTE

DO NOT USE SG100 AS A TOPCOAT CLEAR, THIS IS A BASE COAT MATERIAL! SG100 is designed to protect base coats for artwork tape outs and blends only. DO NOT USE SG100 AS A BUILD-UP CLEAR. Do not apply more than 4 medium coats of SG100 as wrinkling and splitting may occur. If over reduced, more coats are acceptable.

NOTE: SG100 may be applied over basecoats, over cured catalyzed urethanes for additional tapeouts. However, use fast reducer and allow dry time between coats to prevent lifting.



1. SUBSTRATE

- All Shimrin® Bases
- Marblizer®s
- Properly cured top coat clears and OEM finishes (artwork only)



2. PREPARATION

Prior to applying SG100 Intercoat Clear, it is advised to lightly tack surface with a fully open tack cloth, or perform minor cleanup with KC20 Post Sanding Cleaner.



3. COMPONENTS

- SG100 Intercoat Clear
- RU310 (fast), RU311 (medium) urethane reducer,
- Air Brush application: RU311 (medium) RU312 (slow)



4. MIXING SG100 INTERCOAT CLEAR

- 2 part SG100 Intercoat Clear
 - 1 part RU- reducer
 - Air Brush Application: 1 part Shimrin® base, 1 part RU-reducer
- Stir SG100 prior to use, as a separation of ingredients will occur.

NOTE: Use fast drying reducer RU310, or as fast a dry as your conditions allow.

NOTE: Intercoat Clear is a base coat resin system, DO NOT ADD CATALYST. See tech sheet for more information on reducers.

NOTE: Maximum recommended over reduction is 1 part SG100 to 1 part reducer. This ratio is always used when Kandy Koncentrates and pearls are mixed with SG100.



5. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Follow gun manufacturer's recommendations



6. APPLYING SG100 INTERCOAT CLEAR

Apply 1 or 2 medium coats of SG100 Intercoat Clear after the last coat of Shimrin® base has flashed dull, with 50% spray pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats and approximately 1 hour before taping (tape time will vary with weather and shop conditions). In many instances SG100 may be taped in less than 30 minutes. Always allow flash time between coats.

SG100 FLASH TEST - SG100 WILL DRY TO A SEMI-GLOSS AND FEEL DRY TO THE TOUCH.

NOTE: DO NOT APPLY MORE THAN 4 COATS OF SG100. It is not designed for hi-build.

NOTE: If 4 hours of dry time has elapsed, scuff Intercoat Clear (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR SG100**) to insure proper adhesion of topcoats. Do artwork with a minimum of tape contact and remove quickly for topcoats. Although we have let hours elapse on many jobs without a problem, common sense tells us that topcoats will merge better if the base is somewhat less than dry.



7. TOUCH UP & BLENDS

SG100 Intercoat Clear may also be used to blend Shimrin® Pearl and Metallic Base Coats. Apply 1 medium coat of SG100 beyond the blend point. Metallics will not darken as they normally would at the blend.



7. TOUCH UP & BLENDS (continued)

Then simply topcoat with any of our Kosmic Kolor® clears.

NOTE: SG100 may also be added to Shimrin® Bases for undetectable blends on touch ups.

8. KANDYS

SG100 Intercoat Clear may also be used to make low solid Kandys by mixing any of our Kandy Koncentrates with SG100. Excellent when many Kandy tape outs are required under urethane topcoats. Perfect for small parts or graphics when speed is a factor. This method is actually faster than lacquer.

See tech sheet for more information on using Kandy Koncentrates.

9. PEARLS

Although SG100 may be used to make Pearls, It is recommended the use of SG150 Intercoat Pearl & Flake Karrier for this application (**please refer to the tech page on SG150 Intercoat Pearl and Flake Karrier**). Double the amount of reducer in the SG100 for Pearls. Mix 1 part SG100 to 1 part reducer.

When using dry pearl, begin with 1/2 teaspoon lots of dry pearl until desired concentration is achieved per mixed quart.

When using pearl paste, begin with 1/4 teaspoon lots of pearl paste until desired concentration is achieved per mixed quart.

These mixtures are designed as starting points for light colored bases. Darker bases may require much less pearl, depending on the effect required.

NOTE: Do not add too much pearl as clouding, mottling, streaking and bunching from too much pearl can occur. Pearl platelets must have room to sparkle. Overcrowding reduces their effect and increases the chance of mottling and streaking.

As with Kandys, use a 75% spray pattern overlap. Do not apply more than 4 coats. **See tech sheet for more information on the use of pearl concentrates.**



10. DRY TIME

Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 4 hours). If 4 hours of dry time has elapsed, scuff Intercoat Clear (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR SG100**) to insure proper adhesion of topcoats. **SG100 FLASH TEST - SG100 WILL DRY TO A SEMI-GLOSS AND FEEL DRY TO THE TOUCH.** Monitor closely for maximum merging of coats.

NOTE: If SG100 is being used as the carrier for pearls. Do not sand directly as you will darken the pearls. You will need to apply 1 or 2 coats of properly reduced SG100 before sanding.

11. CLEAR COAT

DO NOT USE SG100 AS A TOPCOAT CLEAR. SG100 must be top coated with Kosmic Kolor® UC01, UFC01, UFC19, UFC35, or UC35.



12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

GENERAL INFORMATION

SG150 Intercoat Pearl & Flake Karrier is a base coat clear material that is designed specifically to be used as the carrier for Pearls, Flakes, as well as other dry products offered in the House of Kolor® product line. Due to its unique chemistry, it greatly reduces or eliminates the settling of pearls and flakes after the products are mixed. It also encapsulates the pearls and flake particles, so when sprayed, self orientates, locking them in place, greatly reducing blotching and streaking of the finish. Although the material looks semi-opaque in the can, it dries to water clear finish allowing the brilliance of the pearls & flakes to show through.



1. SUBSTRATE

- Ko-Seal® II
- All Shimrin® Base Coats
- Properly cured and prepared top coat clears and OEM finishes



2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, please refer to the tech pages on KP & KD Epoxy Primers.



3. GROUND COAT

- Ko-Seal® II
- All Shimrin® Base Coats
- OEM Finishes



4. COMPONENTS

- SG150 Intercoat Pearl & Flake Karrier
- RU310 (fast), RU311 (medium) urethane reducer.
- Pearls, Flakes, & other Dry products
- Air Brush application: RU311 (medium), RU312 (slow)



5. MIXING SG150

- 1 part SG150 Intercoat Pearl & Flake Karrier
- 1 part RU310, RU311 reducer
- (Refer to Tech Sheets on pearls, flakes, & other dry products for mixing ratios)
- Air Brush Application: 1 part Shimrin® base, 1 part RU311, RU312 reducer



NOTE: For some heavy Flakes we suggest decreasing the mixing ratio to 2 parts SG150 to 1 part RU Reducer. This will greatly help the suspension of the mixed flake.

Stir SG150 prior to use, as a separation of ingredients will occur.

• **NOTE:** Use fast drying reducer RU310, or as fast a dry as your conditions allow. For large flakes a slower reducer can improve lay down.

• **NOTE:** SG150 Intercoat Pearl & Flake Karrier is a base coat resin system, DO NOT ADD CATALYST. **See tech sheet for more information on reducers.**

6. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.8
(Depending on the size of object being painted)
- Trigger Pull = 75% to 100%
- Air Brush = Follow gun manufacturer's recommendations



7. APPLYING SG150

Apply 1 to 3 coats of SG150 Intercoat Pearl & Flake Karrier with 75% spray pattern overlap. Gun distance while spraying should be approximately 4 to 6 inches. Do not tape or scuff directly over the SG150. This will discolor the pearl or flake. Allow 15 to 60 minutes flash time between coats. If you intend to do tape outs or allow the SG150 to sit more than 4 hours before applying top coat clear or candy, apply 1 or 2 coats of SG100 Intercoat Clear to protect the pearl and flake (**see tech sheet on SG100**).



SG150 FLASH TEST - SG150 WILL DRY TO A SEMI-GLOSS AND FEEL DRY TO THE TOUCH.

NOTE: DO NOT APPLY MORE THAN 4 COATS OF SG150. It is not designed for hi-build.

8. DRY TIME

Allow 60 minutes (but not longer than 4 hours) dry time before Candy or clear is applied. If you anticipate the SG150 to sit 4 hours or longer, apply 1 to 2 coats of SG100. (**REFER TO SG100 TECH SHEET**)



SG150 FLASH TEST - SG150 WILL DRY TO A SEMI-GLOSS AND FEEL DRY TO THE TOUCH. Monitor closely for maximum merging of coats.

9. CLEAN UP

Clean equipment thoroughly with lacquer thinner, acetone, or urethane reducer (check local regulations).



USG100 INTERCOAT BARRIER KLEAR



GENERAL INFORMATION

USG100 Intercoat Barrier Klear is a two-component acrylic urethane base intercoat clear that was designed to offer protection if a light solvent wipe is required, when applied over House Of Kolor® Shimrin® basecoats when used for artistic effects. With the application of 2 medium coats, the USG100 will typically cure in 3 to 4 hours (depending upon shop conditions), and is ready for sanding, tape outs, and the application of artwork and pinstripes. In the event there are errors made such as mis-tapes, or striping mishaps, a light solvent wipe using **KC10 WAX AND GREASE REMOVER ONLY** can be done to remove these mistakes without effecting the base coat or previous artwork under the USG100. The USG100 has demonstrated an ability to prevent bleed through with some of our kandy colors.

IMPORTANT NOTES

- **DO NOT USE USG100 AS A BUILDUP OR TOPCOAT CLEAR, THIS IS AN ACTIVATED BASE COAT MATERIAL!** USG100 is designed to protect base coats for artwork, pin striping and tape outs only.
- **DO NOT USE USG100 AS A CARRIER FOR PEARLS, FLAKES, OR KANDY KONCENTRATES.**
- **DO NOT USE RU REDUCER AS A SOLVENT WIPE. USE ONLY KC10 AS A WIPE DOWN AGENT, FOLLOWED WITH KC20 POST SANDING CLEANER AS A FINAL WIPE TO REMOVE ANY SOLVENT RESIDUE LEFT BY THE KC10. REMEMBER THE KEY WORD IS A LIGHT SOLVENT WIPE DOWN, DO NOT OVER WET THE SURFACE.**
- **ON OCCASION, YOU MAY EXPERIENCE IMPRINTING OF THE PIN STRIPE OR GRAPHIC. A LIGHT SCUFFING WITH A SCUFF PAD WILL REMOVE THESE.**
- **ALWAYS DO A TEST TO INSURE THE USG100 HAS PROPERLY CURED PRIOR TO DOING A SOLVENT WIPE DOWN WITH KC10 OVER THE ARTWORK.**



1. SUBSTRATE

- All Shimrin® Bases
 - Properly cured and prepared topcoat clears and OEM finishes (artwork only)
- NOTE:** USG100 should never be used directly over Marblizers. Only use SG100 first. USG100 can then be used over the SG100.



2. PREPARATION

Prior to applying USG100 Intercoat Barrier Klear, it is advised to wipe down the Shimrin® Base with a tack free cloth, or if needed, with KC20 Post Sanding Cleaner.



3. COMPONENTS

- USG100 Intercoat Barrier Klear
- RU310 (fast), RU311 (medium) urethane reducer,
- KU100 Catalyst
- Not recommended for Air Brush application



4. MIXING USG100 INTERCOAT Barrier Klear

- 3 part USG100 Intercoat Barrier Klear
- 1 part KU100 Catalyst
- 1 part RU- reducer
- Stir USG100 prior to use, as a separation of ingredients will occur.
- Pot Life: 1 Hour

NOTE: Use as fast a reducer as your shop conditions will allow.



5. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



6. APPLYING SG100 INTERCOAT CLEAR

Apply 2 medium coats of USG100 Intercoat Barrier Klear at a 50% pattern overlap. Gun distance should be 4" to 6" from object being sprayed. Allow 4 to 6 minutes between coats depending on shop conditions. Use the string test, the finish should feel tacky but not stringing to your finger. Do not allow the USG100 to go out of tack between coats as lifting may occur and ruin all your hard work. DO NOT DRY SPRAY USG100, this will cause possible lifting and the loss of integrity of the finish.

NOTE: Do not attempt to improve the flow out of USG100 by applying medium wet or full wet coats or applying more than 2 coats. This will greatly slow down the cure time and its ability to be sanded and taped over within the recommended 3 to 4 hour time period. REMEMBER, this is a catalyzed base coat material designed to be used as a barrier protectant of your base coats and artwork, not as a buildup or top coat clear. Flow out and build is not at issue at this stage of your paint job.



7. DRY TIME

Allow the USG100 to cure for 3 to 4 hours (depending on shop conditions) prior to sanding or applying artwork. USG100 can be force dried at 140 degrees for 20 minutes. All tests and evaluations are based at 70 degrees with adequate air movement.



8. SANDING

USG100 Intercoat Barrier Klear MUST be sanded prior to tape outs for artwork or pin striping.



- Dry Sanding – 320P to 400P Grit DA Paper
- Wet Sanding – 500 to 600 Grit paper
- Maroon Scuff Pad for small or difficult to reach areas.

IMPORTANT NOTE: Be very careful not to sand through and into the base coat underneath the USG100. This could lead to edge lifting when top coating the USG100 Intercoat Barrier Klear.



9. INTENDED USE AS A BARRIER AGAINST KANDY BLEED THROUGH

Some Kandy colors are known to be bleeders. Apply 2 coats of USG100 as outlined above. Wet sand the clear. If you notice any color in the sanding residue, you will need to reapply additional coats of USG100 until the sanding residue shows white.

10. CLEAR COAT

USG100 Intercoat Barrier Klear must be top coated with House Of Kolor's Kosmic Kolor® UCC01, UC35, UFC35, or UFC19 Clear Coats.



11. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



GENERAL INFORMATION

Kosmic Urethane Flo-Klear UFC35 is a National Rule and SCAQMD Rule 1151 compliant product. See mixing directions below. UFC35 may be used to topcoat any of our Kosmic Kolor® urethane or polyurethane enamel finishes, or any of our Shimrin® Base Coats. UFC35 is a medium solids Klear that has application properties similar to conventional Klear UFC01. UFC35 features excellent flow out for better D.O.I... (Distinctness of Image), ultra-high gloss, good chemical and water resistance, good abrasion, and stone bruise resistance, is extremely flexible and polishes, and buffs easily.



1. PREPARATION

Read "TECH REP" thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



2. SUBSTRATE

- Shimrin® Base Coats
- UK Kandy's
- Properly cured and prepared OEM finishes



3. SANDING THE SUBSTRATE

- UK's and Shimrin® Base Coats,
 - See tech sheets on UK Kandy's and Shimrin® Base Coats
- OEM Finishes
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon scuff pad



4. COMPONENTS

- UFC35 Kosmic Urethane Flo-Klear
- RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) urethane reducer, RU300 Exempt Reducer (California only)
- KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush application: Not recommended



5. MIXING UFC35 FLO-KLEAR (MIX ONLY WHEN READY TO SPRAY)

- 2 parts Kosmic Urethane Flo-Klear
- 1 part RU- reducer
- 1 part KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush Application: Not recommended

For National Rule compliance:

For a 3.5 VOC National Rule compliant Klear, mix 2 parts UFC35 Flo-Klear to 1 part KU150 or KU151 Exempt Catalyst to 1 part Kosmic Reducer. Mix well. Reduce only with Kosmic Reducers. Use a reducer best suited to your shop conditions.

For a 4.2 VOC National Rule compliant Klear, mix 2 parts UFC35 Flo-Klear to 1 part KU100 or KU151 Exempt Catalyst to 1 part Kosmic Reducer. Mix well. Reduce only with Kosmic Reducers. Use a reducer best suited to your shop conditions. **See tech sheet for more information on reducers.**

For SCAQMD Rule 1151 compliance:

For a 0.57 VOC SCAQMD Rule 1151 compliant Klear, mix 2 parts UFC35 Flo-Klear to 1 part KU150 or KU151 Exempt Catalyst to 1 part RU300 Exempt Reducer. Mix well. Must reduce with RU300 to remain at 0.57 VOC.

For a 1.90 VOC SCAQMD Rule 1151 compliant Klear, follow directions above except in place of RU300 use a 70% by volume RU300/ 30% by volume Kosmic Reducer blend. **See tech sheet for more information on reducers.**

NOTE: UFC35 has a pot life of 3 hours at 70°F. Shop conditions can vary pot life.

NOTE: We have designed specific Catalysts to work with each of our clears. Use only the Catalyst specified for the specific Klear you are using. Never use another company's Catalyst in our products.

NOTE: KU150 and KU151 Exempt Catalysts are moisture sensitive and will not keep for long periods once opened. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the Catalyst container's pour spout by wiping the threads with reducer for easy reopening.



6. GUN SET UP

- Conventional Gun = 55 to 65 PSI
- HVLP Gun = 10 PSI at the cap
 - (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
 - (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush: Not recommended



7. APPLYING UFC35 FLO-KLEAR

First coat should be a medium wet coat with gun close. Apply 2-3 wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats.

URETHANE FLASH TEST- PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.

When using the flash test, always touch a new spot. Monitor closely for maximum merging of coats.

NOTE: Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 24 hours before sanding and re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material such as UFC35 may lift when basecoats are applied. Mask carefully to prevent this over spray when painting door jambs, etc. If basecoats are applied over UFC35, a 24-hour dry time at 70°F is required, then wet sand (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Use Fast Reducer, allow Flash between coats to prevent lifting.



8. DRY TIME

- Air dry at 70°F = 24 hours
- Force dry at 140°F = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, etc., it is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.



9. COLOR SANDING

IF NOT FLOW COATING, GO TO STEP 11 POLISHING. After clear coats have cured, (approximately 24 hrs.), color sand wet (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go; soap residue can bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 Post Sanding Cleaner if contaminated.

NOTE: Avoid touching the vehicle with your bare hand as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE KLEAR AND RUIN ALL THAT YOU HAVE DONE. Look for colored water, this will indicate you sanded through the clear.



10. FLOW COATS (optional)

RE-TAPING THE VEHICLE, AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using UFC35 mixed at 2-1-1.5 (30% to 50% additional RU300 reducer to a premixed quart of clear) works best for flow coats. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Keep gun close and wet it out, use a 50% pattern overlap. Allow flash time between coats. For improved hardness the next day, add 1 extra oz. of KU150 or KU151 Exempt Hi Temp Flo-Catalyst per mixed quart of clear.

UFC35 KOSMIC URETHANE FLO-KLEAR (continued)

10. FLOW COATS (optional) (continued)

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles. Polish after 24-48 hours. UFC35 polishes easy after cure time.



NOTES

11. FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**



12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



ADDITIONAL INFORMATION

When clear coating UFB04 Jet Set Black: mix equal amounts of UFB04 and UFC35 Kosmic Urethane Flo-Klear, then catalyze with KU150 and reduce as usual, for improved gloss and jetness.



GENERAL INFORMATION

UFC19 URETHANE KOMPLY KLEAR® II is a 1.9 VOC polyurethane clear coat with application properties of low solids clear coats such as UFC01. UFC19 is 33% solids as applied and buffs easily the next day. UFC19 delivers the low VOC needed for air quality regulations yet handles like conventional clear coats currently used. Komply Klear® II may be used to topcoat any of our Kosmic Kolor® urethane or polyurethane enamel finishes, or any of our Shimrin® Base coats. UFC19 features excellent gloss, long flow out, very good D.O.I., (Distinctness of Image), and good chemical and water resistance. UFC19 has excellent weathering and ultraviolet resistance, and easily color sands and polishes from 24 up to 72 hours.



1. PREPARATION

Read "TECH REP" thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



2. SUBSTRATE

- Shimrin® Base Coats
- UK Kandys
- Properly cured and prepared OEM finishes



3. SANDING THE SUBSTRATE

- UK's and Shimrin® Base Coats,
 - See tech sheets on UK Kandys and Shimrin® Base Coats
- OEM Finishes
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon scuff pad



4. COMPONENTS

- UFC19 Urethane Komply Klear® II
- RU300 Exempt Reducer only
- KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush application: Not recommended



5. MIXING KOMPLY KLEAR® II (MIX ONLY WHEN READY TO SPRAY)

- 2 parts UFC19 Urethane Komply Klear® II
- 1 part KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- 1 part RU300 Reducer
- Air Brush Application: Not recommended

Mix well. Pot life is approximately 3 hours depending on shop conditions.

NOTE: No reducer other than RU300 VOC Exempt Reducer can be used to remain at 1.9 VOC.

NOTE: AX01 Accelerator may be used to speed up flash times.

NOTE: We have designed specific catalysts to work with each of our clears. The catalysts are NOT interchangeable. Use only the catalyst specified for the specific clear you are using.

NOTE: KU150 & KU151 Exempt Catalysts are moisture sensitive and will not keep for long periods once opened. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.



6. GUN SET UP

- Conventional Gun = 55 to 65 PSI
- HVLP Gun = 10 PSI at the cap
 - (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
 - (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not recommended



7. APPLYING KOMPLY KLEAR® II (UFC19)

Apply one medium wet coat with 50% pattern overlap, wait approximately 5-10 minutes (do "URETHANE FLASH TEST" below). Follow with a full wet coat, wait approximately 10-15 minutes. Allow flash time between coats (do "URETHANE FLASH TEST" below). Apply a second wet coat. Gun distance while spraying should be approximately 6 inches.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.

(When using the flash test, always touch a new spot.) Monitor closely for maximum merging of coats.



7. APPLYING KOMPLY KLEAR® II (continued)

Dry time between coats is approximately 10-20 minutes depending on shop conditions. High heat or high humidity conditions will accelerate cure time. Always check dry time using the string test.

CAUTION: Too long a wait between coats can cause wrinkling or lifting. Also too fast a re-coat can cause pinholes or solvent popping during cure. If excessive dry time has elapsed and clear coat feels dry to touch, allow 24 hours before sanding and re-coating to avoid lifting problems.



8. DRY TIME

- Air dry at 70°F = 24 hours
- Force dry at 140°F = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, etc. It is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured, it indicates the finish is holding solvents and will need additional time to fully harden.



9. COLOR SANDING

IF NOT FLOW COATING, GO TO STEP 11 POLISHING. After clear coats have cured, (approximately, 24 hrs.), color sand wet (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, soap residue can bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 Post Sanding Cleaner if contaminated.

NOTE: Avoid touching the vehicle with your bare hand as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE KLEAR AND RUIN ALL THAT YOU HAVE DONE. Look for colored water, this will indicate you sanded through the clear.



10. FLOW COATS (optional)

RE-TAPING THE VEHICLE, AFTER COLOR SANDING, WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using UFC19 mixed at 2-1-1.5 (30% to 50% additional RU300 reducer to a premixed quart of clear) works best for flow coats. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Keep gun close and wet it out, use a 50% pattern overlap. Allow flash time between coats. For improved hardness the next day, add 1 extra oz. of KU150 Exempt Catalyst per mixed quart of clear.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles. Polish after 24-48 hours.



11. FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**



12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

UC35 KOSMIC ACRYLIC URETHANE KLEAR

GENERAL INFORMATION

UC35 Kosmic Acrylic Urethane Klear is a 3.5 VOC for national rule or 0.50 VOC SCAQMD Rule 1151 compliant version. UC35 may be used to topcoat any urethane enamel finish, including all Shimrin® Base Coats. UC35 is medium solids, 30% solids as applied, and has the same application properties of conventional clear coats. UC35 features excellent gloss and D.O.I. (Distinctness Of Image). It has good chemical, fuel and water resistance, and excellent weathering and ultraviolet resistance. UC35 dries fast and hard and may be colored sanded and buffed the next day.

NOTE: UC35 IS THE PREFERRED CLEAR FOR USE ON MOTORCYCLES. BECAUSE OF ITS HIGHER ACRYLIC CONTENT, IT IS FASTER CURING, AND ALSO HAS BETTER RESISTANCE TO FUEL SPILLS.

1. PREPARATION

Read "TECH REP" thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



2. SUBSTRATE

- Shimrin® Base Coats
- UK Kandys
- Properly cured and prepared OEM finishes



3. SANDING THE SUBSTRATE

- UK's and Shimrin® Base Coats,
 - See tech sheets on UK Kandys and Shimrin® Base Coats
- OEM Finishes
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon scuff pad



4. COMPONENTS

- UC35 Kosmic Acrylic Urethane Klear
- RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) urethane reducer, RU300 Exempt Reducer (California only)
- KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush application: Not recommended



5. MIXING UC35 KOSMIC URETHANE KLEAR (MIX ONLY WHEN READY TO SPRAY)

- 2 parts Kosmic Acrylic Urethane Klear
- 1 part KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- 1 part RU- Reducer
- Air Brush Application: Not recommended



For National Rule Compliance:

For a 3.5 VOC National Rule compliant Klear use RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) reducers. **REDUCE ONLY WITH KOSMIC REDUCERS.** Use a reducer best suited to your shop temperature.

See tech sheet for more information on reducers.

For SCAQMD Rule 1151 Compliance:

For a 0.50 VOC SCAQMD Rule 1151 compliant Klear, use RU300 exempt reducer. **MUST REDUCE WITH RU300 TO REMAIN AT 0.50 VOC. See tech sheet for more information on reducers.**

For a 1.90 VOC SCAQMD Rule 1151 Compliant Klear, follow directions above except in place of RU300 use a 70% by volume RU300 / 30% by volume Kosmic Reducer blend. **See tech sheet for more information on reducers.**

NOTE: UC35 has a pot life of approximately 2 hours at 70°F.

NOTE: For extra flow out, add up to 10% of RU300 VOC Exempt Reducer per mixed quart of clear.

NOTE: We have designed specific Catalysts to work with each of our clears. These Catalysts are NOT interchangeable. Use only the Catalyst specified for the specific clear you are using.

NOTE: KU150 and KU151 Exempt Catalysts are moisture sensitive and will not keep for long periods once open. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.

6. GUN SET UP

- Conventional Gun = 55 to 65 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not recommended



7. APPLYING KOSMIC KLEAR (UC35)

Apply 2-3 medium wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.

(When using the flash test, always touch a new spot.) Monitor closely for maximum merging of coats.

NOTE: Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material (such as our UB04, UB05, UK Kandys, UC35 Klear or UFC19 Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.



8. DRY TIME

- Air dry at 70°F = 24 hours
- Force dry at 140°F = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, and flash time between coats, etc., it is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.



9. COLOR SANDING

IF NOT FLOW COATING, GO TO STEP10 POLISHING

After clear coats have been cured overnight (12-24 hours), color sand wet

(PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS). Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue doesn't bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 or warm water.

NOTE: Avoid touching the vehicle with your bare hands as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE KLEAR AND RUIN ALL YOU'VE DONE.



10. FLOW COATS (optional)

RE-MASKING THE VEHICLE AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using 4-6 ounces of extra RU300 VOC Exempt reducer per mixed quart of clear. The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Allow flash time between coats. (For improved hardness the next day, add 1 extra ounce of KU150 or KU151 VOC Exempt Catalyst to this mixture) per mixed quart.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles.





11. FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- ***See tech sheet for information on Polishing & Finishing.***



12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

ADDITIONAL INFORMATION

When clear coating UB04 Jet Set Black mix equal amounts of UB04 and UC35 Kosmic Acrylic Urethane Klear, then catalyze and reduce as usual for improved gloss and jetness.

NOTES

UCC01 KOSMIC ACRYLIC URETHANE KUSTOM KLEAR

GENERAL INFORMATION

Kosmic Acrylic Urethane Kustom Klear UCC01 may be used to topcoat any urethane enamel finish, including all Shimrin® Base Coats. UCC01 is a tough clear coat, has ultra wet gloss, is crack proof and resists gas spills and most racing fuels. Stones bounce off without chipping. UCC01 contains sunscreen agents to preserve the color below. One coat equals 2 or 3 coats of lacquer. Higher solids than others, UCC01 can be over-reduced. UCC01 dries fast and may be buffed the next day.



1. PREPARATION

Read "TECH REP" thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



2. SUBSTRATE

- Shimrin® Base Coats
- UK Kandys
- Properly cured and prepared OEM finishes



3. SANDING THE SUBSTRATE

- UK's and Shimrin® Base Coats,
 - See tech sheets on UK Kandys and Shimrin® Base Coats
- OEM Finishes
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon scuff pad



4. COMPONENTS

- UCC01 Kosmic Acrylic Urethane Kustom Klear
- RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) urethane reducer
- KU150 or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush application: Not recommended



5. MIXING KOSMIC ACRYLIC URETHANES (MIX ONLY WHEN READY TO SPRAY)

- 2 parts UCC01 Kosmic Acrylic Urethane Kustom Klear
- 1 part KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- 1 part RU- reducer
- Air Brush Application: Not recommended



REDUCE ONLY WITH KOSMIC REDUCERS. Use a reducer best suited to your shop temperature. **See tech sheet for more information on reducers.**

NOTE: UCC01 has a pot life of approximately 2 hours at 70°F (shop conditions will vary pot life).

NOTE: For extra flow out add 3 ounces of additional reducer per mixed quart of clear.

NOTE: We have designed specific Catalyst to work with each of our clears. These Catalysts are NOT interchangeable. Use only the Catalyst specified for the specific clear you are using.

NOTE: KU150 & KU151 Exempt Catalysts are moisture sensitive and will not keep for long periods once opened. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.

6. GUN SET UP

- Conventional Gun = 55 to 65 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not recommended



7. APPLYING UCC01 KLEAR

Apply 2 to 3 wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Air pressure varies, use Gun Mfgs. recommendation for fluid tip size and air pressure. Allow flash time between coats.



URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.

(When using the flash test, always touch a new spot).

Monitor closely for maximum merging of coats.

7. APPLYING UCC01 KLEAR (continued)

NOTE: Too long a wait between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material (such as our UB04, UB05, UK Kandys, UCC01 Klear or UFC01 Flo-Klear) may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.



8. DRY TIME

- Air dry at 70°F = 24 hours
- Force dry at 140°F = 30 minutes flash time, 2 hours bake, with 1 hour cool down.



NOTE: Based upon weather conditions, number of coats, solvent speed, etc. It is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.

9. COLOR SANDING

IF NOT FLOW COATING, GO TO STEP 11 FINISHING & POLISHING

After clear coats have been cured overnight (12-24 hours), color sand wet **(PLEASE REFER TO SANDING GRIT RECOMMENDATIONS PG 59 FOR URETHANE CLEARS)**. Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue doesn't bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended.) Use clean rags and KC20 or warm water.



NOTE: Avoid touching the vehicle with your bare hands as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE KLEAR AND RUIN ALL YOU'VE DONE.

10. FLOW COATS (optional)

RE-MASKING THE VEHICLE AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using 4-6 ounces of extra RU reducer per mixed quart of clear. The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Allow flash time between coats. (For improved hardness the next day, add 1 extra ounce of KU150 or KU151 Catalyst to this mixture) per mixed quart.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles.



11. FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**



12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



ADDITIONAL INFORMATION

MATERIAL VOC: 2.76 LBS./GAL. (331 g/L)

COATING VOC: 3.87 LBS./GAL. (464 g/L)

When clear coating UB04 Jet Set Black mix equal amounts of UB04 and UCC01 Kosmic Acrylic Urethane Kustom Klear, then catalyze and reduce as usual for improved gloss and jetness.

UC01 KOSMIC ACRYLIC URETHANE KLEAR (for sale outside of the US only)

GENERAL INFORMATION

Kosmic Acrylic Urethane Klear UC01 may be used to topcoat any urethane enamel finish, including all Shimrin® Base Coats. UC01 is a tough clear coat, has ultra wet gloss, is crack proof and resists gas spills and most racing fuels. Stones bounce off without chipping. UC01 contains sunscreen agents to preserve the color below. One coat equals 2 or 3 coats of lacquer. Higher solids than others, UC01 can be over-reduced. UC01 dries fast and may be buffed the next day.



1. PREPARATION

Read "TECH REP" thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



2. SUBSTRATE

- Shimrin® Base Coats
- UK Kandys
- Properly cured and prepared OEM finishes



3. SANDING THE SUBSTRATE

- UK's and Shimrin® Base Coats,
 - See tech sheets on UK Kandys and Shimrin® Base Coats
- OEM Finishes
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon scuff pad



4. COMPONENTS

- UC01 Kosmic Acrylic Urethane Klear
- RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) urethane reducer
- KU100 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush application: Not recommended



5. MIXING KOSMIC URETHANE ENAMELS (MIX ONLY WHEN READY TO SPRAY)

- 2 parts UC01 Kosmic Acrylic Urethane Klear
- 1 part KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- 1 part RU- Reducer
- Air Brush Application: Not recommended



REDUCE ONLY WITH KOSMIC REDUCERS. Use a reducer best suited to your shop temperature. **See tech sheet for more information on reducers.** **NOTE:** UC01 has a pot life of approximately 2 hours at 70°F (shop conditions will vary pot life).

NOTE: For extra flow out add 3 ounces of additional reducer per mixed quart of clear.

NOTE: We have designed specific Catalyst to work with each of our clears. These Catalysts are NOT interchangeable. Use only the Catalyst specified for the specific clear you are using.

NOTE: KU100 & KU151 Catalysts are moisture sensitive and will not keep for long periods once opened. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.

6. GUN SET UP

- Conventional Gun = 55 to 65 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not recommended



7. APPLYING UC01 KLEAR

Apply 2 to 3 wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Air pressure varies, use Gun Mfgs. recommendation for fluid tip size and air pressure. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.

(When using the flash test, always touch a new spot).

Monitor closely for maximum merging of coats.



7. APPLYING UC01 KLEAR (continued)

NOTE: Too long a wait between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material (such as our UB04, UB05, UK Kandys, UC01 Klear or UFC01 Flo-Klear) may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jams, etc.



8. DRY TIME

- Air dry at 70°F = 12 hours for recoats
- Force dry at 140°F = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, etc. It is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.



9. COLOR SANDING

IF NOT FLOW COATING, GO TO STEP 11 FINISHING & POLISHING

After clear coats have been cured overnight (12-24 hours), color sand wet **(PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS)**. Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue doesn't bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended.) Use clean rags and KC20 or warm water.



NOTE: Avoid touching the vehicle with your bare hands as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE KLEAR AND RUIN ALL YOU'VE DONE.

10. FLOW COATS (optional)

RE-MASKING THE VEHICLE AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using 4-6 ounces of extra RU reducer per mixed quart of clear. The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Allow flash time between coats. (For improved hardness the next day, add 1 extra ounce of KU100 or KU151 Catalyst to this mixture) per mixed quart.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles.



11. FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**



12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



ADDITIONAL INFORMATION

When clear coating UB04 Jet Set Black mix equal amounts of UB04 and UC01 Kosmic Acrylic Urethane Klear, then catalyze and reduce as usual for improved gloss and jetness.



GENERAL INFORMATION

UFC01 Kosmic Urethane Flo-Klear may be used to topcoat any of our Kosmic Kolor® urethane or polyurethane enamel finishes, or any of our Shimrin® Base Coats. UFC01 features excellent flow out for better D.O.I. (Distinctness of Image), ultra high gloss, improved chemical and water resistance, 38% solids for faster build, better abrasion and stone bruise resistance, is extremely flexible and polishes easily. UFC01 Flo-Klear is very resistant to salt, so it would be an excellent choice for Jet Skis or boats used in salt water. However, it is not recommended for continual immersion in fresh or salt water.



1. PREPARATION

Read "TECH REP" thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



2. SUBSTRATE

- Shimrin® Base Coats
- UK Kandys
- Properly cured and prepared OEM finishes



3. SANDING THE SUBSTRATE

- UK's and Shimrin® Base Coats,
 - See tech sheets on UK Kandys and Shimrin® Base Coats
- OEM Finishes
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon scuff pad



4. COMPONENTS

- UFC01 Kosmic Urethane Flo-Klear
- RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) urethane reducer
- KU100 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush application: Not recommended



5. MIXING UFC01 FLO-KLEAR (MIX ONLY WHEN READY TO SPRAY)

- 2 parts Kosmic Urethane Flo-Klear
- 1 part KU100 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- 1 part RU- Reducer
- Air Brush Application: Not recommended

REDUCE ONLY WITH KOSMIC REDUCERS. Use a reducer best suited to your shop temperature. **See tech sheet for more information on reducers.**

NOTE: UFC01 has a pot life of 2 to 3 hours at 70°F (Shop conditions may vary pot life).

NOTE: For extra flow out add 1 or 2 ounces of additional reducer per mixed quart of clear.

NOTE: We have designed specific Catalyst to work with each of our clears. These Catalysts are NOT interchangeable. Use only the Catalyst specified for the specific clear you are using.

NOTE: KU100 & KU151 Catalysts are moisture sensitive and will not keep for long periods once opened. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.



6. GUN SET UP

- Conventional Gun = 55 to 65 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not recommended



7. APPLYING UFC01 FLO-KLEAR

Apply 2 to 3 wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING. WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED. (When using the flash test, always touch a new spot). Monitor closely for maximum merging of coats.



7. APPLYING UFC01 FLO-KLEAR (continued)

NOTE: Too long a wait between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before re-coating to avoid lifting problems. UFC01 is less sensitive than UC01 to lifting.

NOTE: Over spray from any catalyzed topcoat material (such as our UB04, UB05, UK Kandys, UC01 Klear or UFC01 Flo-Klear) may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jams, etc.



8. DRY TIME

- Air dry at 70°F = 12 hours for recoats
- Force dry at 140°F = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, etc. It is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.



9. COLOR SANDING

IF NOT FLOW COATING, GO TO STEP 11 POLISHING

After clear coats have been cured overnight (12-24 hours), color sand wet **(PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS)**. Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue doesn't bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 or warm water.

NOTE: Avoid touching the vehicle with your bare hands as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE KLEAR AND RUIN ALL YOU'VE DONE.



10. FLOW COATS (optional)

RE-MASKING THE VEHICLE AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using 4-6 ounces of extra RU reducer per mixed quart of clear. The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Allow flash time between coats. (For improved hardness the next day, add 1 extra ounce of KU100 or KU151 Catalyst to this mixture) per mixed quart.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles.



11. FINISHING AND POLISHING

- In a 70°F shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**

ADDITIONAL INFORMATION

When clear coating UFBO4 Jet Set Black: mix equal amounts of UFBO4 and UFC01 Kosmic Urethane Flo-Klear, then catalyze and reduce as usual, for improved gloss and jetness.



12. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

SC01 KOSMIC KOLOR® SUNSCREEN ACRYLIC LACQUER CLEAR

GENERAL INFORMATION

Kosmic Kolor® SC01 Sunscreen Clear may be used to topcoat any of our acrylic lacquer finishes or any of our Shimrin® Base Coats. SC01 may also be used over the Shimrin® Base Coats to protect them from artwork tape outs, when the vehicle is to be top coated with acrylic lacquers.



SC01 Sunscreen Clear

Kosmic Kolor® SC01 Sunscreen Clear was designed to live in the thick paint films common to custom painting. Only the best raw materials are used, with special ingredients to resist sun fade, cold-cracking, gas spills, and bird droppings. SC01 Sunscreen Clear is one of the most chip-resistant acrylic lacquer clears on the market and is also a high-solids lacquer clear.

SC01 Clear has proven itself since 1965, both in the upper Midwest (with 40°F below zero conditions) and in southern Florida (100°F plus temperatures). SC01 features high gloss, even before rubbing, and UV protection. SC01 Sunscreen Clear contains the maximum allowable amounts of UV absorber to protect your paint job from the most damaging rays of the sun. A must for acrylic lacquer finishes. We have seen lacquer Kandy finishes 12 to 14 years old and still looking great when SC01 is used as a topcoat clear. SC01 is excellent for colored pearls, too.

CAUTION: Do not use SC01 over whites or very light colors as a slight yellowing is possible due to the ingredients used for UV protection.

1. MIXING SC01 SUNSCREEN CLEAR

Thin SC01 Sunscreen Clear 150% (1 part clear to 1-1/2 parts Kustom Thinner). THIN ONLY WITH OUR KUSTOM THINNERS (RU101 or RU202). Use a thinner best suited to your shop temperature. RU101 and RU202 may be intermixed for varying drying times. **See tech sheet for more information on thinners.**

Note: For Air Brush application reduce 200% (1 part paint to 2 part RU101 thinner)



2. GUN SET UP

- Conventional Gun = 35 to 45 PSI
- HVLP Gun = 8 to 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.4
(Depending on the size of object being painted)



3. APPLYING SC01 SUNSCREEN CLEAR

Apply 5 to 7 wet coats with 50% pattern overlap. Gun distance while spraying should be 6 to 8 inches. Allow flash time between coats (see "LACQUER FLASH TEST" below).

LACQUER FLASH TEST - PAINT SHOULD BE DRY TO THE TOUCH AT THE WETTEST POINT BEFORE THE NEXT COAT IS APPLIED.

NOTE: Flash time is important for proper solvent release, as entrapment of solvents may result in a rubbery final finish.

NOTE: Acrylic Lacquer has a critical re-coat time. Too long a dry time (over 48 hours) on re-coats may cause crazing. To extend the critical dry time an additional 48 hours, apply 1 to 2 additional coats of clear. When thoroughly dry, crazing is still possible if slow-dry thinners are used or if not enough dry time was allowed between coats.



4. COLOR SANDING

IF NOT FLOW COATING, GO TO STEP 6 POLISHING.

After clear coats have cured overnight (12 to 24 hours), color sand with 500 or 800P grit wet sandpaper. Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15 to 20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue does not bite the fresh paint. After sanding, wipe the vehicle with a clean rag and KC20 Post Sanding Cleaner. Wipe dry. Use a tack cloth to remove lint before re-coating. (Chemical washes at this stage are not recommended).

NOTE: Avoid touching the vehicle with your bare hands, as the oil from your skin may impair flow coats.

CAUTION: Do not sand through the clear and ruin all that you have done.

NOTE: Re-taping the vehicle after color sanding will give you a cleaner finish when flow coats are applied.



5. FLOW COATS

Apply two more coats of clear thinned 200 to 300%. (In hot, humid conditions, add 10 to 20% RU315 retarder to prevent blushing.)

-OR-

Perfectionist method (Reflow)

Apply one medium to light coat of clear thinned 200%, using a slow-dry thinner, then apply one wet coat. The medium coat tacks the surface, giving the wet coat that follows something to adhere to. A wet first coat may cause problems.

After the wet coat has flashed, thin the clear 200 to 300% and apply 1 wet coat. Check gun pattern as this much thinner usually means narrowing the gun pattern. A spray booth with good air movement is necessary for this method.

NOTE: If the shop temperature is below 75°F (or if you are not in a spray booth), DO NOT USE SLOW-DRY THINNER. Air movement is critical to remove the thinner during flow coats. Use a fast-dry thinner and allow plenty of time between coats to prevent crazing. (Use retarder only in a spray booth with shop temperatures over 75°F).



6. CLEAN UP

Clean equipment thoroughly using lacquer thinner or urethane reducer.



7. POLISHING

Wait 10 to 14 days before polishing.

See tech sheet for more information on Polishing & Finishing.





GENERAL INFORMATION

HOUSE OF KOLOR® QUALITY SHINES THROUGH

Make no mistake, there is a big difference in the quality of ingredients used in reducers and thinners. Some manufacturers, in an effort to cut costs, use inexpensive products and chemicals that have residual or long term release problems (often causing the paint to have a rubbery consistency for many weeks). Also these inexpensive ingredients cause reduced gloss or hazing of the final finish. This is particularly evident when paint is over reduced. With House of Kolor® Reducers and Thinners, no dulling occurs even when the paint is over reduced. Our quality shines through.

House of Kolor® uses only the finest ingredients. Our reducers and thinners leave the paint in stages for proper flow out and they retain the original gloss of the paint. We recommend that you use only our quality reducers and thinners with House of Kolor® products.

DO NOT USE OTHER COMPANIES HARDENERS, REDUCERS OR THINNERS IN OUR PRODUCTS.

REDUCERS

Reducers for Kosmic Kolor® Urethane Enamel & Shimrin® Universal Bases:

Kosmic Reducers - RU300 EXEMPT, RU310 FAST DRY, RU311 MEDIUM DRY, RU312 SLOW DRY, RU313 HIGH TEMP - are the only reducers we recommend for use with our Kosmic Kolor® Urethane Enamel system. Used in the base, Kandy and clear coats, our reducers allow for:

- excellent sprayability
- good flow out and leveling
- fast staged release
- retention of gloss when dry

NOTE: Even with over reduction, the paint retains its gloss. Other reducers may cause dulling. This is especially true when any amount of over reduction has been attempted to even metallics or increase flow out. Choice of reducer is dependent on three factors:

1. size of object being painted
2. shop temperature and humidity
3. air movement within the spray booth

**The following chart is for spray booth application only.
When not using a spray booth, use the next fastest reducer.**

Our reducers are not cross referenced by any other paint company.

RU300	RU310	RU311	RU312	RU313
70 - 80°F	65 - 75°F	75 - 85°F	85 - 95°F	95 - 110°F
Exempt reducer to meet VOC regulations	Generally used on smaller objects for touch-ups, on larger objects, and with Intercoat Clear to speed dry time.	Most commonly used reducer. Used for small objects in temperatures above 85°F or for larger objects in spray booth temperatures of 75 - 85°F.	Used for blending bases or Kandys and for larger objects. Also used in warm, humid conditions to increase flow time and leveling.	Used for blending bases or Kandys and for very larger objects. Also used in very warm, humid conditions to increase flow time and leveling. In extremely hot & humid conditions, use RU315 Retarder (up to 10% by volume to slow dry time even more).

NOTE: Use RU315 Retarder to slow dry times or for force drying.

NOTE: Use RU315 Retarder Sparingly. This is an additive, not a reducer.

NOTE: These reducers may also be intermixed for varying conditions. DO NOT MIX KOSMIC REDUCERS WITH REDUCERS MADE BY OTHER MANUFACTURERS. Regardless of what others say, our reducers are not cross-referenced by any other paint company.

THINNERS

Thinners for Kustom Kolor® Acrylic Lacquers:

Kustom Thinners 101 HI-GLOSS and 202 FAST DRY are the finest thinners you can buy at any price. The thinner carries the paint to the surface, then evaporates from the paint film. The way the thinner leaves the film determines the flow, tack free time, consistency, shrinkage, leveling, dry time, tape time and final gloss. Choose the thinner best suited to your shop conditions and the size of the object to be sprayed.

Our thinners are not cross referenced by any other paint company.

RU101 HI-GLOSS	RU202 FAST DRY
SLOW DRY	FAST DRY
Shop Temperature Above 75°F	Shop Temperature Below 75°F
For large objects or in extreme hot or humid conditions. With slow dry thinner, proper air movement is necessary to pull the thinner from the paint.	For small objects or cool shop conditions.

NOTE: Use RU315 Retarder to slow dry times or for force drying.

NOTE: These thinners may also be intermixed for varying conditions. DO NOT MIX KUSTOM THINNERS WITH THINNERS MADE BY OTHER MANUFACTURERS.

MIXING

Always measure when mixing. There is little room for guess work in custom painting. For mixing ratios of reducers and thinners, refer to the individual product instructions.

ADDITIONAL INFORMATION

KOSMIC KOLOR® BASES, KANDYS & CLEAR COATS: Follow label instructions on reduction amounts. For increased flow out, add additional reducer. House of Kolor® paint products are thicker in the can than others and the additional reducer gives you more coverage per quart and also increases flow out. Usually 3 ounces per mixed quart is adequate.

SHIMRIN® UNIVERSAL BASES: Extra reducer should not be used in the Shimrin® Universal Bases. When Shimrin®'s are used with a complete lacquer paint job, they may be thinned with lacquer thinner (in place of Kosmic Reducer).

INTERCOAT CLEAR: Reducers in Intercoat Clear should be as fast as can comfortably be used. This will lesson dry time and allow artwork tape outs as soon as possible (usually within the hour, depending upon shop and weather conditions).

KOSMIC REDUCERS, THINNERS, & HARDENERS (continued)

THINNERS

Thinners for Kustom Kolor® Acrylic Lacquers:

Kustom Thinners 101 HI-GLOSS and 202 FAST DRY are the finest thinners you can buy at any price. The thinner carries the paint to the surface, then evaporates from the paint film. The way the thinner leaves the film determines the flow, tack free time, consistency, shrinkage, leveling, dry time, tape time and final gloss. Choose the thinner best suited to your shop conditions and the size of the object to be sprayed.

Our thinners are not cross referenced by any other paint company.

RU101 HI-GLOSS	RU202 FAST DRY
SLOW DRY	FAST DRY
Shop Temperature Above 75°F	Shop Temperature Below 75°F
For large objects or in extreme hot or humid conditions. With slow dry thinner, proper air movement is necessary to pull the thinner from the paint.	For small objects or cool shop conditions.

NOTE: Use RU315 Retarder to slow dry times or for force drying.

NOTE: These thinners may also be intermixed for varying conditions. DO NOT MIX KUSTOM THINNERS WITH THINNERS MADE BY OTHER MANUFACTURERS.

MIXING

Always measure when mixing. There is little room for guess work in custom painting. For mixing ratios of reducers and thinners, refer to the individual product instructions.

ADDITIONAL INFORMATION

KOSMIC KOLOR® BASES, KANDYS & CLEAR COATS: Follow label instructions on reduction amounts. For increased flow out, add additional reducer. House of Kolor® paint products are thicker in the can than others and the additional reducer gives you more coverage per quart and also increases flow out. Usually 3 ounces per mixed quart is adequate.

SHIMRIN® UNIVERSAL BASES: Extra reducer should not be used in the Shimrin® Universal Bases. When Shimrin®'s are used with a complete lacquer paint job, they may be thinned with lacquer thinner (in place of Kosmic Reducer).

INTERCOAT CLEAR: Reducers in Intercoat Clear should be as fast as can comfortably be used. This will lesson dry time and allow artwork tape outs as soon as possible (usually within the hour, depending upon shop and weather conditions).

HARDENERS

House of Kolor's Hardeners are specifically designed to be used in our urethane kandys, klears, and sealers. They're designed with the specific hydroxyl groups needed for proper cross-linking with our resins used in the manufacturing of our products.

NEVER USE OTHER MANUFACTURERS' HARDENERS WITH HOUSE OF KOLOR® PRODUCTS. THEY ARE NOT FORMULATED TO WORK WITH THE EXOTIC RESINS WE USE TO PRODUCE THE HIGH QUALITY KUSTOM FINISHES THAT ARE DESIGNED FOR THE EXTREME PERFORMANCE REQUIREMENTS OF KUSTOM FINISHING.

- KU100 Catalyst was designed for areas where VOC compliance is not an issue. It is a faster curing activator.
- KU150 Exempt Catalyst was designed to meet all VOC regulations. This is a medium curing activator.
- KU151 Exempt Hi-Temp Flo-Catalyst was designed to meet all VOC regulations. It is an excellent activator where high humidity and temperatures are present and also greatly improves flow out of our clears. This is an excellent choice where larger objects are being finished, as well as being used in the final flow coating of clears. This is a slower curing version of our KU150.

NOTE: With the exception of your sealer, never use a slower curing hardener in a finish or underneath a finish using a faster curing hardener.

Example: Using KU151 in the kandy and then KU100 in the clear. This could cause solvent to become trapped in the overall finish.

KU100 Catalyst	KU150 Exempt Catalyst	KU151 Exempt Hi-Temp Flo-Catalyst
• UK Kandy's • UC35 Klear (for 3.5 VOC compliance) • UFC35 Klear (for 4.3 VOC compliance) • UC01 Klear • UFC01 Flo-Klear	• UK Kandy's • UC35 Klear • UFC35 Klear • UFC19 Klear • UCC01 Klear • UC01 Klear • UFC01 Flo-Klear • Ko-Seal® II Sealers	• UK Kandy's • UC35 Klear • UFC35 Klear • UFC19 Klear • UCC01 Klear • UC01 Klear • UFC01 Flo-Klear

KNOW AND UNDERSTAND YOUR LOCAL VOC LAWS BEFORE CHOOSING THE REDUCERS AND HARDENERS THAT WILL BE USED IN YOUR PAINT JOB.

GENERAL INFORMATION

At last a fisheye additive that does not need to be used in every coat. Use KE170 to correct fisheye or crater defects. Works with lacquer, urethane, polyurethane, acrylic urethane, acrylic enamel, etc. A must have product for your paint shop.

NOTE: Do individual testing with other company's paint products.

CAUTION: May not correct major silicone contamination. In that case, use a silicone oil - which will be required throughout the job.



1. USING KRATOR ELIMINATOR (KE170)

Add 1/2 - 2 capfuls of KE170 Krator Eliminator per mixed quart.

Use only when necessary. Once the problem is corrected you do not need to continue using KE170.



NOTES

NOTE: KE170 is a very unique product that works in ALL coatings to reduce fisheyes.



GENERAL INFORMATION

Accelerator™ AX01 is a potent curing aid. Use Accelerator™ to speed dry time in cool shops on parts that must be handled (or sanded for artwork layouts) or re-coated the same day. Accelerator™ was designed for catalyzed acrylic urethanes and specific polyurethanes to speed up cure time. Accelerator™ can be added to any of the following Kosmic Kolor® products: UC01, UC35, UFC01, UFC19, UFC35, and UMC35 Klears; UB and UFB Solid Colors; SBS10 Bleed Check Sealer, and UK Kandys.



1. MIXING ACCELERATOR™ (AX01)

Use sparingly, up to 1/8 teaspoon per mixed quart.

DO NOT EXCEED 1/8 TEASPOON PER MIXED QUART.

Carefully monitor dry time between coats. Accelerator™ will cause the urethanes to flash between coats much faster and can cause lifting if allowed too much time between coats. Use the touch test:

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING UP ON FINGER AT THE WETTEST POINT, BEFORE NEXT COAT IS APPLIED.

Approximate time between coats is 5 minutes, depending upon your shop conditions.



ADDITIONAL INFORMATION

Use Accelerator™ only in the following Kosmic Kolor® products:

- UC01 Kosmic Acrylic Urethane Klear
- UC35 Kosmic Acrylic Urethane Klear
- UCC01 Kosmic Acrylic Urethane Kustom Klear
- UFC01 Kosmic Urethane Flo-Klear
- UFC19 Urethane Komply Klear® II
- UFC35 Kosmic Urethane Flo-Klear
- UMC35 Kos-Matte Klear
- UB and UFB Solid Colors
- UK Kandys
- SBS10 Bleed Check Sealer

NOTE: Do not use Accelerator™ in acrylic lacquers, or base coats.

NOTE: Use AX01 sparingly. It can reduce the coating's flexibility and deplete the UV absorber.

NOTES

GENERAL INFORMATION

Flattening Agent is designed to reduce the gloss of our acrylic lacquer, acrylic urethane and polyurethane enamel topcoats and clears. Flattening Agent will not effect adhesion or hardness. It is great for under carriages, frames and engine parts where high gloss is not desired, but a tough, durable finish is.



1. MIXING FLATTENING AGENT (FA01)

Shake or stir FA01 to ensure a uniform blend. Add while stirring to your pre-measured reducer then add this to your topcoat or clear. A drill and a paint stirring attachment ensure a uniform blend.



NOTE: Each product will react differently to FA01 based on the solid content of product used. Add additional reducer for proper sprayability. Amount of reducer is based on amount of FA01 added.

2. APPLYING FLATTENING AGENT (FA01)

Strain the paint into your paint gun. Use normal application methods based on the product you are spraying. Gloss reduction will begin as the paint dries. Dry overnight to show the true final level of gloss flattening.



NOTE: We recommend painting a test panel and allowing it to dry for 12 hours to determine the true final gloss flattening.

NOTES

GLOSS REDUCTION	OZ. PER MIXED QUART	ADDITIONAL REDUCER
10%	2 oz.	N/A
25%	4 oz.	1 oz.
60%	6 oz.	2 oz.
90%	8 oz.	2 oz.
95%	12 oz.	3 oz.
99%	16 oz.	4 oz.

NOTE: Large amounts of FA01 (8 oz. or more per "ready to spray" mixed quart) can cause reduction of flexibility, which should be considered before applying to flexible substrates. Do not exceed 16 oz. of FA01 per mixed quart. Adding more Flattening Agent beyond this point will have no effect on further gloss reduction.

DP, DR DRY PEARLS

PP PASTE PEARLS

KDP KOSMIC PEARLS

KOP KAMELEON® OPALS



GENERAL INFORMATION

Our Pearl Concentrates are available in paste or dry form and may be added to any of our acrylic lacquers or urethane enamels SG100 Intercoat Clear and SG150 Intercoat Pearl & Flake Karrier. They may also be added to first coats of Kandys when shooting over solid color bases. Design your own one of a kind custom paint. Additionally, Dry Pearls (DP, DR, KDP & KOP) can be added to the MB00 Neutral Marblizer® for custom marblizing effects.

KOSMIC PEARLS - MUST BE VIEWED IN SUNLIGHT TO SEE MAXIMUM EFFECT:

Kosmic Pearls are our newest pearl line that features greatly increased reflectivity, brightness and sparkle. Kosmic Pearls high intensity makes them a great choice to use over white bases or solid colors for eye catching effects in sunlight. KDP2001, 2002, 2005 and 2006 are great choices over white bases. KDP2003 and 2004 are richly colored pearls that can be used as base coats for creating new Kandy colors. Use Kosmic Pearls to create your own custom colors. All KDP Pearls can be added to acrylic lacquer, urethane, SG100 Intercoat Clear, SG150 Intercoat Pearl & Flake Karrier, and the MB00 Neutral Marblizer®.

KAMELEON® OPALS:

Kameleon® Opals represents some of the latest advancements in pearlescent and flake technology allowing radical color change from different viewing angles. These unique products are available as easy dispersing powders that can be added to House of Kolor® brand clears, pearl basecoats, and Marblizer® to create dazzling effects and exciting new colors. Available in eight amazing colors Kameleon® Opals is sure to add exciting new effects to your kustom coatings palette.

IMPORTANT NOTE

Bleeding from underneath is the most common problem when painting with pearls. Follow instructions carefully and protect yourself against failure. Good preparation is important for a quality, long lasting paint job.



1. PREPARATION

Read "TECH PREP" thoroughly before you begin painting. Pearls are very susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, please refer to the tech pages on KP2CF or KD2000 Epoxy Primer Surfacer.



2. GROUND COAT

- Sealer
- Base Coat
- Properly prepared OEM finishes

UNIFORM COVERAGE OF SEALER IS REQUIRED BEFORE APPLICATION OF BASE COAT. Use House of Kolor® Ko-Seal® II. Use a sealer closest to the base color for faster coverage of base coats. Follow label instructions. Allow flash time on sealer. **See tech sheet for more information on Ko-Seal® II.**

NOTE: Sealers will not prevent bleeding. Remember, sealer is not a cure all for poor preparation.

3. BASE COAT

Apply base coat. This step is where the creativity begins. White pearl will radiate whatever base color is used. For example: a white pearl over an orange base becomes orange pearl. Do your own experimenting - creativity begins at the base. **See appropriate tech sheets for base coat instructions.**



4. MIXING PEARLS CONCENTRATES

Add Pearl Concentrates to mixed clear (ready to spray) and apply over the base coat. Pearl Concentrates may be added to any of our Kustom or Kosmic Clears, including SG100 Intercoat Clear and SG150 Intercoat Pearl & Flake Karrier. Use SG100 and SG150 over Shimrin® Universal Bases only. The color of your base will determine how much pearl to use. The following chart is a guide for proper mixing:

PEARL AMOUNT - PER MIXED QUART OF CLEAR		
TYPE OF PEARL	FOR DARK BASE	FOR LIGHT BASE
Dry Pearl	1/4 - 1 level tsp.	1-2 level tsp.
Pearl Paste	begin with drops	1/2 - 1-1/2 tsp.

The size of the object being painted will dictate the amount of pearl also. Larger objects require less pearl than small objects. On large objects, start low and add additional pearl slowly. Too much pearl will reduce the iridescent pearl effect due to overcrowding of the pearl platelets.



4. MIXING PEARLS CONCENTRATES (continued)

NOTE: When applying pearl over a dark base, do not add too much pearl concentrate as mottling or streaking can occur quite easily. Apply more coats instead of mixing the pearl too strong.

NOTE: Urethane enamel may take slightly more pearl than acrylic lacquer due to its high solids.

ALWAYS OVER REDUCE WHEN USING PEARL CONCENTRATES.

See appropriate tech sheets for clear mixing instructions.

PEARL CONCENTRATES - REDUCTION AMOUNT

TYPE OF CLEAR	REDUCTION AMOUNT
SC01 Sunscreen Clear	Additional 50 - 100%
UC01 or UC35 Kosmic Klears	Additional 6 oz. per mixed quart
SG100 Intercoat Clear	Additional 50%
SG150 Pearl & Flake Karrier	Additional 50%



5. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)



6. APPLYING PEARL CONCENTRATES

Strain the paint into the paint gun. Apply 2-6 medium (almost wet) coats with 75% pattern overlap. Gun distance while spraying should be 5-6 inches. Walk long objects. Allow flash time between coats.

Be sure that your spray equipment and environment are very clean and the spray pattern correct. An uneven spray gun pattern will make proper application impossible. Apply enough coats to achieve the effect you desire. Then begin Kandy or clear coats.

NOTE: When using SG100 and SG150, never apply more than 4 coats. Mix the pearls rich enough to complete the application in 3 or 4 coats.

7. KANDY (optional)

See appropriate tech sheet for Kandy application.

8. CLEAR COAT

See appropriate tech sheet for Clear Coat application.

CAUTIONS

Read Cautions and Warnings on all product can labels. Use a recommended respirator when spraying. KEEP OUT OF REACH OF CHILDREN.

NOTE: All of our pearls are lead free. So are the PBC Designer Pearls.

GENERAL INFORMATION

Kameleon® Pearls are unique color changing pigments available in 5 dazzling colors and two particle sizes, Standard and Fine. They are supplied in a dry form that may be added to SG100 Intercoat Clear, SG150 Intercoat Pearl & Flake Karrier, SC01 Sunscreen Acrylic Lacquer Clear, House of Kolor® brand urethane clears, or MB00 for dramatic, eye catching art work. Kameleon® Pearls change color based on the viewing angle, so, often different people will see different colors when looking at the same vehicle. When ordering Kameleon® Pearls use the following codes to specify the product you are interested in obtaining:



CODE	DESCRIPTION	CODE	DESCRIPTION
KPF100	GREEN TO BLUE	KPF100SF	FINE GREEN TO BLUE
KPF101	GOLD TO GREEN	KPF101SF	FINE GOLD TO GREEN
KPF102	COPPER RED TO GREEN	KPF102SF	FINE COPPER RED TO GREEN
KPF103	SAPPHIRE	KPF103SF	FINE SAPPHIRE
KPF104	AQUARIUS	KPF104SF	FINE AQUARIUS

1. SUBSTRATE

- Ko-Seal® II
- BC25, or Dark Shaded Shimrin® Bases
- Properly prepared OEM finishes



2. PREPARATION

Read "TECH PREP" thoroughly before you begin painting. Pearls are very susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP Primers.**



3. GROUND COAT:

- Ko-Seal® II
- BC25 or dark shared finishes

Use KS11, KS211 or BC25 as a ground coat for the most dramatic color change effect. The color of the ground coat will vary the amount of coats it will require to obtain the best results. White or light color basecoats will require many coats to achieve coverage. If BC25 cannot be used, use PBC100 or PBC43.

NOTE: On large surfaces use BC03 or FBC03 as a basecoat for more even coverage of Kameleon® Pearls.



4. MIXING KAMELEON® PEARLS

Add Kameleon® Pearls to mixed clear (ready to spray) and apply over the base coat. Kameleon® Pearls may be added to any of our Kustom or Kosmic Klears including SG100 Intercoat Clear. Use SG100 over Shimrin® Universal Bases or Ko-Seal® II only.

ADD 1-2 TEASPOONS OF KAMELEON® PEARL PER MIXED PINT OF CLEAR.

NOTE: When applying pearl over a dark base, do not add too much pearl as mottling or streaking can occur.

Kameleon® Pearls may be intermixed to create custom colors. They can also be added to our Kameleon® Basecoats for novel color effects.

For novel color effects, Kameleon Pearls may also be mixed into MB00 Neutral Marblizer®.

ALWAYS REDUCE KAMELEON® PEARL MIXES:



KAMELEON® PEARL - REDUCTION AMOUNTS	
TYPE OF CLEAR	REDUCTION AMOUNT
SC01 Sunscreen Clear	Additional 50 - 100%
UC01 or UC35 Kosmic Klears	Additional 6 oz. per mixed quart
SG100 Intercoat Clear	Additional 50%
SG150 Pearl & Flake Karrier	Additional 50%

5. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Follow gun manufacturer's recommendations



6. APPLYING KAMELEON® PEARL

Strain the paint into the paint gun. Apply 3 medium (almost wet) coats with 75% pattern overlap. Gun distance while spraying should be 4-6 inches. Walk long objects. Allow flash time between coats. Avoid dry spraying, as loss of adhesion is possible with pearls. Be sure that your spray equipment and environment are very clean and the spray pattern correct. An uneven spray gun pattern will make proper application impossible. Apply enough coats to achieve the effect you desire. Then begin clear coats.

NOTE: When using SG100 or SG150, never apply more than 4 coats. Mix the pearls rich enough to complete the application in 3 or 4 coats.

NOTE: ANY KANDY OR ARTWORK APPLIED OVER KAMELEON® PEARLS CAN REDUCE OR COMPLETELY ELIMINATE THE COLOR CHANGE EFFECT. ALWAYS TEST ANY ARTWORK OR KANDY PLANNED ON A TEST PANEL.



7. CLEAR COAT

See appropriate tech sheet for Clear Coat application.

CAUTIONS

Read Cautions and Warnings on all product can labels. Use a recommended respirator when spraying.

KEEP OUT OF REACH OF CHILDREN and do not apply to objects used by children.



GENERAL INFORMATION

Ice Pearl glass flake pigments go beyond traditional pearls in brightness of color, transparency, and reflectivity. They have brightness and sparkle under sunlight conditions. Ice Pearl may be used in any of our Shimrin® Universal bases, Kandys, Klears, Marblizer®s or Kustom Bases. They are an excellent base for Kandy finishes, giving a brilliant glitter effect. Blends of Ice Pearl pigments give true multicolor effect, showing the individual colors of the pearl used in the blend. Ice Pearl gives the custom painter additional creativity to design "one of a kind" custom finishes.



1. MIXING ICE PEARL

Add Ice Pearl to mixed clear (ready to spray) and apply over the base coat. Ice Pearl may be added to any of our or Kosmic Clears, including SG100 Intercoat Clear or SG150 Intercoat Pearl & Flake Karrier for best results. Use SG100 or SG150 over Shimrin® Universal Bases only. The color of your base will determine how much pearl you use. The following chart is a guide for proper mixing:

ICE PEARL AMOUNTS - PER MIXED QUART OF CLEAR		
ICE PEARL	FOR DARK BASE	FOR LIGHT BASE
	2 teaspoons	3 - 4 teaspoons

The size of the object being painted will dictate the amount of pearl also. Larger objects require less pearl than smaller objects. On large objects, start low and add additional pearl slowly. Too much pearl will reduce the pearl effect due to overcrowding of the pearl platelets.

NOTE: When applying pearl over a dark base, do not add too much pearl, as mottling or streaking can occur.

NOTE: Urethane enamel may take slightly more pearl than acrylic lacquer due to its high solids.



2. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)



3. APPLYING ICE PEARL

Strain the paint or clear into the gun, then add the Ice Pearl. Air pressure varies, use Gun Mfgs. recommendations. Apply 2-3 medium (almost wet) coats with 75% pattern overlap. Gun distance while spraying should be 6 inches or less to reduce roughness. Walk long objects. Allow flash time between coats. Be sure that your spray equipment and environment are very clean and the spray pattern correct. An uneven spray gun pattern will make proper application impossible. Apply enough coats to achieve the effect you desire. Then begin Kandy or clear coats.

NOTE: When using SG100 or SG150, never apply more than 4 coats. Mix the pearls rich enough to complete the application in 3 or 4 coats.

NOTE: Check effect of Ice Pearl color in direct sunlight to see their maximum impact.

4. KANDY (optional)

See appropriate tech sheet for Kandy application.

5. CLEAR COAT

See appropriate tech sheet for Klear application.

CAUTIONS

Read Cautions and Warnings on all product can labels. Use a recommended respirator when spraying.

KEEP OUT OF REACH OF CHILDREN and do not apply to objects used by children.

NOTES

GENERAL INFORMATION

Depending on use and sun exposure, light fastness on some colors will be limited. The glow effect continues even if the color fades. The Kosmic Long-Glo has demonstrated better light fastness than the Kosmic-Glo® when applied over a white base. We recommend using Kosmic Long-Glo with discretion - even though the color may change with time and exposure, the Glow-in-the-Dark feature remains for a long time. Kosmic Long-Glo is provided in 4 oz. jars of dry powder. (Bulk prices available on request.)

IMPORTANT NOTE - KOSMIC LONG-GLO IS NOT RECOMMENDED FOR OVERALL REFINISHING.



1. SUBSTRATE

- Ko-Seal® II KS10 or KS210
- BC26



Maximum glow occurs when Kosmic Long-Glo is applied over a white base. We recommend using our Shimrin® BC26 White as a base or Ko-Seal® II KS10 or KS210. Other colors/bases (such as Pearls, Kandys, Neons, Solid Colors, etc.) may be used for unusual effects, but glow time will be less.

2. MIXING KOSMIC LONG-GLO

Add 4 to 6 oz. of Kosmic Long-Glo dry powder to 1 pint of ready to spray SG150 Intercoat Pearl & Flake Karrier. Mix thoroughly. Mix only when ready to use. Stir between coats as setting occurs quickly. Spray immediately after mixing as this product may not store well when mixed.



NOTE: An agitator cup can help keep product mixed during spraying.

NOTE: Use a gun with a 1.5 fluid tip to prevent the gun from plugging or miss-spraying. Always empty a gravity feed gun between coats due to rapid settling. Re-stir and add to gun for the next coat.

For Urethane Finishes:

Our SG150 Intercoat Pearl & Flake Karrier works well for mixing the Kosmic Long-Glo pigment. Topcoat with our UC01 Kosmic Klear®, UC35 Kosmic Klear®, UFC01 Kosmic Urethane Flo-Klear, UFC19 Komply Klear® or UFC35 Kosmic Urethane Flo-Klear.

For Lacquer Finishes:

Mix the Kosmic Long-Glo pigment with our SC01 Sunscreen Lacquer Clear and then topcoat with an additional coat of SC01 Sunscreen Lacquer Clear.

3. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLG Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Follow gun manufacturer's recommendations



4. APPLYING KOSMIC LONG-GLO

Apply 3 coats using a 75% pattern overlap when spraying. Allow plenty of flash time between coats. Clear with a compatible clear. For best glow time, apply over a white base.



5. GLOW TIME

Maximum excitation for Kosmic Long-Glo is UV light (both long and short), daylight and artificial light (tungsten and fluorescent lamps). Sodium vapor or I.R. light sources are unsuitable.

Glow time will vary based on application, base color and light exposure. Maximum glow time is 4 to 12 hours, based on the intensity of the excitation energy.

13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



NOTES

F, MF, UMF FLAKES



GENERAL INFORMATION

Flakes may be added to any of our Kandys or Clears. We offer flakes in five grain sizes:

- 1/64 inch Flake (the most difficult to use)
- Mini Flake (comes on fast with greatly reduced surface roughness)
- Ultra-Mini Flake (3 sizes, easy to apply and smooths out with topcoats)

Built from ultra thin polyester, our flakes are the lightest and easiest to use. The mini and ultra-mini flakes have the brilliance of a much larger flake, combining the ultimate in a flake look and ease of use. Check out our MBC Basecoats. These basecoats offer outstanding brilliance, producing a medium Flake look without the extra work associated with flake.



1. MIXING FLAKES AND GUN SET UP

For maximum reflectivity and ease of use, we recommend adding Flakes directly to the clear and spraying over the base coat. Flakes may be added to any of our Kustom or Kosmic Clears, including SG100 Intercoat Clear and SG150 Intercoat Flake & Pearl Karrier. For best results we recommend the use of SG150 Intercoat Flake & Pearl Karrier **(see tech sheet on SG150)** Use SG100 and SG150 over Shimrin® Universal Bases only. The color of your base coat will determine how much flake to use. The following chart is a guide for proper mixing. If a full flake look is desired, be sure your base color is similar to the flake color, preferably 4-5 shades darker than the flake, to create the illusion of coverage in 2 coats. 3 or more coats of flake will greatly increase the roughness of the finish. Always do a test panel first to gauge the coverage, color and roughness before committing to the paint job. You may find you'll need to add additional flake to achieve the proper coverage. (Always measure for consistency of mix)

NOTE: With a gravity feed gun, remove flakes between coats, simply stir and add for next coat or purchase an agitator gun cup.

NOTE: Flake should not be applied with an Air Brush.

NOTE: On large objects, use a reducer (or thinner) on the slow side to allow the flakes to flow into the clear, for better leveling and reduced roughness.

NOTE: When mixing straight clear to be sprayed over flake to bury it, use a faster reducer. Don't use SG100 as a build clear.

NOTE: Flakes may also be added (in small amounts) to any of our Shimrin® Bases, Kustom Bases, and to first coats of Kustom and Kosmic Kandys. A great place for creativity. (Do not add Flakes to UB04, UB05, BC25 or BC26 as these high pigmented bases will diminish the flakes.)

NOTE: Mixing ratios listed for flakes are for ready-to-spray material, per quart.

ITEM NUMBER	DESCRIPTION	FLAKE SIZE	MIN. NOZZLE SIZE	DARK BASE	LIGHT BASE
F14.C01	RAINBO (1/64)	1/64th HEX	1.8	4 - 12 Tbls	12 Tbls
F15.C01	SILVER (1/64)	1/64th HEX	1.8	4 - 12 Tbls	12 Tbls
F16.C01	LITE GOLD	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F17.C01	DARK GOLD	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F18.C01	ORANGE	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F19.C01	APRICOT	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F20.C01	RED	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F21.C01	FUSCHIA	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F22.C01	ROYAL BLUE	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F23.C01	GREEN	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F24.C01	ABALONE	1/64th Hex	1.8	4 - 12 Tbls	12 Tbls
F25.C01	SMOKE	1/128th Rectangle	1.5	1 - 3 Tbls	3 Tbls
F28.C01	KAMEN BLUE	1/64th Hex	1.8	3 - 9 Tbls	9 Tbls
F31.C01	RICH GOLD	1/64th Hex	1.8	3 - 9 Tbls	9 Tbls
F32.C01	FIREBALL	1/64th Hex	1.8	3 - 9 Tbls	9 Tbls
F33.C01	FINE RAINBO	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F34.C01	PINK ROSE	1/64th Hex	1.8	3 - 9 Tbls	9 Tbls
F61.C01	MINI KAMEN BLUE	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F64.C01	MINI RICH GOLD	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F65.C01	MINI FIREBALL	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F66.C01	MINI PINK ROSE	1/128th Hex	1.5	1 - 3 Tbls	3 Tbls
F70.C01	RED GOLD TRANS	1/166th Square	1.5	1 - 3 Tbls	3 Tbls
F71.C01	GREEN GOLD TRANS	1/166th Square	1.5	1 - 3 Tbls	3 Tbls
F72.C01	BLUE GREEN TRANS	1/166th Square	1.5	1 - 3 Tbls	3 Tbls
F73.C01	VIOLET RED TRANS	1/166th Square	1.5	1 - 3 Tbls	3 Tbls
F74.C01	GREEN TO PURPLE	1/125th Hex	1.5	4 - 6 Tbls	6 Tbls
F75.C01	BLUE TO RED	1/125th Hex	1.5	4 - 6 Tbls	6 Tbls
F76.C01	GOLD TO GREEN	1/125th Hex	1.5	4 - 6 Tbls	6 Tbls

MF01.C01	GOLD MINI FLAKE	1/256th Rectangle	1.4	1 - 3 Tbls	3 Tbls
MF02.C01	SILVER MINI FLAKE	1/256th Square	1.4	1 - 3 Tbls	3 Tbls
UMF01.C01	ULTRA GOLD MINI	1/500th Square	1.3	1 - 3 Tbls	3 Tbls
UMF02.C01	ULTRA SILVER MINI	1/500th Square	1.3	1 - 3 Tbls	3 Tbls
UMF03.C01	ULTRA RAINBO MINI	1/256th Square	1.4	1 - 3 Tbls	3 Tbls
UMF04.C01	ULTRA RAINBO MINI	1/500th Square	1.3	1 - 3 Tbls	3 Tbls

2. APPLYING FLAKES

WHEN USING LARGE FLAKES - BE SURE YOUR SPRAY GUN HAS A LARGE ENOUGH FLUID TIP TO ALLOW PASSAGE OF THE FLAKE.

Strain the paint into the paint gun, then add the Flake. Air pressure varies gun to gun, but lower pressure works best to reduce overspray. Apply 1 - 2 medium coats with 75% pattern overlap. Gun distance while spraying should be 4-5 inches. If Flake is sprayed too far away from the vehicle, dryness can occur which can be difficult to smooth out. Walk long objects. Allow 15 to 30 minutes flash time between coats.

NOTE: TRY NOT TO APPLY MORE THAN 2 COATS. Succeeding coats add greatly to increased surface roughness and will require more clear and sanding to smooth out.

3. KANDY COAT (optional)

Once you are satisfied with the flake application, allow flash time. Using a white scuff pad, lightly scuff over the flake to lay down or knock off any standing flake, then topcoat with 3 - 4 coats of Urethane Clear. Let dry overnight and D.A. sand with 320P grit sandpaper the next day. Be careful of high points and edges, as it is easy to sand through and ruin all you have done. Air and tack. Then begin Kandy coats. Follow label instructions. **See appropriate tech sheets for Kandy application.**

NOTE: When using 1/64 inch Silver Flake (only) you may simply dry sand with 220P grit sandpaper and a washing motion to knock down standing flakes; then begin topcoats. Do not use this method with colored flakes as the color is easily sanded off. Silver is the true flake color.

4. CLEAR COAT

FOR ACRYLIC LACQUER PAINT JOBS:

Allow flash time before top coating with clear. Apply 5-7* coats of SC01 Sunscreen Clear. **See tech sheet for clear coat application.**

NOTE: The normal critical dry time of 48 hours is not a problem with Flakes. You may re-coat at any time with no fear of line checking or crows feet.

***NOTE:** Flake size, Kandy coat, application expertise, thinner, etc. will determine the number of clear coats required. Sand between every 5-7 coats.

FOR URETHANE ENAMEL FINISHES:

Allow flash time before top coating with clear. Paint should be sticky and not string when touched at the wettest point before next coat is applied. (When using the touch test always touch a new spot). Monitor closely for maximum merging of coats.

Apply 2-4* coats of our UC01 or UC35 Clear. See tech sheet for clear coat application. Do not use SG100 or SG150 as a topcoat clear.

***NOTE:** Flake size, Kandy coat, application expertise, thinner, etc. will determine the number of clear coats required.

5. COLOR SANDING & REFLOW

FOR 1/64 INCH SILVER FLAKE AND RAINBOW FLAKE:

Use D.A. Sander with 320P grit dry sandpaper to begin smoothing the paint job. Hold D.A. at eye level and spin pad. It should not wobble, but spin true. Avoid high points, edges or any area where you might sand through.

NOTE: D.A. color sanding requires practice and a true sandpaper pad.

Air and tack. Re-clear. Wet sand with 400 or 500 grit sandpaper for final clear coats.

NOTE: Flake jobs often require more than one reclearing to achieve full coverage and flatness of the flake prior to polishing.

FOR MINI FLAKE AND ULTRA-MINI FLAKE:

Color sand and finish with normal methods. **See tech sheet on Polishing & Finishing for instructions.**



6. POLISHING

Allow a Flake job to dry down before polishing, usually 30 days minimum for lacquer and 48 hours for urethane (in temperatures of 70-80°F). As the paint dries, it shrinks down around the Flakes and if you polish too soon you may wind up polishing again after the dry down. In winter months, it may take 60-90 days or more for dry down. If possible, let the paint bake in the sun for a good cure before polishing. Urethanes cure chemically at 70°F. Color sand wet; if rough, start with 500 grit. Finish color sanding with 1200 to 2000 grit. **See tech sheet on Polishing & Finishing for more information.**

CAUTIONS

Read Cautions and Warnings on all product can labels. Wear eye protection and approved respirator based on the type of paint the Flake is mixed into. The polyester flakes offer no hazard in dry form, but when sprayed may enter eyes, nose, throat or lungs if proper protection is not worn.



U KOSMIC KOLOR® URETHANE STRIPING & LETTERING ENAMEL



GENERAL INFORMATION

Our Striping & Lettering Enamel is designed for striping, lettering and airbrush artwork. It features high pigmentation, low solids for a minimal edge and long open time. Apply over existing finishes or topcoat with clear for a smooth, durable finish. Our Striping & Lettering Enamel may be top coated with acrylic lacquer, urethane enamel, acrylic enamel and alkyd enamel.



1. PREPARATION

Remove all traces of wax, silicone, grease, dirt, etc. If finish is oxidized or dull, polish before striping is begun. If overall clear coats are required, color sand with 500 or 600 grit wet sandpaper. **See tech sheet for color sanding instructions.**



2. MIXING & APPLYING STRIPING & LETTERING ENAMELS

Stir the color to be used. Deposit 1 or 2 brush loads of paint onto the palette. Use U00 Reducer to maintain proper consistency. Simply add a small amount to a shot glass, dip your brush into the reducer and add to the mixture on your palette. Brush back and forth a few times, then begin your artwork. As the paint is used, add more to your palette by the brush full.

CAUTION: Do final wipe down with KC20 or water only. Wash solvents will remove the artwork. Mistakes over catalyzed Urethane are easily removed with a rag dampened with acetone.

Clean your brush with U00 Reducer or lacquer thinner. Many artists will simply fluff the brush with low air pressure after cleaning with reducer prior to storage.

Allow artwork to dry 1 to 4 hours (depending on shop conditions) before applying clear coats.

3. STRIPING CLEAR UC03

UC03 is a clear Striping & Lettering Urethane that can be added to the striping colors to reduce tint strength. UC03, when catalyzed, can be used to topcoat by brush the Neons or other colors to add gloss and chemical resistance.

UC03 Clear Catalyzed Mixing Ratio: 4 parts UC03 Clear to 1 part KU200 Striping Catalyst. Some reducer may be added (RU310 or RU311) to reduce viscosity.

CAUTION: TOO WET A FIRST COAT OF CLEAR OR NOT ENOUGH DRY TIME BETWEEN COATS MAY MOVE THE ART - USE CARE AND DO NOT RUSH! Monitor your coats closely for maximum merging of coats. General rule, use fast reducer in clear coats and allow flash time.



4. APPLYING GOLD LEAF

Gold Leafing:

U05 Imitation Gold (striping enamel) makes an excellent sizing for applying gold or variegated gold leaf. Mix 4 parts U05 striping enamel with 1 part KU200 catalyst. Apply U05 with brush, let set until sticky (20-30 minutes), apply gold leaf and allow to dry overnight. Brush away excess outline and clear with catalyzed UC03 Clear, or topcoat clear the complete part with any of our Kosmic Klears.

5. IMPORTANT INFORMATION

WHEN STRIPING OVER FINAL FINISHES:

Mix Striping & Lettering Enamel with KU200 Striping Catalyst. Follow label instructions. The catalyst adds gloss and chemical resistance so clear coats are not necessary.

Mixing Ratio - Striping Colors: 8 parts paint to 1 part KU200 Catalyst.

Mixing Ratio - UC03 Clear: 4 parts UC03 Clear to 1 part KU200 Catalyst.

NOTE: Use only KU200 Striping Catalyst with our Urethane Striping & Lettering Enamels.

NOTE: KU200 Striping Catalyst is moisture sensitive and will not keep for long periods once open. Keep container tightly sealed. Clean the catalyst container pour spout by wiping the threads with reducer for easy opening.

WHEN TOP COATING ARTWORK WITH CLEAR:

No catalyst is required. Striping & Lettering Enamel will dry in 1-4 hours for clear coats.

NOTE: When using Striping & Lettering Enamel for artwork or murals, it is a good idea to use the KU200 Catalyst for faster dry times and no tape marks.

FOR AIRBRUSH ARTWORK:

For airbrushing with Striping & Lettering Enamel, reduce 100-150% with RU311 Medium Reducer for good sprayability and rapid dry times. In warmer weather, use RU312. Strain through a fine strainer.

5. IMPORTANT INFORMATION (continued)

FOR ARTWORK ON SHIMRIN® METALLIC OR PEARL BASE COATS:

Apply 1 or 2 coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for Acrylic Lacquer topcoats) before artwork is applied. **DO NOT ATTEMPT TO STRIPE DIRECTLY ONTO THE SHIMRIN® METALLIC OR PEARL BASE COAT.**

6. REMOVING MISTAPES

Urethane Enamel Finishes:

Wipe with U00, RU310 Reducer, or acetone using hard pressure and a clean spot on the rag. Carefully check the area to be sure no residual paint film remains.

CAUTION: Base coats will be removed with reducers unless they have been cleared with a topcoat clear. Base coats do not have any chemical resistance until cleared. Final wash solvents and reducers will remove base coats. Use care not to wipe away your artwork.

On extensive art jobs, we recommend applying 2 coats of urethane clear (before applying the artwork). The following day, color sand with 500 grit wet, then pinstripe or airbrush the artwork. This allows mistakes to be easily removed with acetone.

Acrylic Lacquer Finishes:

Remove mistakes with a final wash solvent. Some reducers may work also. Test in an inconspicuous spot before using. Use firm pressure and make sure no residual paint film remains.

7. CLEARING OVER FINAL ARTWORK

Urethane Enamel Finishes:

When clearing over artwork, adjust the gun and bring the clear on slowly to prevent sliding of artwork.

NOTE: Applying the clear too wet may cause the artwork to slide or run. Allow flash time between coats, use fast reducer.

Acrylic Lacquer Finishes:

When applying clear coats over artwork or striping, begin with medium coats, to prevent sliding of artwork. Allow flash time between coats.

ADDITIONAL INFORMATION

Provide adequate ventilation when mixing and airbrushing. Avoid breathing fumes and skin contact with KU200 Striping Catalyst.

GENERAL INFORMATION

ADHERETO® Adhesion Promoters are designed to create a bond between a substrate and a coating. Apply Adhereto® before applying topcoats to ensure proper adhesion of automotive paint to: plastics, brass, aluminum, metal, chrome, or a variety of other surfaces. Adhereto® is easy to use and dries in minutes. Ready to spray right out of the can (no reduction required). Clear in color.



ADHERETO® is available in two formulas:

AP01 is designed to use when top coating Polypropylene, TPO (Thermoplastic Polypropylene), Polypropylene/elastomer blends, other plastics, aluminum, steel, brass and other metals.

AP02 is designed for Polyethylene only.

1. PREPARATION

Clean substrate of all contamination, such as dirt, oil, grease and mold release agents, with isopropyl alcohol or KC20 Post Sanding Cleaner. Dry thoroughly after cleaning. Scuff using a maroon scuff pad.



2. MIXING RATIO

Ready to spray as packaged, no reducer.



3. GUN SET UP

- Conventional Gun = 35 to 45 PSI
- HVLP Gun = 8 to 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3

4. APPLYING ADHERETO® (AP)

Apply Adhereto® with a dry film thickness of 0.1 to 0.2 mils equal to one medium coat.



WARNING: Proper coat thickness is critical for good adhesion properties. With adhesion promoters, more is not better. Carefully monitor coat thickness. Topcoats may be applied immediately after the Adhereto® coat has dried, usually within 2 to 3 minutes not to exceed 5 minutes at 70°F. Adhereto® acts as a clear adhesive primer providing a bond for topcoats.

NOTE: If Adhereto® completely dries, it must be reapplied prior to top-coating.

5. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



NOTES

HH HI-HEAT™ BLACK



GENERAL INFORMATION

Hi-Heat™ Black is a superior, high temperature coating. It is a great coating for engine parts or exhaust systems on cars, trucks, motorcycles, small engines, etc., where high temperature is a concern. It features fast coverage and cures to a beautiful semi-gloss jet black finish that will endure 1400°F with no flaking or discoloration. Hi-Heat™ Black comes ready to spray and no reduction is required. Parts are dry enough to handle in one hour. No baking is required.



1. PREPARATION

For new steel surfaces make sure metal is bare and clean with no traces of water, oil, wax, or surface rust. Wiping parts with a quality, mid temperature lacquer thinner (such as House of Kolor® RU202 Lacquer Thinner) works well as a final wash. Allow to dry, then start application. If possible, warm the parts with a heat lamp. This will speed up the process.



2. SUBSTRATE

- Bare Steel



3. SANDING THE SUBSTRATE

For previously coated or rusted surfaces, sand or bead blasting is the only method of preparation recommended. After blasting, prepare surface the same as described above for new steel surfaces.

NOTE: Sand or bead blasting is the ideal surface preparation for all surfaces including new steel surfaces.

Apply Hi-Heat™ Finish as soon as possible after cleaning for maximum adhesion.



4. COMPONENTS

- Ready To Spray



5. MIXING HI-HEAT™

- Ready To Spray



6. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 25% to 50%
- Air Brush = Not Recommended



7. APPLYING HI-HEAT™ BLACK (HH04)

Hi-Heat™ Black is ready to spray as packaged. Do not add any extra reducer. Warm parts with an infrared heat lamp. Remove heat lamp from booth, then apply one medium wet coat. Allow 10-20 minutes dry time or until paint has flashed dull then apply one more medium wet coat. Apply just enough paint to achieve coverage, but never more than two medium coats of HH04. Many motorcyclists also coat the exhaust pipes inside to minimize bluing on chrome pipes.

WARNING: Proper film thickness is critical for good heat resistance properties. Dry film thickness should not exceed 0.6 mils. Excessive film thickness will cause coating failure such as blistering and flaking. More is not better.



8. DRY TIME

Parts are ready to handle in one hour. Allow parts to cure for 24 hours after last coat is applied to ensure that solvent is no longer present in the coating. Final cure will be accomplished by the inherent heat of operation. This will cause the parts to emit smoke and odor upon first use. This is a chemical reaction that final cures the paint. After this, the parts will be a beautiful semi-gloss black finish.



9. CLEAN UP

Clean equipment thoroughly with thinner (check local regulations).

NOTES

GENERAL INFORMATION

KC10 WAX & GREASE REMOVER removes grease, wax, silicone, adhesives, tar, tree sap, insects and dirt. KC10 is a quick flashing product designed to speed initial surface prep before sanding and body work. Don't apply more than you can wipe clean before KC10 dries, or no contaminants are removed. (Wiping cloths become contaminated, change regularly and dispose of properly).



1. USING KC10

KC10 is to be used over unsanded surfaces and OEM finishes. DO NOT USE KC10 over polyester fillers, primers, sealers, or during any step of paint application. It is surface prep cleaner only.

2. APPLICATION

1. Wash surface with mild detergent and water.
2. Rinse and dry surface.
3. Soak clean cloth with KC10.
4. Wipe surface with KC10 and wipe dry with clean, dry cloth before product dries.



KC10 should not be allowed to dry on surface. If this occurs, re-apply KC10 using a clean cloth and wipe dry.

NOTES

KC20 POST SANDING CLEANER



GENERAL INFORMATION

KC20 POST SANDING CLEANER removes sanding residue as well as dirt, hand oils, and other light contaminants. KC20 will also reduce static when used on plastic and fiberglass parts. KC20 is designed for use in initial and final surface preparation. However before sanding existing finish KC10 should be used first. **See instructions for KC10 Wax and Grease Remover.**

1. USING KC20

KC20 is to be used over sanded surfaces, OEM finishes, sanded primers, cured sealers, fresh base coats, Pin Stripes, Air Brush Art, and other sensitive surfaces.



2. APPLICATION

1. Wash surface with mild detergent and water.
2. Rinse and dry surface.
3. Soak clean cloth with KC20.
4. Wipe surface with KC20 and wipe dry with clean, dry cloth before product dries.

KC20 should not be allowed to dry on surface. If this occurs, re-apply KC20 using a clean cloth and wipe dry.

NOTE: KC20 is the only cleaner recommended for cleaning Shimrin® base coats prior to top coating.

NOTES

GENERAL INFORMATION

Bleed Check is a two-component acrylic urethane sealer designed to stop the bleed through of products. Bleed Check will stop bleeding colors from interfering with artwork. The following House of Kolor® products have a tendency to bleed: KBC03, KBC05, KBC06, KBC10, KBC13, KK03, KK05, KK06, KK10, KK13, UK03, UK05, UK06, UK10 AND UK13. We recommend using Bleed Check over the above products to protect artwork.

NOTE: The active ingredient in Bleed Check Sealer is graphite and is black in color; therefore, it may not be suitable under certain graphics.



1. SUBSTRATE

- UK Kandys
- KBC Kandys
- KK Kandy Koncentrate mixes



NOTES

2. COMPONENTS

- SBS10 Bleed Check Sealer
- RU310 (fast), RU311 (medium) urethane reducer,
- AX01 Accelerator (IMPORTANT)
- Air Brush application: Not Recommended



NOTE: Without the addition of AX01, SBS10 will not properly cure.

3. MIXING BLEED CHECK

- 4 part Bleed Check
- 1 part RU- reducer
- 1 part KU100 catalyst
- 1/8 Teaspoon AX01 per pre-mixed quart
- Air Brush Application: Not recommended



4. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush = Not recommended



5. APPLYING BLEED CHECK

NOTE: ALLOW THE BLEED SUSPECT BASECOAT PRODUCT TO DRY 30 MINUTES BEFORE APPLYING BLEED CHECK. ALLOW UK'S (URETHANE KANDYS) TO DRY OVERNIGHT. **See UK tech sheet for more information.**

Strain the paint into the gun. Gun distance while spraying should be approximately 6 inches. Apply 1-2 medium wet coats with 50% pattern overlap.

Walk long objects. Be sure of thorough coverage. Allow flash time between coats.

BLEED CHECK FLASH TEST— ALLOW TO FLASH DULL BETWEEN COATS. USUALLY 1-4 MINUTES.



6. DRY TIME

Allow to dry 1 hour but not longer than 3 hours before artwork or basecoat application. (Dry time may vary with shop conditions). Follow basecoat directions. A light wash sand, using 500P or 600P grit wet assures proper adhesion.



7. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



POLISHING & FINISHING INSTRUCTIONS



1. COLOR SANDING

Color Sanding for Flow Coats:

After clear coats have cured overnight (12-24 hours), color sand with 500 grit wet sandpaper. Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue does not bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemicals washes at this stage are not recommended).

NOTE: Avoid touching the vehicle with your bare hand, as the oil from your skin may impair flow coats. Final wipe use warm water, if contaminated wash with KC20.

NOTE: When using a tack cloth, open the cloth and let stand for 15-20 minutes to eliminate resin transfer, then form the cloth into a ball and use in that manner.

CAUTION: Do not sand through the clear and ruin all you have done.

Color Sanding for Polishing:

Begin color sanding with wet 1200P grit sandpaper. Block large areas. Avoid color sanding areas that are difficult to polish by machine without risk of burning or tearing the finish. Add a small amount of Ivory® liquid detergent to ease sandpaper loading. Dry as you go. You may continue with 1500P – 2000P grit etc. Many quality polishing products exist for this work. Use proven polishing pads and rubbing/polishing compounds, and a polisher not to exceed 1750 rpm free running speed.



2. FLOW COATS (optional)

Flow coats (or reflow) is the perfectionist method for finishing a topcoat clear. With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles. This method reduces time required to color sand and polish.

Urethane Enamel Reflow Method:

After color sanding, re-clear using 6-10 oz. of extra reducer per mixed quart using UC01 Klear, UC35 Klear, UFC01 Flo-Klear, UFC19 Komply Klear® or UFC35 Flo-Klear (needs less extra reducer). The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1 or 2 wet coats. Allow flash time between coats. (For improved hardness the next day, add an additional 1-1.5 oz. of the specified catalyst to this mixture).

Acrylic Lacquer Reflow Method:

After color sanding, apply 1 medium to light coat of SC01 Sunscreen Clear thinned 200%, using a slow dry thinner. Then apply 1 wet coat. The medium/light coat tacks the surface, giving the wet coat that follows something to adhere to. A wet first coat may cause problems. After the wet coat has flashed, thin the clear 300-400% and apply 1 wet coat. Check gun pattern, as this much thinner usually means narrowing the gun pattern. A spray booth with good air movement is necessary for this method.

NOTE: If the shop temperature is below 75°F (or if you are not in a spray booth), DO NOT USE SLOW DRY THINNER. Air movement is critical to remove the thinner during flow coats. Use a fast dry thinner and allow plenty of time between coats to prevent crazing. (Use retarder only in a spray booth with shop temperatures over 75°F).



3. POLISHING

Polishing may be done after 1 to 3 days for urethane enamel finishes and 10 to 14 days for acrylic lacquer finishes. Dry times will vary with weather and shop conditions.

For great results use 3M® Superbuff III Wool Pad #05703 with Extra Cut Compound #05936. Clean surface with a 50/50 mix of distilled water and alcohol and repolish any spots you may have missed. Change pad to 3M® foam pad #05725 with Machine Glaze #05937 and buff at 1500 to 1750 rpm.

For the ultimate show finish, color sand with 1200 to 2000 grit sandpaper. Then polish, using a 1500 to 1750 rpm polisher and compounds of your choice.

After 60 days, the vehicle may be waxed. We recommend using a quality non-abrasive Carnauba wax.



3. POLISHING (continued)

*3M and the 3M logo are trademarks or registered trademarks of 3M. All other product names mentioned herein are the trademarks of their respective owners.

NOTE: Many other products exist that work excellent with our products for achieving that beautiful long lasting shine. Use what works for you!!

Approximate materials needed for a complete paint job.

Quantities may vary from painter to painter and articles to be sprayed, etc. This chart is an approximate only.

URETHANE ENAMEL FINISH

		Motorcycle (tank & fenders)	Small to Average Auto	Van or Full-Size Truck
Primer:	KP2CF Primer	2 quart Kit	2 gallon Kit	2 gallon Kit
Low VOC Primer:	KD2000 Low VOC Primer	1 quart Kit	1 gallon Kit	1 gallon Kit
Ground Coat:	Ko-Seal® II **	1 quart	2 quarts	3 quarts
(choose one)	BC25 Black or BC26 White	1 quart	1 gallon	6 quarts
NOTE: Neons require BC26 White or KS10 White for Ground Coat				
Top Coats &	UB04 or UFB04 Jet Set Black **	1 quart	4 quarts	6 - 8 quarts
Base Coats	UB05 or UFB05 Brite White **	1 quart	4 quarts	6 - 8 quarts
(choose one)	UFB06 Kosmos Red **	1 quart	4 quarts	6 - 8 quarts
Shimrin® Universal Bases:	Designer Pearls (PBC)	1 - 2 quarts	6 quarts	8 - 10 quarts
	Graphic Kolors (SG)	1 - 2 quarts	6 quarts	8 - 10 quarts
	Neons (NE)	1 - 2 quarts	6 quarts	8 - 10 quarts
	Metallics (BC or FBC)	1 - 2 quarts	5 - 6 quarts	8 quarts
	Metajuls™ (MBC)	1 - 2 quarts	4 - 5 quarts	8 quarts
	Universal Pearls (PC)	1 - 2 quarts	6 - 8 quarts	8 quarts
	Marblizer® (MB)	1 quart	2 quarts	2 - 3 quarts
	Kandy Basecoats (KBC)	1 - 2 quarts	6 quarts	8 - 10 quarts
	Kameleon® (KF)	1 quart	3 quarts	4 quarts
Note: Marblizer® requires a Base Coat. See instructions.				
Kandy:	Kosmic Kandy (UK) **	1 - 2 quarts	4 - 6 quarts	2 gallons
(optional)	Kandy Koncentrate (KK)	8 oz. of Koncentrate plus 2 quarts clear = 2 quarts Kandy		
Note: Kandy Koncentrate requires additional clear. See instructions.				
Clear Coat:	UC01 Kosmic Acrylic Urethane Klear **	1 - 2 quarts	3 - 4 quarts	6 quarts
	UC35 Kosmic Acrylic Urethane Klear **	1 - 2 quarts	3 - 4 quarts	6 quarts
	UFC01 Kosmic Urethane Flo-Klear **	1 - 2 quarts	3 - 4 quarts	6 quarts
	UFC19 Urethane Komply Klear® II **	1 - 2 quarts	3 - 4 quarts	6 quarts
	UFC35 Kosmic Urethane Flo-Klear **	1 - 2 quarts	3 - 4 quarts	6 quarts
		UCC01 Kosmic Acrylic Urethane Kustom Klear **	1 - 2 quarts	3 - 4 quarts
	UMC35 Kos-Matte Klear	1 - 2 quarts	3 - 4 quarts	6 quarts
NOTE: UB04, UB05, UFB04, UFB05, and UFB06 DO NOT require a Clear Coat.				
NOTE: If artwork is planned over Shimrin® Pearl or Metallic Bases, add 1-2 quarts of SG100 Intercoat Clear. See instructions.				
Reducer:	Kosmic Reducer	1 - 2 gallons reducer per 2 gallons of paint		
Components:	Catalyst	1 pint per quart of paint (required only with products whose code begins with "U") (KS Ko-Seal® II requires 1/2 pint per quart)		

** Requires Catalyst

MATERIAL ORDERING GUIDE (continued)

Approximate materials needed for a complete paint job.

Quantities may vary from painter to painter and articles to be sprayed, etc. This chart is an approximate only.

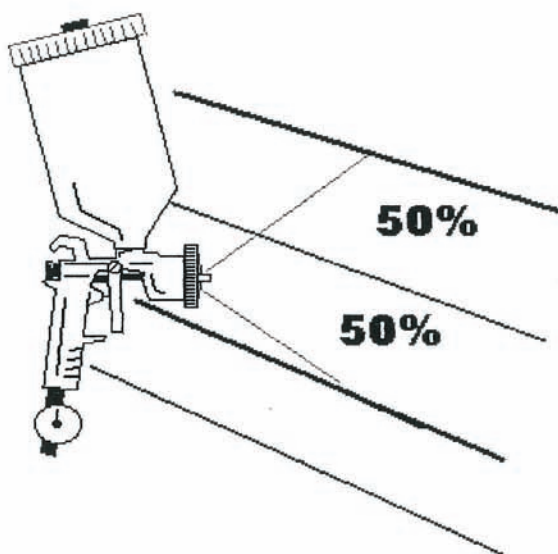
ACRYLIC LACQUER FINISH

		Motorcycle (tank & fenders)	Small to Average Auto	Van or Full-Size Truck
Primer:	KP2CF Primer	2 quart Kit	2 gallon Kit	2 gallon Kit
Low VOC Primer:	KD2000 Low VOC Primer	1 quart Kit	1 gallon Kit	1 gallon Kit
Ground Coat:	Ko-Seal® II	1 quart	2 quarts	3 quarts
(choose one)	BC25 Black or BC26 White	1 quart	1 gallon	6 quarts
Note: Neons require BC26 White for Ground Coat				
Top Coats &	Designer Pearls (PBC)	1 - 2 quarts	6 - 8 quarts	8 quarts
Base Coats	Graphic Kolors (SG)	1 - 2 quarts	6 - 8 quarts	8 quarts
(choose one)	Neons (NE)	1 - 2 quarts	6 - 8 quarts	8 quarts
Shimrin® Universal Bases:	Metallics (BC or FBC)	1 - 2 quarts	6 - 8 quarts	8 quarts
	Universal Pearls (PC)	1 - 2 quarts	6 - 8 quarts	8 quarts
	Marblizer® (MB)	1 quart	2 quarts	2 - 3 quarts
	Kandy Basecoats (KBC)	1 - 2 quarts	6 quarts	8 - 10 quarts
	Kameleon® (KF)	1 quart	3 quarts	4 quarts
Note: Marblizer® requires a Base Coat. See instructions.				
Kandy:	Kandy Koncentrate (KK)	8 oz. of Koncentrate plus 2 quarts clear = 2 quarts Kandy		
Note: Kandy Koncentrate requires additional clear. See instructions.				
Clear Coat:	SC01 Sunscreen Clear	1 quart	1 gallon	2 gallons
Note: If artwork is planned over Shimrin® Pearl or Metallic Bases, add 1-2 quarts of C01 or SC01 Clear.				
Thinner:	RU101 or RU202 Thinner	2 gallons thinner per each gallon of paint		

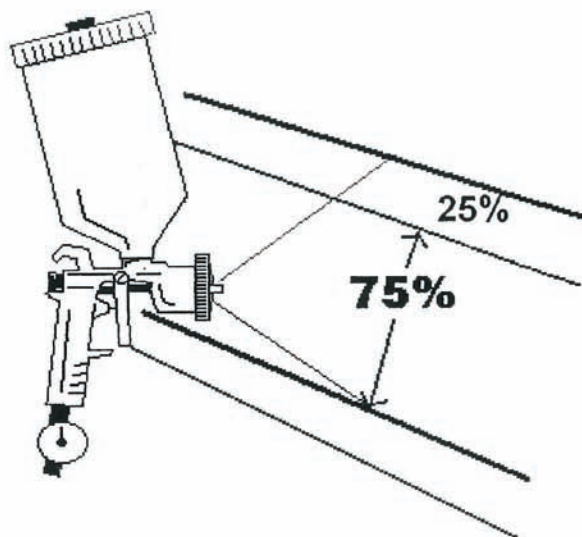
APPLICATION TECHNIQUES

Spray Pattern Overlap

Custom painting requires a good understanding of the basics. It demands attention to detail and a working knowledge of sound application techniques. The following is a brief description of both a 50% and 75% spray pattern overlap.



50% Overlap



75% Overlap

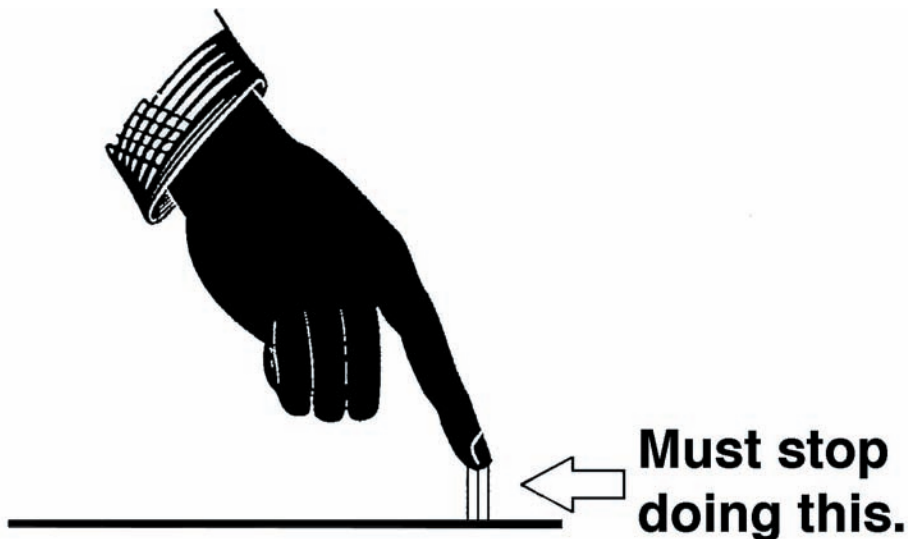
- Measure spray gun pattern width, do not guess.
- Adjust spray gun for pattern consistency.
- Restrict amount of fluid being delivered when using 75% overlap to avoid runs and sags.
- 75% overlap generally used for Pearls and the first 2 to 3 coats of Kandys.

URETHANES / POLYURETHANES

Flash Between Coats

The times allowed between coats of Urethanes and Polyurethanes are critical for the success of a custom paint job. Actual times vary depending on temperature, air flow and humidity. One of the safest ways to determine when a finish is ready for the next coat is by the "string" method. This method is as follows:

- Find area on masking tape closest to "wettest" point of sprayed finish.
- Press finger into finish and lift up approximately one inch.
- Look for fine hair-like strings pulling up with finger.
- Continue this process using a different spot each time until finish stops "stringing".
- Once finish still feels sticky, but does not "string", it is ready for next coat.
- Do not allow House of Kolor® Urethanes or Polyurethanes to completely dry to touch. If finish completely dries to touch, finish must not be recoated for 12 hours or lifting may occur.



TECH TIPS

SANDPAPER GRADING SYSTEMS

When choosing a sandpaper, it is important to remember that sandpapers produce a significantly different scratch pattern based on the different grading systems.

CAMI (Coated Abrasives Manufacturer's Institute) graded sandpaper has long been the standard system of measurement in the automotive refinsh industry in America. It is known as having a wider variety of grit

FEPA graded sandpaper is new from the Federation of European Producers of Abrasives. It is regarded as having a tighter measurement system, with closer tolerances for particle size. The result, as shown in the chart, is that the scratch patterns of FEPA and CAMI differ significantly the higher you go.

Sanding Grit Recommendations

KP2CF, KD2000 Epoxy Primers		
Substrate	CAMI Grade	FEPA Grade (P Grit)
Bare Metal / Old Finish	Minimum 80 Grit Dry	Minimum 80P Grit Dry
Ko-Seal® II		
Substrate	CAMI Grade	FEPA Grade (P Grit)
KP2CF, KD2000, and Old Finish	240 to 280 Grit Dry 400 to 500 Grit Wet	280P to 320P Grit Dry 600P to 800P Grit Wet
Shimrin® Base Coats		
Substrate	CAMI Grade	FEPA Grade (P Grit)
** Ko-Seal® II (after 3 hours) and SG100 Intercoat Clear	280 Grit Dry 500 Grit Wet Maroon Scuff Pad	320P Grit Dry 800P Grit Wet Maroon Scuff Pad
UC, UFC, Urethane Clear (Flow Coating)		
Substrate	CAMI Grade	FEPA Grade (P Grit)
UC, UFC Urethane Clear	280 Grit Dry 500 Grit Wet	320P Grit Dry 800P Grit Wet

**** NOTE:** If Ko-Seal® II has cured beyond 24 hours, DO NOT use a Maroon Scuff Pad. It must be sanded and resealed.

To identify the grade sand paper you are working with; FEPA grade will have a “P” either proceeding or following the grit size. CAMI grade will not have the letter “P” on the sand paper.

Examples: FEPA Grade 400P or P400
CAMI Grade 400 (No “P” proceeding or following the grit size)

CAMI GRADE	FEPA GRADE
	P
1200	
	2500
1000	
	2000
800	
	1500
	1200
600	
	1000
500	
	800
400	
	600
360	
	500
	400
320	
	360
280	
	320
	280
240	
	240
220	
	220
	180
150	
	150
120	
	120
100	
	100
80	
	80
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40	
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36	
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16	

VOC INFORMATION

PRODUCT	PACKAGED VOC **		RECOMMENDED MIXING RATIOS (by volume)	FAST REDUCER (RU310) VOC**		SLOW REDUCER (RU312) VOC**	
	lbs./gal.	grams/liter		lbs./gal.	grams/liter	lbs./gal.	grams/liter
BC25 Black Base	5.83	699	2 parts paint / 1 part reducer	6.26	751	6.36	762
BC26 White Base	5.45	653	2 parts paint / 1 part reducer	5.99	718	6.11	732
BC Glamour Metallic	6.31	756	2 parts paint / 1 part reducer	6.60	791	6.68	800
FBC Fine Metallic	6.35	761	2 parts paint / 1 part reducer	6.63	795	6.70	803
MBC Metajuls™ Metallic	6.33	758	2 parts paint / 1 part reducer	6.62	793	6.69	801
NE Neons	5.19	622	2 parts paint / 1 part reducer	5.80	695	5.93	711
PBC Designer Pearls	6.33	758	2 parts paint / 1 part reducer	6.62	793	6.69	802
PBC Designer Pearls	6.33	758	1 part paint / 1 part reducer	6.78	812	6.87	823
PBC Black Pearls	6.23	747	2 parts paint / 1 part reducer	6.55	785	6.63	794
PBC Black Pearls	6.23	747	1 part paint / 1 part reducer	6.72	805	6.82	818
PC Universal Pearls	5.90	708	2 parts paint / 1 part reducer	6.31	757	6.41	768
SG Graphic Kolors	5.75	689	2 parts paint / 1 part reducer	6.21	744	6.31	756
MB Marblizer®	5.78	693	Ready to Spray	5.78	693	5.78	693
KBC Kandy Basecoats	6.39	766	2 parts paint / 1 part reducer	6.66	798	6.73	807
KF Kameleon® Kolor	6.38	765	2 parts paint / 1 part reducer	6.66	798	6.72	806
MC Kosmic Krome®	7.37	883	Ready to Spray	7.37	883	7.37	883
UB04 Jet Set Black	4.38	524	2 parts paint/1 part reducer/1 part KU100	5.02	601	5.15	618
UB05 Brite White	4.09	490	2 parts paint/1 part reducer/1 part KU100	4.87	583	5.01	600
UFB04 Jet Set Black	4.48	536	2 parts paint/1 part reducer/1 part KU100	5.07	608	5.20	624
UFB05 Brite White	3.81	457	2 parts paint/1 part reducer/1 part KU100	4.72	566	4.87	584
UFB06 Kosmos Red	4.28	513	2 parts paint/1 part reducer/1 part KU100	4.96	595	5.10	612
UK Kandys	4.88	585	2 parts paint/1 part reducer/1 part KU100	5.28	633	5.40	648
KK Kandy Koncentrates	5.22	626	N/A	5.22	626	5.22	626
UC01 Kosmic Acrylic Urethane Klear	4.71	564	2 parts paint/1 part reducer/1 part KU100	5.19	622	5.32	638
UC35 Kosmic Acrylic Urethane Klear	0.63	76	2 parts paint/1 part reducer/1 part KU150	3.11	373	3.52	422
UC35 Kosmic Acrylic Urethane Klear	0.63	76	2 parts paint/1 part RU300/1 part KU150	0.45	54	0.45	54
UFC01 Kosmic Urethane Flo-Klear	4.15	497	2 parts paint/1 part reducer/1 part KU100	4.90	587	5.04	604
UFC19 Urethane Komply Klear® II	2.41	289	2 parts paint/1 part reducer/1 part KU150	3.64	436	3.94	473
UFC19 Urethane Komply Klear® II	2.41	289	2 parts paint/1 part RU300/1 part KU150	1.89	226	1.89	226
UFC35 Kosmic Urethane Flo-Klear	0.75	90	2 parts paint/1 part reducer/1 part KU150	3.09	371	3.50	419
UFC35 Kosmic Urethane Flo-Klear	0.75	90	2 parts paint/1 part RU300/1 part KU150	0.54	65	0.54	65
UCC01 Kosmic Acrylic Urethane Kustom Klear	2.76	331	2 parts paint/1 part reducer/1 part KU150	3.88	465	4.18	501
SG100 Intercoat Clear	5.72	685	2 parts paint / 1 part reducer	6.18	740	6.28	753
SG150 Intercoat Pearl & Flake Karrier	5.92	709	2 parts paint / 1 part reducer	6.32	758	6.42	769
USG100 Intercoat Barrier	0.02	1.93	3 parts paint/1 part reducer/1 part KU100	3.80	455	4.07	488

VOC INFORMATION (continued)

PRODUCT	PACKAGED VOC **		RECOMMENDED MIXING RATIOS (by volume)	FAST REDUCER (RU310) VOC**		SLOW REDUCER (RU312) VOC**	
	lbs./gal.	grams/liter		lbs./gal.	grams/liter	lbs./gal.	grams/liter
KUSTOM KOLOR® ACRYLIC LACQUER							
KK Kandy Koncentrates	5.22	626	N/A	5.22	626	5.22	626
C01 Clear	5.18	621	150% (1 part paint / 1.5 parts thinner)	6.37	764	6.54	784
SC01 Clear	5.16	618	150% (1 part paint / 1.5 parts thinner)	6.36	762	6.53	783
DRY PEARLS, FLAKES, KOSMIC LONG-GLO							
PP Pearl Paste	4.58	549	N/A	4.58	549	4.58	549
DP, DR Dry Pearl	-	-	DRY			-	-
F, MF, UMF Flakes	-	-	DRY			-	-
KLK Kosmic Long-Glo	-	-	DRY			-	-
IP Ice Pearls	-	-	DRY			-	-
KPF Kameleon® Pearls	-	-	DRY			-	-
KDP Kosmic Pearls	2.4	291	DRY	2.4	291	2.4	291
KOP Kameleon® Opals	-	-	DRY			-	-
PRIMERS & SEALERS							
KD2000 Direct to Metal Primer	1.93	231	4 parts paint / 1 part catalyst / 10% part RU300	2.07	248	2.07	248
KDA2000 Direct to Metal Activator	2.71	325		2.71	325	2.71	325
KP2CF Chromate Free Kwikure Primer	3.94	472	1 parts paint / 1 part catalyst / 10% part reducer	4.19	503	4.26	510.3
KP2CF-B Chromate Free Kwikure Activator	4.72	566		4.72	566	4.72	566
KP21 Kwikure Epoxy Primer	2.36	283	4 parts paint / 1 part catalyst / 10% part RU300	2.22	226	2.22	226
KP21-B Kwikure Activator	0.78	94		0.78	94	0.78	94
Ko-Seal® II (KS10, KS11, KS12)	4.31	516	4 parts paint / 1 part reducer / 1 part KU150	4.48	537	4.60	552
Ko-Seal® II (KS210, KS211, KS212)	2.37	284	4 parts paint / 1 part reducer / 1 part catalyst	3.19	382	3.42	410
Ko-Seal® II (KS210, KS211, KS212)	2.37	284	4 parts paint / 1 part RU300 / 1 part KU150	2.08	249	2.08	249
REDUCERS, THINNERS, & COMPONENTS							
RU101 Thinner	7.32	878	N/A	7.32	878	7.32	878
RU202 Thinner	7.29	874	N/A	7.29	874	7.29	874
RU300 (RU302) VOC Exempt Slow Reducer	0	0	N/A	0	0	0	0
RU301 VOC Exempt Fast Reducer	0	0	N/A	0	0	0	0
RU310 Fast Reducer	7.34	880	N/A	7.34	880	7.34	880
RU311 Medium Reducer	7.29	873	N/A	7.29	873	7.29	873
RU312 Slow Reducer	7.42	889	N/A	7.42	889	7.42	889
RU313 Very Slow Reducer	7.35	881	N/A	7.35	881	7.35	881
RU315 Retarder	7.85	941	N/A	7.85	941	7.85	941

**** NOTE:** VOC reported as coating VOC using Fast Reducer. VOC will vary slightly with Reducer selection. All calculations made assuming PCBTF and Dimethyl Ketone are exempt solvents.

VOC INFORMATION (continued)

PRODUCT	PACKAGED VOC **		RECOMMENDED MIXING RATIOS (by volume)	FAST REDUCER (RU310) VOC**		SLOW REDUCER (RU312) VOC**	
	lbs./gal.	grams/liter		lbs./gal.	grams/liter	lbs./gal.	grams/liter
REDUCERS, THINNERS, & COMPONENTS							
KE170 Krator Eliminator	6.94	832	N/A	6.94	832	6.94	832
KU100 Catalyst	4.44	553	N/A	4.44	553	4.44	553
KU150 Catalyst	0	0	N/A	0	0	0	0
KU151 Catalyst	0	0	N/A	0	0	0	0
KV1 Converter	0.9	108	N/A	0.9	108	0.9	108
STRIPING & LETTERING ENAMELS (& COMPONENTS)							
U01 - U36 Striping Enamels	5.09	610	Ready as Packaged	5.09	610	5.09	610
U00 Striping Reducer	7.56	906	N/A	7.56	906	7.56	906
KU200 Striping Catalyst	3.68	441	N/A	3.68	441	3.68	441
UC03 Striping Klear	3.84	460	4 parts paint / 1 part catalyst	3.81	456	3.81	456
SPECIALTY PRODUCTS							
AP Adhereto	6.90	827	As Is	6.90	827	6.90	827
AX01 Accelerator	6.63	794	As Is	6.63	794	6.63	794
FA01 Flattening Agent	5.45	653	As Is	5.45	653	5.45	653
KC10 Wax & Grease Remover	6.43	770	As Is	6.43	770	6.43	770
KC20 Post Sanding Cleaner	0.39	47	As Is	0.39	47	0.39	47
HH Hi-Heat™ Black	5.85	702	As Is	5.85	702	5.85	702
SBS10 Bleed Check Sealer	3.30	396	4 parts SBS10 / 1 part catalyst / 1 part reducer	4.05	486	4.18	501

**** NOTE:** VOC reported as coating VOC using Fast Reducer. VOC will vary slightly with Reducer selection. All calculations made assuming PCBTF and Dimethyl Ketone are exempt solvents.

California Products and Application Procedures.

Rule 1151

Rule 4602 & 4612 Phase II

Appendix A

The South Coast Air Quality Management District (Rule 1151) (www.aqmd.gov) and the San Joaquin Valley Air Quality Management District (Rule 4602 and 4612 Phase II) (www.valleyair.org) have made significant changes to their current rules.

The South Coast Air Quality Management District (Rule 1151) rule goes into effect July 1, 2008. Any product manufactured prior to July 1, 2008, can be used through December 31, 2008. This district consists of the following areas:

Los Angeles County

Orange County

Western San Bernardino County

Western Riverside County

The San Joaquin Valley Air Quality Management District (Rule 4602 and 4612 Phase II) goes into effect January 1, 2009. This district consists of the following areas:

San Joaquin County

Stanislaus County

Madera County

Merced County

Fresno County

Kings County

Tulare County

Western Kern County

If you intend to do your custom paint job in any of the above listed areas after the dates stated, you must only use the products listed and follow the directions as outlined in this manual under California Products and application procedures, Appendix A.

**GENERAL INFORMATION**

KD2000 Direct to Metal Epoxy Primer was formulated with a hybrid of epoxy and acrylic polymers, which provide excellent adhesion, good corrosion resistance, productive dry times, and ease of sanding. These primers emit very low amounts of Volatile Organic Compounds (VOCs), Hazardous Air Polluting Solvents (HAPS), and contain no isocyanides.

KD2000 may be applied to the existing OEM finish, bare steel, aluminum, fiberglass, and galvanized surfaces. Its tenacious adhesion, hi-build, excellent durability, and water and corrosion resistance make it a logical choice for the basis of a long lasting paint job. KD2000 Epoxy Primer:

- Resists cracking for years and years
- Cures for sanding and finishing in 3 hours at 77 degrees
- Prevents plastic filler staining or bleed through
- Will not stain, shrink, or swell from sand scratches

KD2000 Direct to Metal Epoxy Primer is the first step to a great long lasting custom finish.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- DO NOT USE ANY ACID BASE PRODUCTS SUCH AS SELF-ETCHING PRIMER, ETC. UNDER THE KD2000 PRIMER. THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.
- KD2000 PREVENTS BLEED THROUGH OF STAINS BY POLYESTER FILLERS AND GLAZES IF MILLAGE AT LEAST 2 MILS AFTER SANDING. APPROXIMATE BUILD IS 1 MIL PER COAT WITH 10% REDUCTION USING A PRIMER GUN.
- KD2000 IS A HIGH BUILD SANDABLE EPOXY PRIMER AND IT IS NOT RECOMMENDED TO APPLY POLYESTER BODY FILLER OR GLAZEING PUTTY OVER THIS PRIMER. YOU MUST APPLY 2 MORE COATS OF KD2000 OVER THE GLAZING PUTTY PRIOR TO TOP COATING.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.

**SUBSTRATE**

- OEM finish
- Body Fillers
- Bare Steel
- Bare aluminum
- Bare fiberglass
- Galvanized surfaces

**PREPARATION**

Read "TECH PREP" thoroughly before you begin painting. Prepare vehicle using normal methods for urethane finishing. Surface to be primed should be free of wax, grease, rust, etc. Clean with KCA100 prior to sanding. Do not apply KD2000 over uncatalyzed primers. KD2000 may be applied over properly prepared OEM factory primers and finishes, but for maximum adhesion and corrosion protection it is best to apply KD2000 directly to the bare substrate. Ko-Seal® II may be applied over properly prepared previously painted surfaces. **See Ko-Seal® II Tech Sheet for application information.**

NOTE: PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR BARE METAL AND OLD FINISH SANDING.

NOTE: DO NOT USE ANY ACID BASE PRODUCTS SUCH AS SELF-ETCHING PRIMER, ETC. UNDER THE KD2000 PRIMER. THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.

NOTE: IF YOU FIND IT NECESSARY TO USE A METAL CONDITIONER TO REMOVE RUST, ETC., BE SURE TO THOROUGHLY CLEAN AND NUTRALIZE THE TREATED AREA FOLLOWING THE CONDITIONER MANUFACTURERS RECOMMENDATIONS, THEN USING OUR KC20 POST SANDING CLEANER WITH A MAROON SCUFF PAD TO INSURE ALL ACID RESIDUE HAS BEEN REMOVED BEFORE PRIMING. IF NOT, THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.

**SANDING THE SUBSTRATE****Striping the old finish**

- Minimum 80P grit DA sandpaper

**Bare metal**

- Minimum 80P grit DA sandpaper

Body fillers

- Minimum 40P grit UNDER the areas being filled with polyester body filler
- 80P grit over the body filler

OEM Finish

- 80P to 180P grit DA Sandpaper

**COMPONENTS**

- KD2000 (Primer)
- KDA2000 (Activator)
- RU300 Exempt Reducer

**MIXING RATIO**

KD2000 Epoxy Primer: 4 parts
KDA2000 Activator: 1 part
RU300 Exempt Reducer: Up to 10% (optional)

Aggressively mix KD2000 Primer thoroughly before mixing the two parts together. Add up to 10% RU300 Exempt Reducer for improved sprayability and flow out. A 10% reduction will give approximately 1 mil dry film thickness per coat. Always measure, do not guess.

Stir mixed components well to ensure a thorough cure, use a paint shaker for best results. No incubation time is needed.

- Pot life: 2-3 hours at 70°F. Shop conditions can vary pot life.

KD2000 DIRECT TO METAL EPOXY PRIMER

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.5 to 1.8 (Depending on the size of object being painted)
- Trigger Pull = Full



APPLICATION

Strain mixed primer into gun. Apply 2-3 wet coats with 50% pattern overlap. Apply 2 extra coats over bodywork. Allow flash time between coats (flashes dull).

KD2000 FLASH TEST - Allow Primer to dry dull before next coat is applied. Usually 5-10 minutes.

NOTE: KD2000 PREVENTS BLEED THROUGH OF STAINS IF MILLAGE IS 2 MILS AFTER SANDING OR ABOVE. APPROXIMATE BUILD IS 1 MIL PER COAT WITH 10% REDUCTION USING A PRIMER GUN



DRY TIME

Allow dry time. We recommend 3-6 hours before sanding and finishing when 3 coats of KD2000 is used at 70°F. Longer dry times are needed if more than 3 coats are applied. KD2000 may also be force dried at 140°F for 45 minutes for faster sanding. After finish sanding, the vehicle is now ready for Ko-Seal® II, followed by base coats and topcoats.



Air Dry: 3-6 hours

Force Dry: 40 minutes @ 140 degrees

FINISH SANDING

Prior to sanding, apply A Guide Coat. During the sanding process, the contrasting color of the guide coat will remain in pits and scratches and become a guide telling you how much sanding is required to smooth the KD2000. Remove the guide coat and a few more sanding strokes and move on. Be careful so you don't expose any polyester filler or glaze. If the primer is less than 2 mils after sanding, bleed through of the polyester filler/glaze is possible.



- Initial Block Sanding (Optional, see info below)
 - o 100P to 150P grit dry sandpaper
- Finish Sanding
 - o Dry Sandpaper = 280P to 320P grit (CAMI grand = 240 to 280 grit)
 - o Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - o Tight Areas (door jams, etc.) = Maroon scuff pad

Block sand wet or dry. IF POLYESTER FILLER/GLAZE IS EXPOSED, RE-PRIME WITH KD2000 TO PREVENT STAINING. You may dry sand KD2000 with 100 or 150 grit, then re-prime with 2 or 3 more coats of KD2000. KD2000 may also be wet sanded. Then simply seal coat with our Ko-Seal® II and apply topcoats. **PLEASE**

REFER TO SANDING GRIT RECOMMENDATIONS IN THIS MANUAL.

NOTE: Do not use alkyd or synthetic sealers or primers with House of Kolor® products as lifting may occur.

NOTE: To prevent bleeding or discoloration of base coats caused by body fillers, at least 2 mils of primer must remain after sanding. (1 coat equals approximately 1 mil when sprayed with production equipment using 10% reduction).

TOPCOATING

Topcoat with Ko-Seal® II. (See Tech Sheet on Ko-Seal® II)

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Primer
- Actual VOC RTS less exempt solvents: 1.37 lbs./gal. (164.4 g/L) max.
- Regulatory VOC RTS less exempt compounds: 2.08 lbs./gal. (250.0 g/L) max.
- Density: 11.81 lbs./gal. (1417.2 g/L) (Max. VOC Color)
- Weight % Volatiles: 40.5%
- Weight % exempt compounds: 28.9%
- Weight % water: 0%



HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

Ko-Seal® II is a two component acrylic urethane primer sealer. Sealers are a must in custom finishing and a step that should never be overlooked. Ko-Seal II does 3 important things:

- Act as a bond coat between the substrate and topcoats.
- Act as a holdout agent to prevent topcoats from soaking into the substrate and reducing gloss.
- Make the object to be painted an appropriate color for faster coverage of topcoats.

Can be applied over properly prepared and sanded previously painted OEM surfaces, KD-Series House of Kolor® Primers for proper adhesion of topcoats.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- KO-SEAL® II **CANNOT** BE APPLIED OVER BARE METAL SURFACES OF ANY KIND. KO-SEAL® II MUST BE APPLIED OVER SANDED AND CLEAN KD2000 EPOXY PRIMER OR PROPERLY PREPARED AND SANDED PREVIOUSLY PAINTED SURFACES FOR PROPER ADHESION.
- DO NOT ATTEMPT TO TOPCOAT KO-SEAL® II EARLIER THAN 1 HOUR AS WRINKLING AND LIFTING CAN OCCUR.
- DO NOT ATTEMPT TO TOPCOAT KO-SEAL® II AFTER 2 HOURS AS DELAMINATION OF THE FINISH IS POSSIBLE.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- OEM finish
- KD Epoxy Primers



PREPARATION

Read "TECH PREP" thoroughly before you begin painting. Use only House of Kolor®'s KD Epoxy Primers over bare metal substrates or metal substrates with bodywork. **See tech sheet for more information on KD Epoxy Primers.**



SANDING THE SUBSTRATE

- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Tight Areas (door jams, etc.) = Maroon scuff pad



COMPONENTS

- Ko-Seal® II
- KU150, KU151 Exempt Catalyst
- RU300 Exempt Urethane Reducer



MIXING RATIO

Ko-Seal® II	4 parts
KU150 or KU151 Exempt Catalyst	1 part
RU300 Exempt Reducer	1 part

- Pot life: 1 Hour at 70°F. Shop conditions can vary pot life.

NOTE: You may intermix KS210 (white) and KS211 (black) Ko-Seal II to create various shades of gray sealer. This may be necessary when you plan to use Shimrin PBC42, PBC44, or PBC49 base coats.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Strain the sealer into the paint gun. Gun distance while spraying should be approximately 5 to 6 inches.

Apply 1 or 2 medium wet coats with 50% pattern overlap. Walk long objects. Be sure of thorough coverage. Allow flash time between coats.

KO-SEAL® II FLASH TEST - ALLOW TO FLASH DULL BETWEEN COATS. USUALLY 5 TO 10 MINUTES.

FINISH SANDING

If Ko-Seal® II cures longer than 2 hours we recommend scuffing with a maroon scuff pad. PLEASE REFER TO SANDING GRIT RECOMMENDATIONS IN THIS MANUAL. (Dry time may vary with weather and shop conditions).

NOTE: If 24 hours dry time has elapsed, wet sand and reseal surface for positive adhesion of topcoats.



DRY TIME

Allow to dry 1 hour but no longer than 2 hours.

RECOAT

After 1 hour, top coat the Ko-Seal® II with Shimrin® base coats or when using KS212 as the silver metallic base coat color you may topcoat with UC35 / KK candy mix.

KO-SEAL®II ACRYLIC URETHANE PRIMER SEALER

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)



- Coatings Category: Primer
- Actual VOC RTS less exempt solvents: 1.03 lbs./gal. (123.3 g/L) max.
- Regulatory VOC RTS less exempt compounds: 2.08 lbs./gal. (249.0 g/L) max.
- Density: 12.09 lbs./gal. (1451.0 g/L) (Max. VOC Color)
- Weight % Volatiles: 51.4%
- Weight % exempt compounds: 42.9%
- Weight % water: 0%

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

SEALER REFERENCE CHART

		RECOMMENDED SEALER		
BASECOAT SYSTEM	CODE	KS10 OR KS210 WHITE	KS11 OR KS211 BLACK	KS12 OR KS212 METALLIC
SHIMRIN® DESIGNER PEARLS	PBC30 THRU PBC68	•	•	
SHIMRIN® BLACK PEARLS	PBC100 THRU PBC107		•	
UNIVERSAL PEARLS	PC'S AND P'S	•	•	
SHIMRIN® GRAPHIC KOLORS	SG'S	•		
SHIMRIN® NEONS	NE'S	•		•
SHIMRIN® KANDY BASECOATS	KBC'S		•	•
SHIMRIN® GLAMOUR METALLICS	BC'S	•	•	•
SHIMRIN® FINE METALLICS	FBC'S	•	•	•
SHIMRIN® METALLIC BASES	MBC'S		•	•
SOLID COLORS	BC25 BLACK		•	
SOLID COLORS	BC26 WHITE	•		
KANDYS	UC / KK Mix			•
KAMELEON® KOLORS	KF'S		•	
MARBLIZER®	MB'S		•	
FLAKES	F'S / MF'S / UMF'S		•	
KOSMIC LONG-GLO	KLG'S	•		
DRY PEARLS	DR'S / DP'S	•	•	
ICE PEARLS	IP'S	•	•	•
KAMELEON® PEARLS	KPF'S		•	
KOSMIC PEARLS	KDP'S	•	•	
KAMELEON® OPALS	KOP'S	•		



GENERAL INFORMATION

Shimrin® Metallic Color Bases (BC & FBC) are universal base coats that may simply be cleared for a final finish, or used as a base coat for Kandys. BC Metallic's are a course, highly brilliant, and very clean metallic colors not matched in the industry. The FBC Metallic's are a finer version of the BC's and produces the old school look, especially under Kandy's.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- WITH THE ADDITION OF KV1 KOSMIC KONVERTOR TO HOUSE OF KOLORS SHIMRIN® BASE COATS (SEE TECH SHEET ON KV1 KOSMIC KONVERTOR), YOU ARE CHANGING THE BASE MATERIAL FROM A NON-CATALYZED PRODUCT TO A CATALYZED BASE COAT, THEREBY INCREASING THE SOLIDS CONTENT AND LOWERING THE VOC'S.
- SOME CAUTION SHOULD BE USED WHEN PULLING YOUR MASKING TAPE AS TEARING OF THE FINISH IS POSSIBLE.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- KO-SEAL® II
- USG100 Intercoat Barrier Klear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.

GROUND COAT

- Sealer (Ko-Seal® II)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Ko-Seal® II Sealers are commonly used and recommended as the ground coat for BC and FBC Metallic Bases. Use Ko-Seal® II sealer for faster coverage of base coats. When using sealer, allow flash time. **See tech sheet for information on Ko-Seal® II application.**

NOTE: *Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.*



SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- USG100, Cured Top Coat Clears & OEM Finishes (artwork only)
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad (difficult to reach areas)



COMPONENTS

- BC, FBC Shimrin® base coat
- KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 2 parts KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- 1 part BC / FBC Metallic Base Coat
- 1 part KU150 or KU151 Exempt Catalyst
- Pot life: 1 Hour at 70°F. Shop conditions can vary pot life.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

After mixing, strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 3-4 **MEDIUM** coats with 50% pattern overlap. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. Again, **MEDIUM** coats work best. Allow flash time between coats.

NOTE: *3 coats of Shimrin® BC or FBC Bases equals 3/4 to 1 mil, of film build. Use caution when pulling your tape, as tearing the finish is possible.*

DRY TIME

Allow dry time before Kandy or clear is applied (usually about 60 minutes and not longer than 2 hours). Topcoat within 2 hours or apply USG100 Intercoat Barrier Klear.

FLASH TEST - AT 5 TO 7 MINUTES YOU WILL FEEL THE FINISH TO BE TACKY BUT NOT TRANSFERING TO YOUR FINGER. DO TEST AT THE TAPE EDGE AS FINGER PRINTING IS POSSIBLE. AT 1 HOUR THE FINISH WILL FEEL DRY TO THE TOUCH.

Monitor closely for maximum merging of coats



ARTWORK & INTERCOAT CLEAR

DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, apply 1 or 2 medium coats of USG100 Intercoat Barrier Klear. The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT BARRIER KLEAR. See tech sheet for more information on USG100 Intercoat Barrier Klear. NOTE: DO NOT SAND SHIMRIN® METALLIC BASES DIRECTLY. Apply USG100 Intercoat Barrier Klear for base coat protection if sanding is required. If you directly sand the Shimrin® metallic, you must re-base. NOTE: USG100 Intercoat Barrier Klear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE USG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will effect base coats. Use KC20 Post Sanding Cleaner for cleanup.**

KANDY COAT (optional)

Shimrin® BC and FBC Bases / KV1 Mix may be Kanded with Urethane enamel. See appropriate tech sheets for Kandy application. For artwork, our Kandy Koncentrates may be mixed with SG150 / KV1 Intercoat Karrier Mix up to 10% to meet the 3.5 lbs/gal VOC rule for Kandy graphics. See KK & SG150 tech sheets for more information

KLEAR COAT

ALL SHIMRIN® BC AND FBC BASES MUST BE CLEAR-COATED. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

ADDITIONAL INFORMATION

Shimrin® BC and FBC Bases may be intermixed for hundreds of color combinations. BC and FBC Bases may also be mixed with other SHIMRIN®s®, including the Designer Pearls, Neons, and Graphic Kolors. The possibilities are endless. Create your own one-of-a-kind custom finish. Shimrin® Pearl and Metallic Bases may also be added, in small amounts (no more than 25%), directly to the UC35 / KK Kandy mix to ease touch-ups or for additional creative effects. Simply catalyze and mix by volume as usual.

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- BC Series
 - Coatings Category: Color Coating
 - Actual VOC RTS less exempt solvents: 1.75 lbs./gal. (209.4 g/L) max.
 - Regulatory VOC RTS less exempt compounds: 3.29 lbs./gal. (395.2 g/L) max.
 - Density: 8.52 lbs./gal. (1022.0 g/L) (Max. VOC Color)
 - Weight % Volatiles: 68.4%
 - Weight % exempt compounds: 47.9%
 - Weight % water: 0%
- FBC Series
 - Coatings Category: Color Coating
 - Actual VOC RTS less exempt solvents: 1.85 lbs./gal. (221.4 g/L) max.
 - Regulatory VOC RTS less exempt compounds: 3.39 lbs./gal. (407.0 g/L) max.
 - Density: 8.63 lbs./gal. (1035.0 g/L) (Max. VOC Color)
 - Weight % Volatiles: 68.8%
 - Weight % exempt compounds: 47.4%
 - Weight % water: 0%



HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

MBC SHIMRIN® METAJULS™ BASE COATS

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II



GENERAL INFORMATION

Shimrin® MBC Metajuls Metallic Bases are our largest size, most brilliant metallic basecoats that feature exceptional sparkle and brightness. Metajuls are available in four unique colors and three flake particle sizes. Pale Gold, Platinum, and Black Diamond are excellent choices for Kandy finishes, while the Prism Effect produces an amazing rainbow effect (**Note: Prism Effect IS NOT recommended for use under Kandy finishes**). When used as a basecoat, MBC01 creates bright dazzling Kandy colors, while MBC03 can create dark rich Kandy colors. MBC02 is a medium color used to slightly darken Kandy colors. All three make Kandys with exceptional sparkle in sunlight. They may also be used for a final finish.

When ordering MBC Metajuls Metallic Bases, please use the following codes to specify the particle size and color:

Code	Description	Code	Description
MBC01FF	Fine Pale Gold	MBC01CF	Coarse Pale Gold
MBC02FF	Fine Platinum	MBC02CF	Coarse Platinum
MBC03FF	Fine Black Diamond	MBC03CF	Coarse Black Diamond
MBC01	Standard Pale Gold	MBC04	Prism Effect (Note: NOT recommended for use under Kandy finishes)
MBC02	Standard Platinum		
MBC03	Standard Black Diamond		

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- WITH THE ADDITION OF KV1 KOSMIC KONVERTOR TO HOUSE OF KOLOR'S SHIMRIN® BASE COATS (SEE TECH SHEET ON KV1 KOSMIC KONVERTOR), YOU ARE CHANGING THE BASE MATERIAL FROM A NON-CATALYZED PRODUCT TO A CATALYZED BASE COAT, THEREBY INCREASING THE SOLIDS CONTENT AND LOWERING THE VOC'S.
- SOME CAUTION SHOULD BE USED WHEN PULLING YOUR MASKING TAPE AS TEARING OF THE FINISH IS POSSIBLE.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- KO-SEAL® II
- USG100 Intercoat Barrier Klear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from Polyester fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.

GROUND COAT

- Sealer (Ko-Seal® II)
- BC, FBC Shimrin® base coat

MBC's must have a proper Base to achieve their maximum effect. Our Ko-Seal® II's work extremely well as a base.

A: MBC01 Pale Gold will work over KS212 Silver Sealer; however for the perfect base sealer: To 24 oz. of mixed KS212 add 1 oz. of KK14 Spanish Gold Intensifier, also a mix of BC01 and BC02 will match the MBC01 for an excellent base.

B: MBC02 Platinum works over KS212 but to closer match the Platinum, add some KS211 Black Sealer. For a beautiful darker Kandy apply 3-4 coats of MBC02 over KS211 or BC25. Try this, apply KS212, let dry one hour. Apply 1-2 coats USG100, let dry 3 to 4. Then do art tapeouts, twotone or blend over sealer base using 1-2 medium coats of BC25 Black or any contrasting base color. Now apply 3-4 coats of MBC02 over both base colors. Allow dry time, lightly wipe with a white or grey scuff pad, air and tack. Then apply the Kandy kolor of your choice; way kool!

C: MBC03 Black Diamond; simply apply 3 coats over KS211 Black Sealer, or BC25 Black will work also. Many other darker base colors also add creativity; try BC10 Pavo Purple as a base under MBC03 and follow with Kandy or simply clear.

D: MBC04 Prism Effect: Apply 3-4 coats over KS212 or BC02. For a darker look, apply over KS211, or BC25. For special effects, try over any of our Shimrin bases or try adding a little KK Koncentrates (5% or less).

NOTE: ALWAYS do a test panel prior to committing to the paint job.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout and gloss retention.

SANDING THE SUBSTRATE

- KO-SEAL® II (see tech page on Ko-Seal® II)
- USG100, Cured Top Coat Clears & OEM Finishes (artwork only)
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad (difficult to reach areas)



COMPONENTS

- MBC Metajuls™ Shimrin® base coat
- KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 2 parts KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- 1 part BC / FBC Metallic Base Coat
- 1 part KU150 or KU151 Exempt Catalyst
- Pot life: 1 Hour at 70°F. Shop conditions can vary pot life.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle
 - Fine & Medium Metajuls™ = 1.3 to 1.5 (Depending on the size of object being painted)
 - Coarse Metajuls™ = 1.6 to 1.8 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

After mixing, strain the paint into the paint gun. Use a coarse strainer or none at all. Strainers are not used with larger flake. Gun distance while spraying should be approximately 4-6 inches, depending on gun used and gun adjustments. Apply 3-4 **MEDIUM** coats with 75% pattern overlap. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. Again, **MEDIUM** coats work best. Allow flash time between coats.

NOTE: 3 coats of Shimrin® MBC Bases equals 3/4 to 1 mil, of film build. Use caution when pulling your tape, as tearing the finish is possible.



DRY TIME

Allow dry time before Kandy or clear is applied (usually about 60 minutes and not longer than 2 hours). Topcoat within 2 hours or apply USG100 Intercoat Barrier Klear.

FLASH TEST - AT 5 TO 7 MINUTES YOU WILL FEEL THE FINISH TO BE TACKY BUT NOT TRANSFERRING TO YOUR FINGER. DO TEST AT THE TAPE EDGE AS FINGER PRINTING IS POSSIBLE. AT 1 HOUR THE FINISH WILL FEEL DRY TO THE TOUCH.

Monitor closely for maximum merging of coats.



ARTWORK & INTERCOAT CLEAR (optional)

DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, apply 1 or 2 medium coats of USG100 Intercoat Barrier Klear. The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT Barrier Klear. See tech sheet for more information on USG100 Intercoat Barrier Klear. NOTE: DO NOT SAND SHIMRIN® METALLIC BASES DIRECTLY. Apply USG100 Intercoat Barrier Klear for base coat protection if sanding is required. If you directly sand the Shimrin® metallic, you must re-base. NOTE: USG100 Intercoat Barrier Klear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE USG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will effect base coats. Use KC20 Post Sanding Cleaner for cleanup.**

KANDY COAT (optional)

Shimrin® MBC / KV1 Mix may be Kanded with Urethane enamel. See appropriate tech sheets for Kandy application. For artwork, our Kandy Concentrates may be mixed with SG150 / KV1 Intercoat Clear Mix up to 10% to meet the 3.5 lbs/gal VOC rule for Kandy graphics. See KK & SG150 tech sheets for more information.

KLEAR COAT

ALL SHIMRIN® MBC BASE COATS MUST BE CLEAR-COATED. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Color Coating
- Actual VOC RTS less exempt solvents: 1.74 lbs./gal. (209.2 g/L) max.
- Regulatory VOC RTS less exempt compounds: 3.35 lbs./gal. (402.4 g/L) max.
- Density: 8.50 lbs./gal. (1020.0 g/L) (Max. VOC Color)
- Weight % Volatiles: 68.5%
- Weight % exempt compounds: 48%
- Weight % water: 0%



HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

Shimrin® Designer Pearls (PBC) are universal base coats that may simply be cleared for a final finish, or used as a base coat for Kandys or other Pearls.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- WITH THE ADDITION OF KV1 KOSMIC KONVERTOR TO HOUSE OF KOLORS SHIMRIN® BASE COATS (SEE TECH SHEET ON KV1 KOSMIC KONVERTOR), YOU ARE CHANGING THE BASE MATERIAL FROM A NON-CATALYZED PRODUCT TO A CATALYZED BASE COAT, THEREBY INCREASING THE SOLIDS CONTENT AND LOWERING THE VOC'S.
- SOME CAUTION SHOULD BE USED WHEN PULLING YOUR MASKING TAPE AS TEARING OF THE FINISH IS POSSIBLE.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- KO-SEAL® II
- USG100 Intercoat Barrier Klear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.

GROUND COAT

- Sealer (Ko-Seal® II)
- SHIMRIN® Solid Color Bases (BC25, BC26, SG, NE)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF PEARL BASE COAT. Use BC26, KS210 as a ground coat for white or light colored pearls (as shown on our Kustom Koatings color card). The color of the ground coat will vary the final pearl color. This is an excellent place for creativity. You may also use any of our Kosmic Kolor® SHIMRIN® Bases, Graphic Kolors or Neons, for the ground coat. Follow Tech Manual instructions. Allow flash time on each coat of ground color.

NOTE: House of Kolor® sealers may also be used as a ground coat.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.



SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- USG100, Cured Top Coat Clears & OEM Finishes (artwork only)
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad (difficult to reach areas)



COMPONENTS

- PBC Shimrin® base coat
- KV1 Kosmic Konverter (See Tech Page On KV1 Kosmic Konverter)
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 2 parts KV1 Kosmic Konverter (See Tech Page On KV1 Kosmic Konverter)
- 1 part PBC Designer Pearl Base Coat
- 1 part KU150 or KU151 Exempt Catalyst
- Pot life: 1 Hour at 70°F. Shop conditions can vary pot life.

NOTE: Even though SHIMRIN® Designer Pearls are the easiest to apply, equipment, spray technique and air pressure can affect the pearl distribution. A full trigger pull is normally not recommended. Leave the fan wide but reduce the material sprayed with the spray gun's trigger restricter or material control knob.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 3-4 medium coats with 75% pattern overlap to achieve coverage, color and effect. Walk long objects. Avoid dry spraying, as loss of adhesion or mottling is possible with pearls. Again, medium coats work best. Allow flash time between coats.

DRY TIME

Allow dry time before Kandy or clear is applied (usually about 60 minutes and not longer than 2 hours). Topcoat within 2 hours or apply USG100 Intercoat BarrierClear.

FLASH TEST - AT 5 TO 7 MINUTES YOU WILL FEEL THE FINISH TO BE TACKY BUT NOT TRANSFERING TO YOUR FINGER. DO TEST AT THE TAPE EDGE AS FINGER PRINTING IS POSSIBLE. AT 1 HOUR THE FINISH WILL FEEL DRY TO THE TOUCH.

Monitor closely for maximum merging of coats



ARTWORK & INTERCOAT CLEAR (optional)

DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, apply 1 or 2 medium coats of USG100 Intercoat Barrier Clear. The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT BARRIER CLEAR. See tech sheet for more information on USG100 Intercoat Barrier Clear. NOTE: DO NOT SAND SHIMRIN® PEARL BASES DIRECTLY. Apply USG100 Intercoat Barrier Clear for base coat protection if sanding is required. If you directly sand the Shimrin® Pearl, you must re-base. NOTE: USG100 Intercoat Barrier Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE USG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will effect base coats. Use KC20 Post Sanding Cleaner for cleanup**

KANDY COAT (optional)

Shimrin® PBC Bases / KV1 Mix may be Kanded with Urethane enamel. See appropriate tech sheets for Kandy application. For artwork, our Kandy Concentrates may be mixed with SG150 / KV1 Intercoat Karrier Mix up to 10% to meet the 3.5 lbs/gal VOC rule for Kandy graphics. See KK & SG150 tech sheets for more information

KLEAR COAT

ALL SHIMRIN® PBC BASE COATS MUST BE CLEAR-COATED. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

ADDITIONAL INFORMATION

Shimrin® PBC Bases may be intermixed for hundreds of color combinations. PBC Bases may also be mixed with other SHIMRIN's®, including the BC, FBC, Neons, and Graphic Kolors. The possibilities are endless. Create your own one-of-a-kind custom finish.

Shimrin® Pearl and Metallic Bases may also be added, in small amounts (no more than 25%), directly to the UC35 / KK Kandy mix to ease touch-ups or for additional creative effects. Simply catalyze and mix by volume as usual.

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Color Coating
- Actual VOC RTS less exempt solvents: 1.75 lbs./gal. (209.7 g/L) max.
- Regulatory VOC RTS less exempt compounds: 3.37 lbs./gal. (403.9 g/L) max.
- Density: 8.53 lbs./gal. (1023.0 g/L) (Max. VOC Color)
- Weight % Volatiles: 68.5%
- Weight % exempt compounds: 48%
- Weight % water: 0%



HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

SHIMRIN® Neons (NE) are universal base coats that are stunningly bright and beautiful. They offer eye grabbing brightness and can be used where longevity of the color is not an issue. They were designed for race cars and graphics. Neons should not be used on vehicles intended to be driven on a daily bases.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- WITH THE ADDITION OF KV1 KOSMIC KONVERTER TO HOUSE OF KOLORS SHIMRIN BASE COATS (SEE TECH SHEET ON KV1 KOSMIC KONVERTER), YOU ARE CHANGING THE BASE MATERIAL FROM A NON-CATALYSED PRODUCT TO A CATALYSED BASE COAT, THEREBY INCREASING THE SOLIDS CONTENT AND LOWERING THE VOC'S.
- SOME CAUTION SHOULD BE USED WHEN PULLING YOUR MASKING TAPE AS TEARING OF THE FINISH IS POSSIBLE.
- **USE WITH DISCRETION! Neons have limited colorfastness in the sun. Neons are not recommended for overall refinishing or where long life is a requirement. Neons are designed for high visual impact on racecars, boats, cycles, etc., where colorfastness is not the priority, but eye-grabbing brightness is.**
- **FOR EXTENDED LIFE, COVER OR SHIELD THE NEONS FROM THE SUN WHENEVER POSSIBLE. AVOID CONSTANT DAY TO DAY SUN EXPOSURE.**
- **NEONS ARE NOT DESIGNED TO BE USED ON VEHICLES YOU INTEND TO DRIVE DAILY.**
- **DO NOT USE OTHER COMPANYS CLEAR COATS OVER HOUSE OF KOLORS NEONS. Premature fading of the Neon will almost be a certainty.**
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- KS210 White Ko-Seal® II
- BC26 White Base
- USG100 Intercoat Barrier Clear (artwork only)



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. SHIMRIN® Neons are susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KD Primers.**

GROUND COAT

- KS210 White Ko-Seal® II
- BC26 White Base

UNIFORM COVERAGE OF SEALER IS REQUIRED BEFORE APPLICATION OF BASE COAT. We recommend using Ko-Seal® II KS210 White under the Neons. Allow flash time on sealer. See tech sheets for more information on Ko-Seal® II and primers.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding

WHITE BASE COAT BC26 OR WHITE KO-SEAL® II KS210

Use our SHIMRIN® BC26 White Base Coat or, Ko-Seal® II KS210 as a base coat for all Neons. This will give the Neons maximum brightness. Apply 2-3 medium coats of BC26 or KS210 with 50% pattern overlap. Allow flash time between coats. Maintain thorough coverage.

NOTE: An OEM white or jelcoat may also be sanded with 400-500 grit wet and used as a base for Neons. Do individual testing to be sure of compatibility.

NOTE: Do not apply over other companies' paint products. Lifting or splitting may occur when Neon is applied over other companies' bases. Neons need a white base for brightness, but other base colors can be used for special effects.

NOTE: Life of the Neons can be greatly increased by tinting the white base with a Neon or SG Graphic Kolor to make a pastel base close to the Neon topcoat color (try mixing 50% BC26 and 50% Neon). Do individual testing as some brilliance may be lost.



SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- USG100, Cured Top Coat Clears & OEM Finishes (artwork only))
- Dry Sandpaper = 280P to 320P grit (CAMI grand = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad



COMPONENTS

- Neon Shimrin® base coat
- KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 2 parts KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- 1 part NE Neon Shimrin® Base
- 1 part KU150 or KU151 Exempt Catalyst
- Pot Life: 1 Hour at 70 degrees. Shop conditions can vary pot life

MIXING RATIO (continued)

Shake or stir Neon well. Mix components. Some painters add SG100 to the Neons for extra control. Maximum recommended addition of SG100 is 25% by volume.

NOTE: Some painters add small amounts (usually 1 to 2%) of BC26 to beginning coats to eliminate streaks and blotches. Also, the life of the Neons will improve by tinting the BC26 base with one of our Neons or SHIMRIN® Graphic Kolors (use a color closest to the Neon color - 50% BC26 to 50% Neon).

NOTE: Neons may be intermixed for additional neon colors. Do individual testing.

GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.0 to 1.3 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%

APPLICATION

Strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches or less. Apply 3-4 medium coats with 75% pattern overlap. Walk long objects. Allow flash time between coats. Do not spray with a full trigger pull as this may cause blotching. Leave fan wide. Spray close, helps prevent blotching.

NOTE: When using NE502 Pink or NE511 Rose, if color is sprayed on too heavy or applied with too many coats, it can start to turn orange. Bring color on more slowly when using these colors and restrict trigger pull.

NOTE: Too much Neon will diminish the base, thus changing the tone and brightness of the Neon. If the base is squelched from too many coats of Neon, add BC26 to the Neon and recoat; then finish with pure mixed Neon. This is particularly prone to happen with NE502 Pink and NE511 Rose, but can occur with other Neons as well. Restrict material control on the gun, not the fan, work within 6-inch gun distance; pattern 5 to 6 inches with 75% pattern overlap. Apply 3 to 4 coats. Pay attention to the color building.

NOTE: 3 coats of Neon equals $\frac{3}{4}$ to 1 mil. Use caution when pulling your tape as tarring the finish is possible.

DRY TIME

Allow dry time before clear is applied (usually about 60 minutes and not longer than 2 hours). Topcoat within 2 hours or apply USG100 Intercoat Barrier Clear.

FLASH TEST - AT 5 TO 7 MINUTES YOU WILL FEEL THE FINISH TO BE TACKY BUT NOT TRANSFERRING TO YOUR FINGER. DO TEST AT THE TAPE EDGE AS FINGER PRINTING IS POSSIBLE. AT 1 HOUR THE FINISH WILL FEEL DRY TO THE TOUCH.

Monitor closely for maximum merging of coats

ARTWORK & INTERCOAT CLEAR (optional)

DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, apply 1 or 2 medium coats of USG100 Intercoat Barrier Clear. The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT CLEAR. See tech sheet for more information on USG100 Intercoat Barrier Clear.** **NOTE:** DO NOT SAND SHIMRIN® NEONS BASES DIRECTLY. Apply USG100 Intercoat Barrier Clear for base coat protection if sanding is required. If you directly sand the Shimrin® Neon, you must re-base. **NOTE:** USG100 Intercoat Barrier Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE USG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT. **CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will effect base coats. Use KC20 Post Sanding Cleaner for cleanup.**

KLEAR COAT

ALL SHIMRIN® BASES MUST BE CLEAR-COATED. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Color Coating
- Actual VOC RTS less exempt solvents: 1.46 lbs./gal. (174.7 g/L) max.
- Regulatory VOC RTS less exempt compounds: 2.8 lbs./gal. (336.0 g/L) max.
- Density: 8.64 lbs./gal. (1037 g/L) (Max. VOC Color)
- Weight % Volatiles: 64.1%
- Weight % exempt compounds: 47.3%
- Weight % water: 0%

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



SG SHIMRIN® GRAPHIC KOLORS BC25 & BC26 SHIMRIN® SOLID COLORS

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II



GENERAL INFORMATION

Shimrin® SG Graphic Kolors and Shimrin® BC25 and BC26 Solid Colors are universal base coats that may simply be cleared for a final finish, or used as a base coat for KBC Base Coat Kandys or Pearls.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- WITH THE ADDITION OF KV1 KOSMIC KONVERTOR TO HOUSE OF KOLORS SHIMRIN® BASE COATS (SEE TECH SHEET ON KV1 KOSMIC KONVERTOR), YOU ARE CHANGING THE BASE MATERIAL FROM A NON-CATALYZED PRODUCT TO A CATALYZED BASE COAT, THEREBY INCREASING THE SOLIDS CONTENT AND LOWERING THE VOC'S.
- SOME CAUTION SHOULD BE USED WHEN PULLING YOUR MASKING TAPE AS TEARING OF THE FINISH IS POSSIBLE.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- KO-SEAL® II
- USG100 Intercoat Barrier Klear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.

GROUND COAT

- Sealer (Ko-Seal® II)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF SG / BC BASE COAT. Use KS210 as a ground coat for SG or BC26, Use KS211 as a ground coat under BC25 Black. Follow Tech Manual instructions. Allow flash time on each coat of ground color.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.



SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- USG100, Cured Top Coat Clears & OEM Finishes (artwork only)
 - Dry Sandpaper = 280P to 320P grit (CAML grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad (difficult to reach areas)



COMPONENTS

- SG / BC Shimrin® Base Coat
- KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 2 parts KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
 - 1 part SG / BC Shimrin® Base Coat
 - 1 part KU150 or KU151 Exempt Catalyst
- Pot life: 1 Hour at 70°F. Shop conditions can vary pot life.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

After mixing, strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 3-4 MEDIUM coats with 50% pattern overlap. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. Again, MEDIUM coats work best. Allow flash time between coats.

NOTE: 3 coats of Shimrin® SG or BC Bases equals 3/4 to 1 mil, of film build. Use caution when pulling your tape, as tearing the finish is possible.



DRY TIME

Allow dry time before Kandy or clear is applied (usually about 60 minutes and not longer than 2 hours). Topcoat within 2 hours or apply USG100 Intercoat Barrier Klear.

FLASH TEST - AT 5 TO 7 MINUTES YOU WILL FEEL THE FINISH TO BE TACKY BUT NOT TRANSFERRING TO YOUR FINGER. DO TEST AT THE TAPE EDGE AS FINGER PRINTING IS POSSIBLE. AT 1 HOUR THE FINISH WILL FEEL DRY TO THE TOUCH.

Monitor closely for maximum merging of coats

SG SHIMRIN® GRAPHIC KOLORS BC25 & BC26 SHIMRIN® SOLID COLORS

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

ARTWORK & INTERCOAT CLEAR (optional)

DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, apply 1 or 2 medium coats of USG100 Intercoat Barrier Clear. The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistapes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT BARRIER CLEAR. See tech sheet for more information on USG100 Intercoat Barrier Clear. NOTE: DO NOT SAND SHIMRIN® BASES DIRECTLY. Apply USG100 Intercoat Barrier Clear for base coat protection if sanding is required. If you directly sand the Shimrin, you must re-base. NOTE: USG100 Intercoat Barrier Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE USG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will effect base coats. Use KC20 Post Sanding Cleaner for cleanup.**

CLEAR COAT

ALL SHIMRIN® SG AND BC BASES MUST BE CLEAR-COATED. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

ADDITIONAL INFORMATION

Shimrin® SG and BC Bases may be intermixed for hundreds of color combinations. SG Bases may also be mixed with other SG Bases. The possibilities are endless. Create your own one-of-a-kind custom finish

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Color Coating
- Actual VOC RTS less exempt solvents: 1.61 lbs./gal. (193.3 g/L) max.
- Regulatory VOC RTS less exempt compounds: 3.11 lbs./gal. (373.0 g/L) max.
- Density: 8.53 lbs./gal. (1023.0 g/L) (Max. VOC Color)
- Weight % Volatiles: 66.9%
- Weight % exempt compounds: 48%
- Weight % water: 0%



HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

Kandy Base Coats are a mixture of Kandy and select Pearls into a SHIMRIN® Universal Base Coat that mimics a Kandy finish. They feature low build, fewer coats, are easy to apply, and touch ups are easier than ever. Available in the same great 20 colors as our regular Kandys.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- WITH THE ADDITION OF KV1 KOSMIC KONVERTOR TO HOUSE OF KOLORS SHIMRIN BASE COATS (SEE TECH SHEET ON KV1 KOSMIC KONVERTOR), YOU ARE CHANGING THE BASE MATERIAL FROM A NON-CATALYZED PRODUCT TO A CATALYZED BASE COAT, THEREBY INCREASING THE SOLIDS CONTENT AND LOWERING THE VOC'S.
- SOME CAUTION SHOULD BE USED WHEN PULLING YOUR MASKING TAPE AS TEARING OF THE FINISH IS POSSIBLE.
- The following KBC's have a tendency to bleed through art work applied over them. Always use our USG100 Intercoat Barrier Klear before any artwork is applied. **See tech sheet for more information on Intercoat Barrier Klear.** A catalyzed clear coat will NOT always prevent their tendency to bleed. Multiple applications of klear may be required. (2 or more) and careful monitoring of dry times reduces pigment migration into the klear coats. **The KBC colors that are considered heavy bleeders are: KBC03, KBC05, KBC06, KBC10, and KBC13.**
- KBC18 Kandy Basecoat Pink has limited light fastness and should only be used on projects that have limited exposure to sunlight. Use with discretion. KBC18 is recommended for show vehicles only.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- Ko-Seal® II
- All Shimrin® Base Coats
- Properly cured top coat clears and OEM finishes (artwork only)



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.

NOTE: Many KBC's are bleeders. Therefore, you must apply 2 coats of UC35 Clear, UFC35 Kosmic Klear® or UFC19 and allow to dry for 24 hours. You can also use USG100 Barrier Klear and allow to dry for 4 hours. Wet sand (PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS).

GROUND COAT

- Sealer (Ko-Seal® II)
- Shimrin® Base Coats

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Ko-Seal® II Sealers are commonly used and recommended as the ground coat for KBC Base coat Kandy's. Use Ko-Seal® II sealer for faster coverage of base coats. When using sealer, allow flash time. **See tech sheet for information on**

Ko-Seal® II application.

Use KS210, KS211 or KS212 Sealers, BC25 Black, BC26 White, or any of our prescribed SHIMRIN® bases as shown in our color book as a base color. The color of this base coat will vary the final Kandy color. Lighter bases may show blotching. Follow label instructions. Allow flash time on each coat of color. Don't use a full trigger pull, adjust your gun to a 5" or 6" pattern, 5" to 6" from the object, and apply using a 75% pattern overlap.

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.



SANDING THE SUBSTRATE

- KO-SEAL® II (see tech page on Ko-Seal® II)
- USG100, Cured Top Coat Clears & OEM Finishes (artwork only)
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad (difficult to reach areas)



COMPONENTS

- KBC Shimrin® Kandy base coat
- KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 2 parts KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- 1 part KBC Kandy Base Coat
- 1 part KU150 or KU151 Exempt Catalyst
- Pot life: 1 Hour at 70°F. Shop conditions can vary pot life.

KBC SHIMRIN® KANDY BASE COATS

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

After mixing, strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 3-4 **MEDIUM** coats with 75% pattern overlap. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. Again, **MEDIUM** coats work best. Allow flash time between coats.

NOTE: 3 coats of Shimrin® KBC Bases equals 3/4 to 1 mil of film build. Use caution when pulling your tape, as tarring the finish is possible.



DRY TIME

Allow dry time before Kandy or clear is applied (usually about 60 minutes and not longer than 2 hours). Topcoat within 2 hours or apply USG100 Intercoat Barrier Klear.

FLASH TEST - AT 5 TO 7 MINUTES YOU WILL FEEL THE FINISH TO BE TACKY BUT NOT TRANSFERRING TO YOUR FINGER. DO TEST AT THE TAPE EDGE AS FINGER PRINTING IS POSSIBLE. AT 1 HOUR THE FINISH WILL FEEL DRY TO THE TOUCH.

Monitor closely for maximum merging of coats.



ARTWORK & INTERCOAT CLEAR (optional)

DO NOT TAPE DIRECTLY ONTO THESE SHIMRIN® BASECOATS. If artwork is planned, apply 1 or 2 medium coats of USG100 Intercoat Barrier Klear. The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT BARRIER KLEAR. See tech sheet for more information on USG100 Intercoat Barrier Klear. NOTE: DO NOT SAND SHIMRIN® KANDY BASES DIRECTLY. Apply USG100 Intercoat Barrier Klear for base coat protection if sanding is required. If you directly sand the Shimrin® kandy, you must re-base. NOTE: USG100 Intercoat Barrier Klear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE USG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will effect base coats. Use KC20 Post Sanding Cleaner for cleanup.**

KLEAR COAT

ALL SHIMRIN® KBC BASE COATS MUST BE CLEAR-COATED. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

ADDITIONAL INFORMATION

Shimrin® KBC Bases may be intermixed for hundreds of color combinations. KBC Bases may also be mixed with other Shimrin's®, including the Designer Pearls, Neons, and Graphic Kolors. The possibilities are endless. Create your own one-of-a-kind custom finish.



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Color Coating
- Actual VOC RTS less exempt solvents: 1.75 lbs./gal. (209.7 g/L) max.
- Regulatory VOC RTS less exempt compounds: 3.38 lbs./gal. (406 g/L) max.
- Density: 8.48 lbs./gal. (1018 g/L) (Max. VOC Color)
- Weight % Volatiles: 68.8%
- Weight % exempt compounds: 48.2%
- Weight % water: 0%



HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

KF SHIMRIN® KAMELEON® BASE COAT

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II



GENERAL INFORMATION

Kameleon® Kolor is a revolutionary new base coat that actually changes color depending on the angle from which it is viewed. Kameleon® Kolor undergoes broad color changes, for example, from a medium green to a deep purple or from a bright gold to a luminous silver. The Kameleon® Kolor base coat can appear to be different colors to people viewing the exact same area of the car from different angles. Rounded, curved surfaces and sharp angles will highlight the uniqueness of Kameleon® Kolor. Kameleon® Kolor base coats are as easy to apply as our Shimrin® Designer Pearl base coats. Application procedures can vary the appearance of the Kameleon® Kolor base coats to give novel color effects. Kameleon® Kolor base coats must be top coated with our urethane clears.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- WITH THE ADDITION OF KV1 KOSMIC KONVERTOR TO HOUSE OF KOLORS SHIMRIN BASE COATS (SEE TECH SHEET ON KV1 KOSMIC KONVERTOR), YOU ARE CHANGING THE BASE MATERIAL FROM A NON-CATALYZED PRODUCT TO A CATALYZED BASE COAT, THEREBY INCREASING THE SOLIDS CONTENT AND LOWERING THE VOC'S.
- SOME CAUTION SHOULD BE USED WHEN PULLING YOUR MASKING TAPE AS TEARING OF THE FINISH IS POSSIBLE.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- KS211 Black Ko-Seal® II
- BC25 Black Shimrin® Base Coat



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.

GROUND COAT

- Sealer (Ko-Seal® II)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Ko-Seal® II Sealers are commonly used and recommended as the ground coat for Kameleon® Bases. Use Ko-Seal® II sealer for faster coverage of base coats. When using sealer, allow flash time. **See tech sheet for information on Ko-Seal® II application.**

NOTE: Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.



SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- USG100, Cured Top Clears & OEM Finishes (artwork only)
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)

Maroon scuff pad (difficult to reach areas)



COMPONENTS

- KF Kameleon® Shimrin® Base Coat
- KV1 Kosmic Konvertor (See Tech Page on KV1 Kosmic Konvertor)
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 2 parts KV1 Kosmic Konvertor (See Tech Page on KV1 Kosmic Konvertor)
- 1 part KF Shimrin® Kameleon® base coat
- 1 part KU150 or KU151 Exempt Catalyst
- Pot life: 1 Hour at 70°F. Shop conditions can vary pot life.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

After mixing, strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 3-4 **MEDIUM** coats with 75% pattern overlap. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. Again, **MEDIUM** coats work best. Allow flash time between coats.

NOTE: 3 coats of Shimrin® KF Kameleon® Bases equals 3/4 to 1 mil, of film build. Use caution when pulling your tape, as tearing the finish is possible.



DRY TIME

Allow dry time before clear is applied (usually about 60 minutes and not longer than 2 hours). Topcoat within 2 hours or apply USG100 Intercoat Barrier Klear.

FLASH TEST - AT 5 TO 7 MINUTES YOU WILL FEEL THE FINISH TO BE TACKY BUT NOT TRANSFERRING TO YOUR FINGER. DO TEST AT THE TAPE EDGE AS FINGER PRINTING IS POSSIBLE. AT 1 HOUR THE FINISH WILL FEEL DRY TO THE TOUCH.

Monitor closely for maximum merging of coats.

KF SHIMRIN® KAMELEON® BASE COAT

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

ARTWORK & INTERCOAT CLEAR (optional)

DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, apply 1 or 2 medium coats of USG100 Intercoat Barrier Klear. The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT CLEAR. See tech sheet for more information on USG100 Intercoat Barrier Klear. NOTE: DO NOT SAND SHIMRIN® KAMELEON® BASES DIRECTLY. Apply USG100 Intercoat Barrier Klear for base coat protection if sanding is required. If you directly sand the Shimrin® Kameleon®, you must re-base. NOTE: USG100 Intercoat Barrier Klear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE USG100 INTERCOAT BARRIER KLEAR AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will effect base coats. Use KC20 Post Sanding Cleaner for cleanup.**

KLEAR COAT

ALL SHIMRIN® KF KAMELEON® BASES MUST BE CLEAR-COATED. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Color Coating
- Actual VOC RTS less exempt solvents: 1.76 lbs./gal. (211 g/L) max.
- Regulatory VOC RTS less exempt compounds: 3.38 lbs./gal. (405 g/L) max.
- Density: 8.49 lbs./gal. (1019.2 g/L) (Max. VOC Color)
- Weight % Volatiles: 68.8%
- Weight % exempt compounds: 48.1%
- Weight % water: 0%

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



KV1 KOSMIC KONVERTOR

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

GENERAL INFORMATION

KV1 Kosmic Konvertor is an additive for Shimrin® base coats and was developed to effectively lower the VOC's of House of Kolor's Shimrin® Base Coats to meet the VOC limits of 3.5 lb / gal voc for SCAQMD Rule 1151 and SJVAQMD Rule 4602 & 4612 Phase II . This is accomplished by using low molecular weight urethane resins and exempt solvents thereby increasing the solids of our Shimrin base coats and lowering the VOC to 3.5 lbs / gal or lower.



IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- AGITATE WELL BEFORE USE

- **Special Note to the Experienced House of Kolor® User.**

The addition of the Kosmic Konvertor to your Shimrins® is going to change the way you have worked with Shimrin® base coats in the past. Below we have listed some of the more obvious differences.

- Konverted Shimrins® will no longer flash dull. Flash time between coats will now be monitored by feeling a stickiness to the finish. Normal flash time with non-Konverted Shimrins® was 15 minutes; it will now be 5 to 7 minutes.
 - The Kosmic Konvertor will add between 1/4 to 1/2 mil of film build to your Shimrin® Bases. When doing graphics, some care will be needed when unmasking.
 - You normally reduce your Shimrin® at the 2 part base to 1 part reducer and spray 2 to 3 coats for coverage. The Konverted Shimrins® will spray as if you increased the reduction to 1 part base to 1 part reducer. This will increase the number of coats from 2 to 3 coats to 3 to 4 coats. You will notice that you will have better control of your metallic and pearls.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.

COMPONENTS

KV1 Kosmic Konvertor
Shimrin® Base Coat
KU150 or KU151 Catalyst



MIXING RATIO

2 parts KV1
1 part Shimrin® Base Coat
1 part KU150 or KU151 Catalyst



TECHNICAL DATA

- Coatings Category: Component used in combination with basecoat items for compliance under color coating
- Actual VOC less exempt solvents: 0.33 lbs/gal (39 grms/ltr) max.
- Regulatory VOC less exempt compounds: 0.90 lbs/gal (108 grms/ltr) max.
- Density: 7.86 lbs/gal (943.6 grm/ltr)
- Weight % Volatiles: 63.1%
- Weight % exempt compounds: 59%
- Weight % water: 0%



HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

**GENERAL INFORMATION**

USG100 Intercoat Barrier Klear is a two-component acrylic urethane base intercoat clear that was designed to offer protection if a light solvent wipe is required, when applied over House of Kolor® Shimrin® basecoats when used for artistic effects. With the application of 2 medium coats, the USG100 will typically cure in 3 to 4 hours (depending upon shop conditions), and is ready for sanding, tape outs, and the application of artwork and pinstripes. In the event there are errors made such as mis-tapes, or striping mishaps, a light solvent wipe using **KCA100 WAX AND GREASE REMOVER ONLY** can be done to remove these mistakes without effecting the base coat or previous artwork under the USG100. The USG100 has demonstrated an ability to prevent bleed through with some of our kandy colors.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- DO NOT USE USG100 AS A BUILDUP OR TOPCOAT CLEAR, THIS IS AN ACTIVATED BASE COAT MATERIAL! USG100 is designed to protect base coats for artwork, pin striping and tape outs only.
- DO NOT USE USG100 AS A CARRIER FOR PEARLS, FLAKES, OR KANDY KONCENTRATES.
- DO NOT USE RU REDUCER AS A SOLVENT WIPE. USE ONLY KCA100 AS A WIPE DOWN AGENT, FOLLOWED WITH KC20 POST SANDING CLEANER AS A FINAL WIPE TO REMOVE ANY SOLVENT RESIDUE LEFT BY THE KCA100. REMEMBER THE KEY WORD IS A LIGHT SOLVENT WIPE DOWN, DO NOT OVER WET THE SURFACE.
- ON OCCASION, YOU MAY EXPERIENCE IMPRINTING OF THE PIN STRIPE OR GRAPHIC. A LIGHT SCUFFING WITH A SCUFF PAD WILL REMOVE THESE.
- ALWAYS DO A TEST TO INSURE THE USG100 HAS PROPERLY CURED PRIOR TO DOING A SOLVENT WIPE DOWN WITH KCA100 OVER THE ARTWORK.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.

**SUBSTRATE**

- All Shimrin® Bases
- Properly cured and prepared topcoat clears and OEM finishes (artwork only)

NOTE: USG100 should never be used directly over Marblizers. Only use AP01 first. USG100 can then be used over the AP01.

**PREPARATION**

Prior to applying USG100 Intercoat Barrier Klear, it is advised to wipe down the Shimrin® Base with a tack cloth, or if needed, with KC20 Post Sanding Cleaner.

**COMPONENTS**

- USG100 Intercoat Barrier Klear
- RU300 Exempt Reducer
- KU150 or KU151 Exempt Catalyst

NOTE: You may replace up to 50% of the RU300 reducer with RU310, RU311 or RU312 reducers without exceeding the 2.1 lbs/gal VOC Limit. This will give you additional control of the Intercoat Barrier Klear (See Mixing Ratio Below)

**MIXING RATIO**

- 3 part USG100 Intercoat Barrier Klear
- 1 part RU300 reducer
- 1 part KU150 or KU151 Catalyst

OPTIONAL

- 3 part USG100 Intercoat Barrier Klear
- 1/2 part RU300 reducer
- 1/2 part RU310, RU311, or RU312 reducer
- 1 part KU150 or KU151 Catalyst
- Pot life: 1 Hour at 70°F.

**GUN SET UP**

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%

**APPLICATION**

Apply 2 medium coats of USG100 Intercoat Barrier Clear at a 50% pattern overlap. Gun distance should be 4" to 6" from object being sprayed. Allow 4 to 6 minutes between coats depending on shop conditions. Use the string test, the finish should feel tacky but not stringing to your finger. Do not allow the USG100 to go out of tack between coats as lifting may occur and ruin all your hard work. DO NOT DRY SPRAY USG100, this will cause possible lifting and the loss of integrity of the finish.

NOTE: Do not attempt to improve the flow out of USG100 by applying medium wet or full wet coats or applying more than 2 coats. This will greatly slow down the cure time and its ability to be sanded and taped over within the recommended 3 to 4 hour time period. REMEMBER, This is a catalyzed base coat material designed to be used as a barrier protectant of your base coats and artwork, not as a buildup or top coat clear. Flow out and build is not at issue at this stage of your paint job.

USG100 INTERCOAT BARRIER KLEAR

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

FINISH SANDING

USG100 Intercoat Barrier Klear MUST be sanded prior to tape outs for artwork or pin striping.

- Dry Sanding – 320P to 400P Grit DA Paper
- Wet Sanding – 400 to 500 Grit paper
- Maroon Scuff Pad for small or difficult to reach areas.

IMPORTANT NOTE: Be very careful not to sand through and into the base coat underneath the USG100. This could lead to edge lifting when top coating the USG100 Intercoat Barrier Klear.

DRY TIME

Allow the USG100 to cure for 3 to 4 hours (depending on shop conditions) prior to sanding or applying artwork. USG100 can be force dried at 140 degrees for 20 minutes.

All tests and evaluations are based at 70 degrees with adequate air movement.



INTENDED USE AS A BARRIER AGAINST CANDY BLEEDTHROUGH

Some candy colors are known to be bleeders. Apply 2 coats of USG100 as outlined above. Wet sand the clear. If you notice any color in the sanding residue, you will need to reapply additional coats of USG100 until the sanding residue shows white.

KLEAR COAT

USG100 Intercoat Barrier Klear must be top coated with House Of Kolor's Urethane Kandy, UC35, UFC35, or UFC19 Clear Coats.

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Clear Coat
- Actual VOC RTS less exempt solvents: 0.74 lbs./gal. (88.8 g/L) max.
- Regulatory VOC RTS less exempt compounds: 2.08 lbs./gal. (250 g/L) max.
- Density: 10.28 lbs./gal. (1234.0 g/L) (Max. VOC Color)
- Weight % Volatiles: 76.1%
- Weight % exempt compounds: 68.9%
- Weight % water: 0%



HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

**GENERAL INFORMATION**

Kosmic Acrylic Urethane Klear UC35 is a 2.1 VOC clear that meets VOC SCAQMD Rule 1151 and SJVAQMD Rule 4602 & 4612 Phase II compliancy. UC35 may be used to topcoat any urethane enamel finish, including all Shimrin® Base Coats. UC35 is medium solids, 30% solids as applied, and has the same application properties of conventional clear coats. UC35 features excellent gloss and D.O.I. (Distinctness Of Image). It has good chemical, fuel and water resistance, and excellent weathering and ultraviolet resistance. UC35 dries fast and hard and may be colored sanded and buffed the next day.

NOTE: UC35 IS THE PREFERRED CLEAR FOR USE ON MOTORCYCLES. BECAUSE OF ITS HIGHER ACRYLIC CONTENT, IT IS FASTER CURING, AND ALSO HAS BETTER RESISTANCE TO FUEL SPILLS.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- We have designed specific Catalysts and Reducers to work with each of our clears. These Catalysts and Reducers are NOT interchangeable. Use only the Catalyst specified for the specific clear you are using.
- KU150 and KU151 VOC Exempt Catalyst are moisture sensitive and will not keep for long periods once open. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.
- Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.
- Over spray from any catalyzed topcoat material (such as our Urethane Kandy Mix, UC35 Kosmic Acrylic Urethane Klear, UFC35 Polyurethane Flo-Klear or UFC19 Urethane Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.

**SUBSTRATE**

- Shimrin® Base Coats
- Urethane Kandy Mix (See tech sheets on Urethane Kandy Mix)
- Properly cured and prepared OEM finishes

**PREPARATION**

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.

**SANDING SUBSTRATE**

- Urethane Kandy Mix and Shimrin® Base Coats (See tech sheets on Urethane Kandy Mix and Shimrin® Base Coats)
- OEM Finishes
- Dry Sandpaper = 280P to 320P grit (CAMI grand = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad

**COMPONENTS**

- UC35 Kosmic Acrylic Urethane Klear
- RU300 Exempt Reducer
- KU150 or KU151 Exempt Catalyst

NOTE: You may replace up to 50% of the RU300 reducer with RU310, RU311 or RU312 reducers without exceeding the 2.1 lbs/gal VOC Limit. This will give you additional control of the Klear (See Mixing Ratio Below)

**MIXING RATIO**

- 2 part UC35 Kosmic Acrylic Urethane Klear
- 1 part RU300 reducer
- 1 part KU150 or KU151 Catalyst

OPTIONAL

- 2 parts UC35 Kosmic Acrylic Urethane Klear
- ¾ part RU300
- ¼ part RU310, RU311, or RU312
- 1 part KU150 or KU151 Catalyst
- Pot life: 2 Hours at 70°F.

**GUN SET UP**

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%

**APPLICATION**

Apply 2-3 medium wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED. (When using the flash test, always touch a new spot.) Monitor closely for maximum merging of coats.

(CONTINUED)

UC35 KOSMIC ACRYLIC URETHANE KLEAR

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

APPLICATION (Continued)

NOTE: Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material (such as our Urethane Kandy Mix, UC35 Kosmic Acrylic Urethane Klear, UFC35 Polyurethane Flo-Klear or UFC19 Urethane Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.



DRY TIME

- Air dry at 70 degrees = 24 hours
- Force dry at 140 degrees = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, and flash time between coats, etc., it is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.



COLOR SANDING

IF NOT FLOW COATING, GO TO STEP FINISHING AND POLISHING

After clear coats have been cured overnight (12-24 hours), color sand wet (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue doesn't bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 or warm water.

NOTE: Avoid touching the vehicle with your bare hands as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE CLEAR AND RUIN ALL YOU'VE DONE. Look for colored water, this will indicate you sanded through the clear

FLO-COATING

RE-MASKING THE VEHICLE AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using 4-6 ounces of extra RU300 VOC Exempt reducer per mixed quart of clear. The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Allow flash time between coats. (For improved hardness the next day, add 1 extra ounce of KU150 or KU151 VOC Exempt Catalyst to this mixture) per mixed quart.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles.

FINISHING AND POLISHING

- In a 70 degree shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing**



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Clear Coat
- Actual VOC RTS less exempt solvents: 0.60 lbs./gal. (72.4 g/L) max.
- Regulatory VOC RTS less exempt compounds: 1.59 lbs./gal. (191 g/L) max.
- Density: 10.23 lbs./gal. (1228.0 g/L) (Max. VOC Color)
- Weight % Volatiles: 71.8%
- Weight % exempt compounds: 65.9%
- Weight % water: 0%



HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

Kosmic Urethane Flo-Klear UFC35 is a 2.1 VOC clear that meets VOC SCAQMD Rule 1151 and SJVQMD Rule 4602 & 4612 Phase II compliance. UFC35 may be used to topcoat any of our Kosmic Kolor® urethane or polyurethane enamel finishes, or any of our SHIMRIN® Base Coats. UFC35 is a medium solids Klear that has application properties similar to our conventional Klear UFC01. UFC35 features excellent flow out for better D.O.I. (Distinctness of Image), ultra-high gloss, good chemical and water resistance, good abrasion, and stone bruise resistance, is extremely flexible and polishes, and buffs easily.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- We have designed specific Catalysts and Reducers to work with each of our clears. These Catalysts and Reducers are NOT interchangeable. Use only the Catalyst specified for the specific clear you are using.
- KU150 and KU151 VOC Exempt Catalyst are moisture sensitive and will not keep for long periods once open. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.
- Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.
- Over spray from any catalyzed topcoat material (such as our Urethane Kandy Mix, UC35 Kosmic Acrylic Urethane Klear, UFC35 Polyurethane Flo-Klear or UFC19 Urethane Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- Shimrin® Base Coats
- Urethane Kandy Mix (See tech sheets on Urethane Kandy Mix)
- Properly cured and prepared OEM finishes



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.



SANDING SUBSTRATE

- Urethane Kandy Mix and Shimrin® Base Coats (See tech sheets on Urethane Kandy Mix and Shimrin® Base Coats)
- OEM Finishes
- Dry Sandpaper = 280P to 320P grit (CAMI grand = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad



COMPONENTS

- UFC35 Kosmic Urethane Flo-Klear
- RU300 Exempt Reducer
- KU150 or KU151 Exempt Catalyst

NOTE: You may replace up to 50% of the RU300 reducer with RU310, RU311 or RU312 reducers without exceeding the 2.1 lbs/gal VOC Limit. This will give you additional control of the Klear (See Mixing Ratio Below)



MIXING RATIO

- 2 part UFC35 Kosmic Urethane Flo-Klear
- 1 part RU300 reducer
- 1 part KU150 or KU151 Catalyst

OPTIONAL

- 2 parts UFC35 Kosmic Urethane Flo-Klear
- ¾ part RU300
- ¼ part RU310, RU311, or RU312
- 1 part KU150 or KU151 Catalyst

- Pot life: 2 Hours at 70°F.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Apply 2-3 medium wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED. (When using the flash test, always touch a new spot.) Monitor closely for maximum merging of coats.
(CONTINUED)

UFC35 KOSMIC URETHANE FLO-KLEAR

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

APPLICATION (Continued)

NOTE: Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material (such as our Urethane Kandy Mix, UC35 Kosmic Acrylic Urethane Klear, UFC35 Polyurethane Flo-Klear or UFC19 Urethane Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.



DRY TIME

- Air dry at 70 degrees = 24 hours
- Force dry at 140 degrees = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, and flash time between coats, etc., it is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.



COLOR SANDING

IF NOT FLOW COATING, GO TO STEP FINISHING AND POLISHING

After clear coats have been cured overnight (12-24 hours), color sand wet (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue doesn't bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 or warm water.

NOTE: Avoid touching the vehicle with your bare hands as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE CLEAR AND RUIN ALL YOU'VE DONE. Look for colored water, this will indicate you sanded through the clear

FLO-COATING

RE-MASKING THE VEHICLE AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using 4-6 ounces of extra RU300 VOC Exempt reducer per mixed quart of clear. The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Allow flash time between coats. (For improved hardness the next day, add 1 extra ounce of KU150 or KU151 VOC Exempt Catalyst to this mixture) per mixed quart.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles.

FINISHING AND POLISHING

- In a 70 degree shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing**



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Clear Coat
- Actual VOC RTS less exempt solvents: 0.98 lbs./gal. (117.4 g/L) max.
- Regulatory VOC RTS less exempt compounds: 1.63 lbs./gal. (196 g/L) max.
- Density: 9.14 lbs./gal. (1097.0 g/L) (Max. VOC Color)
- Weight % Volatiles: 71.2%
- Weight % exempt compounds: 60.5%
- Weight % water: 0%



HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

UMC35 Kos-Matte Klear is used to produce a primer flat finish in any color including our Kandy's to give you the "Old Rat Rod" look. This Klear was formulated specifically not to blotch or streak when applied and is extremely hard to prevent scuffing, marring and scratching. It also has a high level of UV screening agent to prevent graying of the finish over time.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- We have designed specific Catalysts and Reducers to work with each of our clears. These Catalysts and Reducers are NOT interchangeable. Use only the Catalyst specified for the specific clear you are using.
- KU150 and KU151 VOC Exempt Catalyst are moisture sensitive and will not keep for long periods once open. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.
- Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.
- Over spray from any catalyzed topcoat material (such as our Urethane Kandy Mix, UC35 Cosmic Acrylic Urethane Klear, UFC35 Polyurethane Flo Klear or UFC19 Urethane Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- Shimrin® Base Coats
- Urethane Kandy
- Urethane Klears
- Properly cured and prepared OEM finishes



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.



SANDING SUBSTRATE

- Urethane Kandy and Shimrin® Base Coats (See tech sheets on Urethane Kandy and Shimrin® Base Coats)
- OEM Finishes
- Dry Sandpaper = 280P to 320P grit (CAMI grand = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad



COMPONENTS

- UMC35 Kos-Matte Klear
- RU- Reducers
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 4 parts UMC35 Kos-Matte Klear
- 1.5 part RU-Reducer
- 1 part KU150 or KU151 Catalyst
- Pot Life: 3 hours at 70 degrees



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Apply 2-3 medium wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED. (When using the flash test, always touch a new spot.) Monitor closely for maximum merging of coats.

NOTE: Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material (such as our Urethane Kandy Mix, UC35 Cosmic Acrylic Urethane Klear, UFC35 Polyurethane Flo Klear, UMC35 Kos-Matte Klear or UFC19 Urethane Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jambs, etc.



DRY TIME

- Air dry at 70 degrees = 24 hours
- Force dry at 140 degrees = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, and flash time between coats, etc., it is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.

UMC35 KOS-MATTE KLEAR

COLOR SANDING

DO NOT ATTEMPT TO COLOR SAND AND BUFF UMC35 KOS-MATTE KLEAR.



HERE IS A TIP:

Apply 2 coats of UC or UFC Klears over the Shimrin® Base or UK Kandy. Sand this flat with 400 grit wet to remove dirt nibs and orange peel. Then apply 2 coats of UMC35 Kos-Matte Klear. This should give you a totally clean, flat finish.

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)



- Coatings Category: Clear Coat
- Actual VOC RTS less exempt solvents: 4.71 lbs/gal (565.2 grms/ltr) max.
- Regulatory VOC RTS less exempt compounds: 3.50 lbs/gal (420 grms/ltr) max.
- Density: 9.07 lbs/gal (1088.4 grm/ltr) (Max. VOC Color)
- Weight % Volatiles 38.60%
- Weight % exempt compounds: 31.68%
- Weight % water: 0%

HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

**GENERAL INFORMATION**

SG150 Intercoat Pearl & Flake Karrier is a base coat clear material that is designed specifically to be used as the karrier for Pearls, Flakes, as well as other dry products offered in the House Of Kolor product line. Due to its unique chemistry, it greatly reduces or eliminates the settling of pearls and flakes after the products are mixed. It also encapsulates the pearls and flake particles, so when sprayed, self orientates, locking them in place, greatly reducing blotching and streaking of the finish. Although the material looks semi-opaque in the can, it dries to water clear finish allowing the brilliance of the pearls & flakes to show through.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- WITH THE ADDITION OF KV1 KOSMIC KONVERTOR TO HOUSE OF KOLORS SHIMRIN® BASE COATS (SEE TECH SHEET ON KV1 KOSMIC KONVERTOR), YOU ARE CHANGING THE BASE MATERIAL FROM A NON-CATALYZED PRODUCT TO A CATALYZED BASE COAT, THEREBY INCREASING THE SOLIDS CONTENT AND LOWERING THE VOC'S.
- SOME CAUTION SHOULD BE USED WHEN PULLING YOUR MASKING TAPE AS TEARING OF THE FINISH IS POSSIBLE.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.

**SUBSTRATE**

- Ko-Seal® II
- All Shimrin® Base Coats
- Properly cured and prepared top coat clears and OEM finishes

**PREPARATION**

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.

GROUND COAT

- Ko-Seal® II
- All Shimrin® Base Coats
- OEM finishes

**SANDING SUBSTRATE**

- Ko-Seal® II (see tech page on Ko-Seal® II)
- USG100, Cured Top Coat Clears & OEM Finishes (artwork only)
 - Dry Sandpaper = 280P to 320P grit
(CAML grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit
(FEPA grade 600P to 800P grit)
- Maroon scuff pad (difficult to reach areas)

**COMPONENTS**

- SG150 Intercoat Pearl & Flake Karrier
- KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- KU150 or KU151 Exempt Catalyst

**MIXING RATIO**

- 2 parts KV1 Kosmic Konvertor (See Tech Page On KV1 Kosmic Konvertor)
- 1 part SG150 Intercoat Pearl & Flake Karrier
- 1 part KU150 or KU151 Exempt Catalyst

(Please refer to the appropriate tech sheet of the dry product you intend to use for mixing instructions)

- Pot life: 1 Hours at 70°F. Shop conditions can vary potlife

NOTE: Even though SG150 Intercoat Pearl & Flake Karrier is the easiest to apply, equipment, spray technique and air pressure can affect the pearl distribution. A full trigger pull is normally not recommended. Leave the fan wide but reduce the material sprayed with the spray gun's trigger restrictor or material control knob.

**GUN SET UP**

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%

**APPLICATION**

Strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 3-4 medium coats with 75% pattern overlap to achieve coverage, color and effect. Walk long objects. Avoid dry spraying, as loss of adhesion or mottling is possible with pearls. Again, medium coats work best. Allow flash time between coats.

SG150 INTERCOAT PEARL & FLAKE KARRIER

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

DRY TIME

Allow dry time before Kandy or clear is applied (usually about 60 minutes and not longer than 2 hours). Topcoat within 2 hours or apply USG100 Intercoat Barrier Klear.

FLASH TEST - AT 5 TO 7 MINUTES YOU WILL FEEL THE FINISH TO BE TACKY BUT NOT TRANSFERRING TO YOUR FINGER. DO TEST AT THE TAPE EDGE AS FINGER PRINTING IS POSSIBLE. AT 1 HOUR THE FINISH WILL FEEL DRY TO THE TOUCH.

Monitor closely for maximum merging of coats



ARTWORK & INTERCOAT Barrier Klear (Optional)

DO NOT TAPE DIRECTLY ONTO THE SG150 BASE. If artwork is planned, apply 1 or 2 medium coats of USG100 Intercoat Barrier Clear. The clear coat will protect the SG150 Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT BARRIER CLEAR. See tech sheet for more information on USG100 Intercoat Barrier Clear. NOTE: DO NOT SAND SG150 / PEARL MIX DIRECTLY. Apply USG100 Intercoat Barrier Clear for base coat protection if sanding is required. If you directly sand the SG150 / Pearl Mix, you must re-base. NOTE: USG100 Intercoat Barrier Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE USG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will effect base coats. Use KC20 Post Sanding Cleaner for cleanup.**

CLEAR COAT

SG150 AND ALL SHIMRIN® PBC BASES MUST BE CLEAR-COATED. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application

CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Clear Coating
- Actual VOC RTS less exempt solvents: 1.64 lbs./gal. (196.6 g/L) max.
- Regulatory VOC RTS less exempt compounds: 3.15 lbs./gal. (378.5 g/L) max.
- Density: 8.49 lbs./gal. (1019 g/L) (Max. VOC Color)
- Weight % Volatiles: 67.42%
- Weight % exempt compounds: 48.13%
- Weight % water: 0%



HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

UFC19 URETHANE KOMPLY KLEAR® II is a 1.9 VOC polyurethane clear coat with application properties of low solids clear coats such as UFC01. UFC19 is 33% solids as applied and buffs easily the next day. UFC19 delivers the low VOC needed for air quality regulations yet handles like conventional clear coats currently used. URETHANE KOMPLY KLEAR® II may be used to topcoat any of our Shimrin® Base coats. UFC19 features excellent gloss, long flow out, very good D.O.I. (Distinctness of Image), and good chemical and water resistance. UFC19 has excellent weathering and ultraviolet resistance, and easily color sands and polishes from 24 up to 72 hours.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- We have designed specific Catalysts and Reducers to work with each of our clears. These Catalysts and Reducers are NOT interchangeable. Use only the Catalyst specified for the specific clear you are using.
- KU150 and KU151 VOC Exempt Catalyst are moisture sensitive and will not keep for long periods once open. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.
- Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.
- Over spray from any catalyzed topcoat material (such as our Urethane Kandy Mix, UC35 Kosmic Acrylic Urethane Klear, UFC35 Polyurethane Flo-Klear or UFC19 Urethane Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jams, etc
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- Shimrin® Base Coats
- Urethane Kandy Mix (See tech sheets on Urethane Kandy Mix)
- Properly cured and prepared OEM finishes



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.



SANDING SUBSTRATE

- Urethane Kandy Mix and Shimrin® Base Coats (See tech sheets on Urethane Kandy Mix and Shimrin® Base Coats)
- OEM Finishes
- Dry Sandpaper = 280P to 320P grit (CAMI grand = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad



COMPONENTS

- UFC19 Urethane Komply Klear® II
- RU300 Exempt Reducer
- KU150 or KU151 Exempt Catalyst



MIXING RATIO

- 2 part UFC19 Urethane Komply Klear® II
- 1 part RU300 reducer
- 1 part KU150 or KU151 Catalyst
- Pot life: 2 Hours at 70°F.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Apply 2-3 medium wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED. (When using the flash test, always touch a new spot.) Monitor closely for maximum merging of coats.

NOTE: Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 12 hours before sanding and re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material (such as our Urethane Kandy Mix, UC35 Kosmic Acrylic Urethane Klear, UFC35 Polyurethane Flo-Klear or UFC19 Urethane Komply Klear® II may lift when base coats are applied. Mask carefully to prevent this over spray when painting door jams, etc.



DRY TIME

- Air dry at 70 degrees = 24 hours
- Force dry at 140 degrees = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, and flash time between coats, etc., it is not unusual for the Klear to remain soft for extended periods of time. This does not mean the finish is uncured; it indicates the finish is holding solvents and will need additional time to fully harden.

UFC19 URETHANE KOMPLY KLEAR® II

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

COLOR SANDING

IF NOT FLOW COATING, GO TO STEP FINISHING AND POLISHING

After clear coats have been cured overnight (12-24 hours), color sand wet (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, so soap residue doesn't bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 or warm water.

NOTE: Avoid touching the vehicle with your bare hands as the oil from your skin may impair flow coats.

CAUTION: DO NOT SAND THROUGH THE CLEAR AND RUIN ALL YOU'VE DONE. Look for colored water, this will indicate you sanded through the clear

FLO-COATING

RE-MASKING THE VEHICLE AFTER COLOR SANDING WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using 4-6 ounces of extra RU300 VOC Exempt reducer per mixed quart of clear. The additional reducer will give you extra flow out. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Allow flash time between coats. (For improved hardness the next day, add 1 extra ounce of KU150 or KU151 VOC Exempt Catalyst to this mixture) per mixed quart.

NOTE: With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles.

FINISHING AND POLISHING

- In a 70 degree shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing**



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Clear Coat
- Actual VOC RTS less exempt solvents: 0.79 lbs./gal. (94.8 g/L) max.
- Regulatory VOC RTS less exempt compounds: 1.88 lbs./gal. (226 g/L) max.
- Density: 9.84 lbs./gal. (1181 g/L) (Max. VOC Color)
- Weight % Volatiles: 69.73%
- Weight % exempt compounds: 61.7%
- Weight % water: 0%



HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

AP01 & AP02 ADHERETO® ADHESION PROMOTER

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II



GENERAL INFORMATION

ADHERETO® Adhesion Promoters are designed to create a bond between a substrate and a coating. Apply ADHERETO® before applying topcoats to ensure proper adhesion of automotive paint to: plastics or a variety of other surfaces. ADHERETO® is easy to use and dries in minutes. Ready to spray right out of the can (no reduction required). Clear in color.

ADHERETO® is available in two formulas:

AP01 is designed to use when top coating Polypropylene, TPO (Thermoplastic Polypropylene), Polypropylene/elastomer blends and Marblizer.

AP02 is designed for Polyethylene only.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- Proper coat thickness is critical for good adhesion properties. With adhesion promoters, more is not better. Carefully monitor coat thickness.
- Topcoats may be applied immediately after the ADHERETO® coat has dried, usually within 2 to 3 minutes not to exceed 5 minutes at 70°F. ADHERETO® acts as a clear adhesive primer providing a bond for topcoats.
- NOTE: If ADHERETO® completely dries, it must be reapplied prior to top-coating.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- Most Plastics
- Marblizer®



PREPARATION

Clean substrate of all contamination, such as dirt, oil, grease and mold release agents, with isopropyl alcohol or KC20 Post Sanding Cleaner. Dry thoroughly after cleaning. Scuff using a Maroon Scuff Pad.



MIXING RATIO

Ready to spray as packaged, no reducer.



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3
- Trigger Pull = 33% to 50%



APPLICATION

Apply ADHERETO® with a dry film thickness of 0.1 to 0.2 mils equal to one medium coat.

WARNING: Proper coat thickness is critical for good adhesion properties. With adhesion promoters, more is not better. Carefully monitor coat thickness. Topcoats may be applied immediately after the ADHERETO® coat has dried, usually within 2 to 3 minutes not to exceed 5 minutes at 70°F. ADHERETO® acts as a clear adhesive primer providing a bond for topcoats.

NOTE: If ADHERETO® completely dries, it must be reapplied prior to top-coating.



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Adhesion Promoter
- Actual VOC RTS less exempt solvents: 6.9 lbs./gal. (828.0 g/L) max.
- Regulatory VOC RTS less exempt compounds: 6.0 lbs./gal. (828.0 g/L) max.
- Density: 7.28 lbs./gal. (874 g/L) (Max. VOC Color)
- Weight % Volatiles: 94.73%
- Weight % exempt compounds: 0%
- Weight % water: 0%

HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

UC25 / KK URETHANE KANDY MIX RATIOS & APPLICATION

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II



GENERAL INFORMATION

UK Kandy's currently do not meet the VOC rules as outlined under SCAQMD's Rule 1151 and SJVAQMD's Rules 4602 & 4612 Phase II. Therefore we have developed formulations that duplicate closely our original UK Kandy Kolors as far as color, strength, and performance. Kandy's are a major part of Kustom finishing and we believe this will give you the ability to continue to offer your customers the stunning Kandy Finishes you have been able to produce in the past.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- UNDER NO CIRCUMSTANCES ATTEMPT TO USE OTHER MANUFACTURES PRODUCTS TO PRODUCE THESE KANDY COLORS. FOR THE MOST PART, ONLY HOUSE OF KOLOR'S UC25 HAS THE FLEXIBILITY AND UV PROTECTION NEEDED FOR THE EXTREME FINISHES ASSOCIATED WITH KANDY PAINT JOBS. CRACKING, SPLITTING AND FADING IS A REAL POSSIBILITY WITH OTHER COMPANIES PRODUCTS.
- The following UC25 / KK Mixes have a tendency to bleed through art work applied over them. Refer to USG100 tech page. A catalyzed clear coat will NOT stop their tendency to bleed. However, if multiple applications of clear (2 or more) and proper flash time between coats is observed, the leaching of color into the clear is reduced, if not eliminated. Do individual testing.

The KK products that have a tendency to bleed are: KK03, KK05, KK06, KK10, and KK13.

- KK18 Kandy Koncentrate Pink has limited light fastness and should only be used on projects that have limited exposure to sunlight. Use with discretion. KK18 is recommended for show vehicles.
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

- KS212 Silver Ko-Seal® II
- USG100 Intercoat Barrier Klear
- SG150 Intercoat Pearl & Flake Karrier
- Shimrin® Base Coats



PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KD epoxy primers.



SANDING SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- USG100 (see tech page on Intercoat Barrier Klear)
 - Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad (difficult to reach areas)



GROUND COAT

- KS212 Silver (Ko-Seal® II)
- SHIMRIN® Base Coats

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF UC25 / KK Kandy Mix. The color of the ground coat will vary the final Kandy color (See Kolor Book). This is an excellent place for creativity. Use any of our Shimrin® Bases for the ground coat. Follow Tech Manual instructions. Allow flash time on each coat of ground color.



COMPONENTS

- UC25 Kosmic Kandy Karrier
- KK Kandy Koncentrates
- RU300, RU310, RU311, RU312, or RU313 Reducer
- KU150 or KU151 Catalyst



MIXING RATIO

To approximate closely the UK Kandy Kolors and meet the VOC rules, Please follow the chart on the next page.

UC25 / KK URETHANE KANDY MIX RATIOS & APPLICATION

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II



MIXING RATIO

To approximate closely the UK Kandy Colors and meet the VOC rules, Please follow the below chart.

To Duplicate UK Kandy Kolor	UC25 Kosmic Kandy Karrier	RU 310, 311, 312, or 313 Reducers	RU300 Exempt Reducer	KU150 or KU151 Exempt Catalyst	KK Koncentrate Kolor	KK Ratio in Ounces	VOC Grams/Liter	VOC Lbs./Gal.
UK01	32 oz.	12 oz.	4 oz.	16 oz.	KK01	10 oz.	417.50	3.48
UK02	32 oz.	13 oz.	3 oz.	16 oz.	KK02	7 oz.	409.7	3.42
UK03	32 oz.	12 oz.	4 oz.	16 oz.	KK03	10 oz.	418.27	3.49
UK04	32 oz.	11 oz.	5 oz.	16 oz.	KK04	10 oz.	411.47	3.43
UK05	32 oz.	10 oz.	6 oz.	16 oz.	KK05	13 oz.	413.07	3.47
UK06	32 oz.	11 oz.	5 oz.	16 oz.	KK06	11 oz.	409.31	3.42
UK07	32 oz.	13 oz.	3 oz.	16 oz.	KK07	6 oz.	413.11	3.45
UK08	32 oz.	14 oz.	2 oz.	16 oz.	KK08	3 oz.	409.75	3.42
UK09	32 oz.	13 oz.	3 oz.	16 oz.	KK09	7 oz.	416.05	3.47
UK10	32 oz.	9 oz.	7 oz.	16 oz.	KK10	20 oz.	416.21	3.47
UK11	32 oz.	12 oz.	4 oz.	16 oz.	KK11	8 oz.	410.07	3.42
UK12	32 oz.	12 oz.	4 oz.	16 oz.	KK12	9 oz.	412.45	3.44
UK13	32 oz.	13 oz.	3 oz.	16 oz.	KK13	7 oz.	412.56	3.44
UK14	32 oz.	10 oz.	6 oz.	16 oz.	KK14	12 oz.	409.99	3.42
UK15	32 oz.	9 oz.	7 oz.	16 oz.	KK15	16 oz.	414.91	3.46
UK16	32 oz.	11 oz.	5 oz.	16 oz.	KK16	10 oz.	414.60	3.46
UK17	32 oz.	15 oz.	1 oz.	16 oz.	KK17	4 oz.	419.85	3.50
UK18	32 oz.	14 oz.	2 oz.	16 oz.	KK18	4 oz.	418.44	3.49
UK19	32 oz.	12 oz.	4 oz.	16 oz.	KK19	9 oz.	418.10	3.47
UK20	32 oz.	11 oz.	5 oz.	16 oz.	KK20	10 oz.	411.26	3.43



GUN SET UP

- HVLP Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%



APPLICATION

Kosmic Kandys may be applied over any of our SHIMRIN® bases or Kosmic Solid Colors. Always spray a test panel before committing to the job.

NOTE: KU150 & KU151 Catalyst are moisture sensitive and will not keep for long periods once opened. When doing small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed.

Strain the paint into the paint gun. Apply 5 to 6 coats to achieve proper color. Start with 3 medium wet coats first, with 75% spray overlap. Finish with 2 to 3 full wet coats with 50% spray pattern overlap. Gun distance while spraying should be approximately 6 inches. Walk long objects. Allow flash time between coats.

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.

NOTE: Too long a dry time between coats may cause lifting. If finish feels dry, allow 12 hours at 70 degrees before re-coating. Scuff with maroon scuff pad to remove gloss or lightly wet sand with 500 or 600 wet. Use caution as too aggressive sanding can cause light and dark spots in the candy.

NOTE: Color strength will vary based on base color, number of Kandy coats, type and number of clear coats, and spray technique. LIGHTER BASE COLORS REQUIRE MAXIMUM NUMBER OF KANDY COATS FOR LONGEVITY. A base color tinted near the Kandy color eases application and improves longevity.

(CONTINUED)



KANDY APPLICATION TECHNIQUES

The application of "Kandy Type" finishes are among the most demanding of all finishes applied. Great attention must be paid in spray gun settings, number of coats and basic spray gun techniques. The following steps, when observed, provide consistent results.

Setting up the Spray Gun

- Know the equipment
- Check spray gun pattern, it must be consistent. (See Diagram One)
- Turn fluid knob in, to restrict trigger pull and reducer amount of Kandy delivered.
This must be done for the first two to three coats to avoid streaking. A 75% pattern overlap is mandatory.

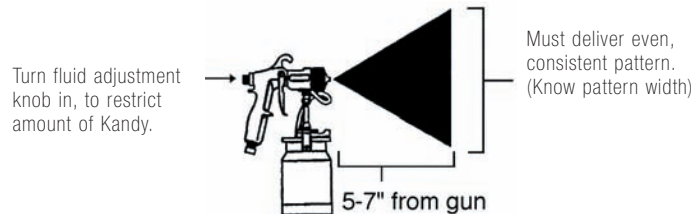


Diagram One

Application - The First 2 to 3 Coats

- Apply Kandy with recommended pattern overlap. (See Diagram Two)
- Spray gun should be 4 to 6 inches from surface.
- Do not apply Kandy panel to panel, spray entire length of object.
- Spray in straight lines, do not follow body lines. (See Diagram Three)

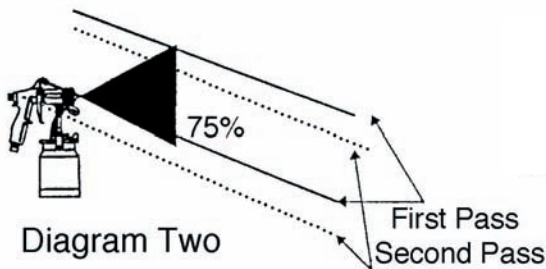


Diagram Two

Spray in straight lines.

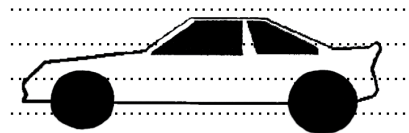


Diagram Three

Application - Final Coats

- Adjust fluid knob for a larger pattern 5-7" apply additional 2 to 3 coats with 50% overlap.
- Allow each coat to stop "stringing" before applying next coat. Do not allow coats to completely dry to touch between coats.
- Apply 2 to 3 coats of UC or UFC urethane top coat clear, allowing Kandy only enough time to stop "stringing". Do not allow Kandy to completely dry before clearing or wrinkling and lifting is likely to occur.

NOTE: Do not use USG100 Intercoat Barrier Klear. This is a base coat material. Use our Catalyzed UC or UFC Clear only.

CLEAR COATING

All Kandys must be clear coated with either UC35, UFC35 or UFC19 clears. DO NOT Allow the Kandy to go out of tack. Apply the clear as if it were the next coat of Kandy.

NOTE: Too long a dry time between coats may cause lifting. If finish feels dry, allow 12 hours at 70 degrees before re-coating. Scuff with maroon scuff pad to remove gloss or lightly wet sand with 500 or 600 wet. Use caution as too aggressive sanding can cause light and dark spots in the candy.

DRY TIME

- Air dry at 70 degrees = 24 hours
- Force dry at 140 degrees = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

NOTE: Based upon weather conditions, number of coats, solvent speed, etc. It is not unusual for the Kandy job to remain soft for extended periods of time. This does not mean the finish is uncured, it indicates the finish is holding solvents and will need additional time to fully harden.

FINISHING AND POLISHING

- In a 70 degree shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**



CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Color Coating
- Actual VOC RTS less exempt solvents: 2.02 lbs./gal. (242.7 g/L) max.
- Regulatory VOC RTS less exempt compounds: 3.5 lbs./gal. (420 g/L) max.
- Density: 9.69 lbs./gal. (1163 g/L) (Max. VOC Color)
- Weight % Volatiles: 69.25%
- Weight % exempt compounds: 48.37%
- Weight % water: 0%

HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

UC25 KOSMIC KANDY KARRIER

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II

GENERAL INFORMATION

Kosmic Kandy Karrier UC25 is a 2.1 VOC product that meets the VOC's for SCAQMD Rule 1151 and SJVAQMD Rule 4602 & 4612 Phase II compliancy. UC25 is designed to be used as a karrier for our KK Koncentrates to duplicate our UK Kandy Kolors over our Shimrin® Base Coats. UC25 is medium solids, 30% solids as applied, and has the same application properties as our conventional UK Kandy's. UC25 features excellent clarity. It has excellent weathering and ultraviolet resistance.



• REFER TO OUR TECH SHEET ON UC25 / KK URETHANE KANDY MIX RATIOS & APPLICATION

TECHNICAL DATA (See Low VOC Data Sheet For Specific Values For Each Product)

- Coatings Category: Color Coating
- Actual VOC RTS less exempt solvents: 0.60 lbs./gal. (72.4 g/L) max.
- Regulatory VOC RTS less exempt compounds: 1.59 lbs./gal. (191 g/L) max.
- Density: 10.23 lbs./gal. (1228.0 g/L) (Max. VOC Color)
- Weight % Volatiles: 71.8%
- Weight % exempt compounds: 65.9%
- Weight % water: 0%



HEATH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



GENERAL INFORMATION

Below is a brief description of all components that currently meet both VOC rules for SCAQMD's Rule 1151 and SJVAQMD's Rules 4602 & 4612 Phase II if used as outlined in Appendix "A" of this technical manual.

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- ALL OF THE COMPONENTS LISTED BELOW CANNOT BE SPRAYED ALONE AND MUST BE MIXED INTO OTHER PRODUCTS PRIOR TO APPLICATION.
- FOLLOW ALL MIXING AND APPLICATION PROCEDURES AS OUTLINED IN THIS MANUAL UNDER APPENDIX "A".
- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.

KV1 KOSMIC KONVERTOR

KV1 Kosmic Konvertor is an additive for Shimrin® base coats and was developed to effectively lower the VOC's of House of Kolor's Shimrin® Base Coats to meet the VOC limits of 3.5 lbs / gal VOC for SCAQMD Rule 1151 and SJVAQMD Rule 4602 & 4612 Phase II. This is accomplished by using low molecular weight urethane resins and exempt solvents thereby increasing the solids of our Shimrin base coats and lowering the VOC to 3.5 lbs / gal or lower. KV1 replaces the reducer in most Shimrin® products.

(See KV1 Kosmic Konvertor Technical Data Sheet In This Manual)



REDUCERS

House of Kolor® reducers were specifically designed to be used in our products only. UNDER NO CIRCUMSTANCES use other manufacturers reducers in House of Kolor® products. (For more information, refer to the tech data sheet in the main manual)

The below chart gives you the recommended temperature range and VOC information.

Reducer	Recommended Temperature (°F)	Actual VOC (lbs./gal.)	Actual VOC (grams/liter)
RU300	65 to 85	0	0
RU310	65 to 75	5.85	702.0
RU311	75 to 85	7.28	874.0
RU312	85 to 95	7.42	890.0
RU313	95 to 110	6.57	788.0
RU315	This is a retarded and must be used sparingly	7.85	941



CATALYSTS (HARDENERS)

House of Kolor's Hardeners are specifically designed to be used in our Shimrins / KV1mix kandy's, klear's and sealers. They're designed with the specific hydroxyl groups needed for proper cross-linking with our resins used in the manufacture our products. DO NOT use other manufacturers hardeners in House of Kolor's products. (For more information, refer to the tech data sheet in the main manual)

The below chart gives you the recommended temperature range and VOC information.

Hardener	Recommended Temperature (°F)	Actual VOC (lbs./gal.)	Actual VOC (grams/liter)
KU150	65 to 85	0	0
KU151	85 to 110	0	0

Based upon the size of object being painted and shop conditions will determine which hardener to us.



KE170 KRATOR ELIMINATOR

KE170 is a fisheye additive that does not need to be used in every coat. Use KE170 to correct fisheye or crater defects. (For more information, refer to the tech data sheet in the main manual)

CAUTION: May not correct major silicone contamination. In that case, use a silicone oil - which will be required throughout the job.

USING KRATOR ELIMINATOR (KE170)

Add 1/2 - 2 capfuls of KE170 Krator Eliminator per mixed quart.

Use only when necessary. Once the problem is corrected you do not need to continue using KE170.

ACTUAL VOC INFORMATION: 6.94 lbs/gal (832 g/L)

**AX01 ACCELERATOR™**

Accelerator™ AX01 is a potent curing aid. Use Accelerator™ to speed dry time in cool shops on parts that must be handled (or sanded for artwork layouts) or re-coated the same day. Accelerator™ was designed for catalyzed urethanes to speed up cure time. (For more information, refer to the tech data sheet in the main manual)

MIXING ACCELERATOR™ (AX01)

Use sparingly, up to 1/8 teaspoon per mixed quart.

DO NOT EXCEED 1/8 TEASPOON PER MIXED QUART.

Carefully monitor dry time between coats. Accelerator™ will cause the urethanes to flash between coats much faster and can cause lifting if allowed too much time between coats. Use the touch test:

URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING UP ON FINGER AT THE WETTEST POINT, BEFORE NEXT COAT IS APPLIED.

ACTUAL VOC INFORMATION: 6.63 lbs/gal (794 g/L)

**FA01 FLATTENING AGENT**

FA01 Flattening Agent is designed to reduce the gloss of our urethane clears. Flattening Agent will not effect adhesion but will increase hardness. It is great for under carriages, frames and engine parts where high gloss is not desired, but a tough, durable finish is.

NOTE: Large amounts of FA01 (8 oz. or more per "ready to spray" mixed quart) can cause reduction of flexibility, which should be considered before applying to flexible substrates. Do not exceed 16 oz. of FA01 per mixed quart. Adding more Flattening Agent beyond this point will have no effect on further gloss reduction.

(For mixing and other information, refer to the tech data sheet in the main manual)

ACTUAL VOC INFORMATION: 6.31 lbs/gal (757.0 g/L)

**KK KANDY KONCENTRATES**

KK Kandy Koncentrates are the same dyes used in our UK Kandys in a concentrated version. They can be used in our UC35 (See UC35 / KK Kandy mix under Appendix "A" of this manual) or in our SG150 Intercoat Pearl & Flake Carrier for artwork. They also can be added in limited amounts to our Ko-Seal® II as a tint. (For more information, refer to the tech data sheet in the main manual)

ACTUAL MAX. VOC INFORMATION: 5.23 lbs/gal (627.0 g/L)

(See Low VOC Data Sheet For Specific Values For Each Color)

**DRY PRODUCT**

The below dry pearl and flakes can be added to our SG150 Intercoat Pearl & Flake Carrier. (For mixing and other information, refer to the tech data sheets in the main manual)

DP & DR – Dry Pearls

F, MF, UMF – Flakes

KLG – Kosmic Long-Glo

IP – Ice Pearls

KPF – Kameleon® Pearls

KDP – Kosmic Pearls

KOP – Kameleon® Opals

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

**GENERAL INFORMATION**

There are products we offer that currently DO NOT meet the rules under SCAQMD Rule 1151 & SJVAQMD Rules 4602 & 4612 Phase II VOC regulations and MUST NOT be used after December 31, 2008, if you are planning to do your Kustom Paint Job in any of the effected districts.

EFFECTED PRODUCTS THAT WILL NOT MEET THE CURRENT RULES AS OF 12/31/08

- PC – Universal Pearls
- MB – Marbilizer®
- MC – Kosmic Krome
- UB04 - Single Stage Urethane
- UB05 - Single Stage Urethane
- UFB04 - Single Stage Urethane
- UFB05 – Single Stage Urethane
- UFB06 - Single Stage Urethane
- UK – Kandy's (see UC35 / KK mix)
- SG100 – Intercoat Clear (see USG100 & SG150)
- HH – High Heat Black
- SBS10 – Bleed Check Sealer
- KU100 – Catalyst (replaced with KU150 & KU151)

We are working hard to develop these products in a low VOC version but we are not comfortable with the current technology that has been offered to us to date.

EFFECTED AREAS

The South Coast Air Quality Management District (Rule 1151) rule goes into effect July 1, 2008. Any product manufactured prior to July 1, 2008, can be used through December 31, 2008. This district consists of the following areas:

Los Angeles County

Orange County

Western San Bernadino County

Western Riverside County

The San Joaquin Valley Air Quality Management District (Rule 4602 and 4612 Phase II) goes into effect January 1, 2009. This district consists of the following areas:

San Joaquin County

Stanislaus County

Madera County

Merced County

Fresno County

Kings County

Tulare County

Western Kern County

KC20 POST SANDING CLEANER

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II



GENERAL INFORMATION

KC20 POST SANDING CLEANER removes sanding residue as well as dirt, hand oils, and other light contaminants. KC20 will also reduce static when used on plastic and fiberglass parts. KC20 is designed for use in initial and final surface prep. However before sanding existing finish KCA100 should be used first. **See instructions for KCA100 Wax and Grease Remover.**

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

KC20 is to be used over sanded surfaces, OEM finishes, sanded primers, cured sealers, fresh base coats, Pin Strips, Air Brush Art, and other sensitive surfaces.



APPLICATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Soak clean cloth with KC20.
- Wipe surface with KC20 and wipe dry with clean, dry cloth before product dries.

KC20 should not be allowed to dry on surface. If this occurs, reapply KC20 using a clean cloth and wipe dry.

NOTE: KC20 is the only cleaner recommended for cleaning Shimrin base coats prior to top coating.



TECHNICAL DATA

KC20 Falls under a separate rule than 1151 & 4602 / 4612 Phase II.

(See appropriate rules for cleaners for your district)

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

KCA100 AEROSOL WAX & GREASE REMOVER

(APPENDIX "A")

Rule 1151 & Rules 4602 & 4612 Phase II



GENERAL INFORMATION

KCA100 WAX & GREASE REMOVER removes grease, wax, silicone, adhesives, tar, tree sap, insects and dirt. KCA100 is a quick flashing product designed to speed initial surface prep before sanding and body work. Don't apply more than you can wipe clean before KCA100 dries, or no contaminants are removed. (Wiping cloths become contaminated, change regularly and dispose of properly).

IMPORTANT NOTES (PLEASE READ AND UNDERSTAND)

- IF YOU ARE HAVING TROUBLE UNDERSTANDING ANY OF THE DIRECTIONS IN THIS TECH MANUAL, PLEASE CALL OUR TECH SUPPORT LINE AT (800) 844-4130.



SUBSTRATE

KCA100 is to be used over unsanded surfaces and OEM finishes. DO NOT USE KCA100 over polyester fillers, primers, sealers, or during any step of paint application. It is surface prep cleaner only.



APPLICATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Spray the KCA100 liberally to the surface or onto a clear rag.
- Wipe surface with KCA100 and wipe dry with clean, dry cloth before product dries.

KCA100 should not be allowed to dry on surface. If this occurs, reapply KCA100 using a clean cloth and wipe dry.



TECHNICAL DATA

KCA100 Falls under a separate rule than 1151 & 4602 / 4612 Phase II.

(See appropriate rules for cleaners and Aerosols for your district)

HEALTH AND SAFETY

IMPORTANT The contents of this package have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

VOC OF COMPONENTS AS PACKAGED

Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	Actual VOC (g/L)	Regulatory VOC (g/L)	Density (g/L)	Wt. % Volatiles	Wt. % Exempt Volatiles	Wt. % Water
PRIMERS & SEALERS								
KD2000	DIRECT TO METAL PRIMER	Primer	663	235	1499.9	63.1	18.9	0
KDA2000	DIRECT TO METAL PRIMER ACTIVATOR	Primer	188	325	1093.5	61.4	44.2	0
KS210	KO-SEAL® II 2.1 VOC WHITE SEALER	Primer	187	284	1555.1	38.7	26.7	0
KS211	KO-SEAL® II 2.1 VOC BLACK SEALER	Primer	184	281	1531.1	38.7	26.7	0
KS212	KO-SEAL® II 2.1 VOC SILVER METALLIC SEALER	Primer	153	280	1188.2	58.5	45.6	0
SHIMRIN® BC & FBC METALLIC BASE COAT								
BC01	SOLAR GOLD	Color Coating	795	794	883.7	90	0	0
BC02	ORION SILVER	Color Coating	738	737	947.2	77.9	0	0
BC03	GALAXY GREY	Color Coating	747	747.3	919.6	81.26	0	0
BC04	STRATTO BLUE	Color Coating	757	757.2	924.4	81.9	0	0
BC05	LAPIS BLUE	Color Coating	757	757.2	924.4	81.9	0	0
BC06	METEOR MAROON	Color Coating	755	755.6	928.0	81.4	0	0
BC07	GAMMA GOLD	Color Coating	756	756	926.8	81.6	0	0
BC08	NOVA ORANGE	Color Coating	753	751.9	940.0	80.1	0	0
BC09	PLANET GREEN	Color Coating	755	753.8	936.4	80.6	0	0
BC10	PAVO PURPLE	Color Coating	756	755.7	922.0	82.01	0	0
BC11	CINDER RED	Color Coating	750	750	934.0	80.26	0	0
BC12	ZENITH GOLD	Color Coating	749	749	944.8	79.29	0	0
FBC01	SOLAR GOLD	Color Coating	799	799	942.4	84.8	0	0
FBC02	ORION SILVER	Color Coating	807	807	917.2	88	0	0
FBC03	GALAXY GREY	Color Coating	793	793	901.6	88	0	0
FBC04	STRATTO BLUE	Color Coating	787	787	928.0	84.8	0	0
FBC05	LAPIS BLUE	Color Coating	755	755	925.6	81.6	0	0
FBC06	METEOR MAROON	Color Coating	758	758	919.6	82.4	0	0
FBC07	GAMMA GOLD	Color Coating	761	761	929.2	81.9	0	0
FBC08	NOVA ORANGE	Color Coating	749	749	937.6	79.9	0	0
FBC09	PLANET GREEN	Color Coating	748	748	937.6	79.79	0	0
FBC10	PAVO PURPLE	Color Coating	736	736	932.8	78.9	0	0
FBC11	CINDER RED	Color Coating	738	738	935.2	78.9	0	0
FBC12	ZENITH GOLD	Color Coating	754	754	944.8	79.8	0	0
MBC SHIMRIN® METAJULS™ BASE COAT								
MBC01	PALE GOLD	Color Coating	756	756	937.6	80.6	0	0
MBC01CF	PALE GOLD (Coarse)	Color Coating	755	755	936.4	80.6	0	0
MBC01FF	PALE GOLD (Fine)	Color Coating	759	759	920.8	82.4	0	0
MBC02	PLATINUM	Color Coating	754	754	935.2	80.6	0	0
MBC02CF	PLATINUM (Coarse)	Color Coating	755	755	936.4	80.6	0	0
MBC02FF	PLATINUM (Fine)	Color Coating	759	759	920.8	82.4	0	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

VOC OF COMPONENTS AS PACKAGED

Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	Actual VOC (g/L)	Regulatory VOC (g/L)	Density (g/L)	Wt. % Volatiles	Wt. % Exempt Volatiles	Wt. % Water
MBC SHIMRIN® METAJULS™ BASE COAT								
MBC03	BLACK DIAMOND	Color Coating	754	754	935.2	80.6	0	0
MBC03FF	BLACK DIAMOND (Fine)	Color Coating	742	724	920.8	80.6	0	0
MBC03CF	BLACK DIAMOND (Coarse)	Color Coating	771	771	935.2	82.4	0	0
PBC SHIMRIN® DESIGNER PEARL BASE COAT								
PBC30	SUNRISE	Color Coating	748	748	948.4	78.9	0	0
PBC31	SUNSET	Color Coating	753	753	943.6	79.8	0	0
PBC32	TANGELO	Color Coating	757	757	941.2	80.46	0	0
PBC33	PERSIMMON	Color Coating	750	750	926.8	80.9	0	0
PBC34	RAZBERRY	Color Coating	756	756	923.2	81.9	0	0
PBC35	PINK	Color Coating	752	752	938.8	80.1	0	0
PBC36	TRUBBLUE	Color Coating	750	750	937.6	80	0	0
PBC37	MAJIK BLUE	Color Coating	763	763	926.8	82.3	0	0
PBC38	LIMETIME	Color Coating	755	755	950.8	79.4	0	0
PBC39	HOT PINK	Color Coating	748	748	942.4	79.4	0	0
PBC40	VIOLETTE	Color Coating	761	761	954.4	79.7	0	0
PBC41	SHERWOOD	Color Coating	751	751	934.0	80.4	0	0
PBC42	PLATINUM	Color Coating	758	758	936.4	80.9	0	0
PBC43	BLACK	Color Coating	751	751	902.8	83.2	0	0
PBC44	SNOWWHITE	Color Coating	757	757	944.8	80.1	0	0
PBC46	KOPPER	Color Coating	747	747	936.4	79.8	0	0
PBC47	GOLDMINE	Color Coating	757	757	948.4	79.8	0	0
PBC48	CINNAMON	Color Coating	745	745	936.4	79.6	0	0
PBC49	SILVERWHITE	Color Coating	757	757	936.4	80.8	0	0
PBC50	COCOA PEARL	Color Coating	743	743	926.8	80.2	0	0
PBC52	CHERRY	Color Coating	736	736	925.6	79.5	0	0
PBC53	LIME GOLD	Color Coating	753	753	928.0	81.1	0	0
PBC55	DARK TEAL	Color Coating	754	754	926.8	81.4	0	0
PBC56	MEDIUM TEAL	Color Coating	756	756	926.8	81.6	0	0
PBC57	LITE TEAL	Color Coating	758	758	928.0	81.7	0	0
PBC58	REAL TEAL	Color Coating	748	748	940.0	79.6	0	0
PBC59	EMERALD GOLD	Color Coating	753	753	935.2	80.5	0	0
PBC60	BLUE GREY	Color Coating	756	756	912.4	82.9	0	0
PBC61	STARLITE	Color Coating	754	754	922.0	81.8	0	0
PBC62	KNOX GOLD	Color Coating	748	748	916.0	81.7	0	0
PBC63	LAKE VIOLET	Color Coating	752	752	926.8	81.1	0	0
PBC64	ULTRA ORANGE	Color Coating	745	745	941.2	79.2	0	0
PBC65	PASSION	Color Coating	746	746	942.4	79.2	0	0
PBC66	BITTERSWEET II	Color Coating	745	745	944.8	78.8	0	0
PBC67	RED II	Color Coating	757	757	923.2	82	0	0
PBC68	MAGENTA II	Color Coating	755	755	929.2	81.26	0	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

VOC OF COMPONENTS AS PACKAGED

Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	Actual VOC (g/L)	Regulatory VOC (g/L)	Density (g/L)	Wt. % Volatiles	Wt. % Exempt Volatiles	Wt. % Water
PBC SHIMRIN® DESIGNER PEARL BASE COAT								
PBC100	BLACK SPARKLE	Color Coating	746	746	905.2	82.4	0	0
PBC101	DARK TURK	Color Coating	748	748	896.9	83.4	0	0
PBC102	BLACK GOLD	Color Coating	747	747	896.9	83.26	0	0
PBC103	CORTEZ BLUE	Color Coating	749	749	931.6	80.4	0	0
PBC104	MIDNITE BLUE	Color Coating	753	753	925.6	81.4	0	0
PBC107	DEEP LILAC	Color Coating	760	760	932.8	81.5	0	0
NE SHIMRIN® NEON BASE COAT								
NE501	YELLOW	Color Coating	618	618	985.6	62.7	0	0
NE502	PINK	Color Coating	622	622	985.6	63.14	0	0
NE503	ORANGE	Color Coating	622	622	985.6	63.14	0	0
NE504	RED	Color Coating	622	622	985.6	63.14	0	0
NE505	MAGENTA	Color Coating	622	622	985.6	63.14	0	0
NE506	BLUE	Color Coating	602	602	985.6	61.1	0	0
NE507	GREEN	Color Coating	610	610	965.2	63.17	0	0
NE508	CHARTREUSE	Color Coating	623	623	983.2	63.35	0	0
NE509	HONEY	Color Coating	621	621	983.2	63.12	0	0
NE510	VERMILLION	Color Coating	622	622	985.6	63.14	0	0
NE511	ROSE	Color Coating	621	621	983.2	63.15	0	0
NE512	VIOLET	Color Coating	621	621	976.0	63.58	0	0
SG SHIMRIN® GRAPHIC COLOR & BC SOLID COLOR BASE COAT								
SG101	LEMON YELLOW	Color Coating	745	745	1087.5	68.5	0	0
SG102	CHROME YELLOW	Color Coating	732	732	1100.7	66.5	0	0
SG103	MOLLY ORANGE	Color Coating	690	690	1008.4	68.4	0	0
SG104	EURO RED	Color Coating	667	667	940.0	71	0	0
SG105	BLUE BLOOD	Color Coating	659	659	947.2	69.6	0	0
SG106	MALTISE MAROON	Color Coating	665	665	965.2	68.9	0	0
SG107	MAGENTA	Color Coating	651	651	967.6	67.31	0	0
SG108	SO-BLUE	Color Coating	636	636	1088.7	58.4	0	0
SG109	BURPLE	Color Coating	637	637	1000.0	63.7	0	0
SG110	MARINE BLUE	Color Coating	597	597	1141.4	52.3	0	0
SG111	TURQUOISE	Color Coating	685	685	978.4	70	0	0
SG112	LAVENDER	Color Coating	671	671	946.0	70.9	0	0
SG113	GREEN	Color Coating	651	651	1001.2	65	0	0
SG114	PINK	Color Coating	676	676	966.4	69.9	0	0
SG115	KOSMOS RED	Color Coating	668	668	947.2	70.5	0	0
BC25	BLACK	Color Coating	700	700	928.0	75.4	0	0
BC26	WHITE	Color Coating	654	654	1158.2	56.5	0	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

VOC OF COMPONENTS AS PACKAGED

Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	Actual VOC (g/L)	Regulatory VOC (g/L)	Density (g/L)	Wt. % Volatiles	Wt. % Exempt Volatiles	Wt. % Water
KBC SHIMRIN® KANDY BASE COAT								
KBC01	BRANDYWINE	Color Coating	720	720	924.4	77.9	0	0
KBC02	LIME GOLD	Color Coating	606	606	913.6	79.9	0	0
KBC03	WILD CHERRY	Color Coating	765	765	910.0	84.1	0	0
KBC04	ORIENTAL BLUE	Color Coating	756	756	911.2	83	0	0
KBC05	COBALT BLUE	Color Coating	747	747	910.0	82.1	0	0
KBC06	BURGUNDY	Color Coating	756	756	911.2	83	0	0
KBC07	ROOT BEER	Color Coating	714	714	935.2	76.3	0	0
KBC08	TANGERINE	Color Coating	746	746	911.2	81.9	0	0
KBC09	ORGANIC GREEN	Color Coating	750	750	905.2	82.89	0	0
KBC10	PURPLE	Color Coating	754	754	911.2	82.77	0	0
KBC11	APPLE RED	Color Coating	759	759	919.6	82.5	0	0
KBC12	PAGAN GOLD	Color Coating	736	736	911.2	80.8	0	0
KBC13	BURPLE	Color Coating	736	736	911.2	80.8	0	0
KBC14	SPANISH GOLD	Color Coating	760	760	911.2	83.4	0	0
KBC15	TEAL	Color Coating	755	755	899.3	84	0	0
KBC16	MAGENTA	Color Coating	755	755	908.8	83.1	0	0
KBC17	VIOLETTE	Color Coating	744	744	936.4	79.4	0	0
KBC18	PINK	Color Coating	752	752	916.0	82.1	0	0
KBC19	SCARLET	Color Coating	766	766	908.8	84.33	0	0
KBC20	PERSIMMON	Color Coating	754	754	904.0	83.35	0	0
KF SHIMRIN® KAMELEON® BASE COAT								
KF01	RED TO GOLD	Color Coating	766	766	913.6	83.79	0	0
KF02	CYAN TO PURPLE	Color Coating	766	766	913.6	83.79	0	0
KF03	SILVER TO GREEN	Color Coating	766	766	913.6	83.79	0	0
KF04	GREEN TO PURPLE	Color Coating	766	766	913.6	83.79	0	0
KF05	MAGENTA TO GOLD	Color Coating	766	766	913.6	83.79	0	0
KF06	GOLD TO SILVER	Color Coating	766	766	913.6	83.79	0	0
KF08	BLUE TO RED	Color Coating	766	766	913.6	83.79	0	0
INTERCOAT PRODUCTS								
SG150	INTERCOAT PEARL & FLAKE KARRIER	Color Coating	710	710	913.6	77.7	0	0
USG100	INTERCOAT BARRIER KLEAR	Clear	0.64	1.93	1279.0	72.68	72.68	0
KLEARS								
UC35	KOSMIC ACRYLIC URETHANE KLEAR	Color Coating	34	76	1245.8	61.6	58.9	0
UFC19	KOMPLY KLEAR® II (1.9 VOC)	Color Coating	190	289	1110.3	54.8	37.7	0
UFC35	POLYURETHANE FLO-KLEAR	Color Coating	44	90	1226.6	60.2	56.6	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

VOC OF COMPONENTS AS PACKAGED

Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	Actual VOC (g/L)	Regulatory VOC (g/L)	Density (g/L)	Wt. % Volatiles	Wt. % Exempt Volatiles	Wt. % Water
KANDY KONCENTRATES								
KK01	BRANDYWINE	N/A (Component)	591	591	928.0	63.7	0	0
KK02	LIME GOLD	N/A (Component)	497	497	918.4	65.9	11.74	0
KK03	WILD CHERRY	N/A (Component)	595	595	926.8	64.2	0	0
KK04	ORIENTAL BLUE	N/A (Component)	613	613	928.0	66.1	0	0
KK05	COBALT BLUE	N/A (Component)	609	609	952.0	64	0	0
KK06	BURGUNDY	N/A (Component)	586	586	930.4	63	0	0
KK07	ROOT BEER	N/A (Component)	600	600	937.6	64	0	0
KK08	TANGERINE	N/A (Component)	586	586	932.8	62.8	0	0
KK09	ORGANIC GREEN	N/A (Component)	590	590	935.2	63.13	0	0
KK10	PURPLE	N/A (Component)	572	572	937.6	61.03	0	0
KK11	APPLE RED	N/A (Component)	597	597	935.2	63.8	0	0
KK12	PAGAN GOLD	N/A (Component)	587	587	929.2	63.2	0	0
KK13	BURPLE	N/A (Component)	570	570	960.4	59.3	0	0
KK14	SPANISH GOLD	N/A (Component)	599	599	929.2	64.5	0	0
KK15	TEAL	N/A (Component)	607	607	941.2	64.5	0	0
KK16	MAGENTA	N/A (Component)	627	627	925.6	67.7	0	0
KK17	VIOLETTE	N/A (Component)	510	510	1071.9	47.6	0	0
KK18	PINK	N/A (Component)	625	625	930.4	67.2	0	0
KK19	SCARLET	N/A (Component)	613	613	926.8	66.1	0	0
KK20	PERSIMMON	N/A (Component)	613	613	925.6	66.2	0	0
ADHESION PROMOTERS								
AP01	ADHERETO® - For Metals & Plastics	Adhesion Promoter	827	827	872.9	94.7	0	0
AP02	ADHERETO® - For Polyethylene's	Adhesion Promoter	769	769	878.9	87.5	0	0
DRY PEARLS								
DP16	RAZBERRY	N/A (Component)	233	233	2330.9	10	0	0
DP18	CINNAMON	N/A (Component)	297	297	2697.8	11	0	0
DP19	GLINT GOLD	N/A (Component)	0	0	3357.2	0	0	0
DP20	ROSETTA RED	N/A (Component)	259	259	2586.2	10	0	0
DP21	LAZULI BLUE	N/A (Component)	259	259	2587.4	10	0	0
DP22	OSIRIS GREEN	N/A (Component)	0	0	3237.3	0	0	0
DP23	EGYPTIAN GOLD	N/A (Component)	270	270	2696.6	10	0	0
DP24	ALABASTER WHITE	N/A (Component)	243	243	2436.8	10	0	0
DP25	LITE ORANGE	N/A (Component)	473	473	1944.8	24.3	0	0
DP26	DEEP ORANGE	N/A (Component)	0	0	3267.3	0	0	0
DP27	VIOLET	N/A (Component)	259	259	2586.2	10	0	0
DP28	SILVER	N/A (Component)	272	272	2477.1	11	0	0
DP29	GREEN	N/A (Component)	0	0	3189.3	0	0	0
DP30	TURQUOISE	N/A (Component)	0	0	2601.8	0	0	0
DP31	AZTEC	N/A (Component)	0	0	3273.3	0	0	0

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VOC OF COMPONENTS AS PACKAGED

Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	Actual VOC (g/L)	Regulatory VOC (g/L)	Density (g/L)	Wt. % Volatiles	Wt. % Exempt Volatiles	Wt. % Water
DRY PEARLS								
DP32	LILAC	N/A (Component)	248	248	2478.3	10	0	0
DP33	GLADE GREEN	N/A (Component)	262	262	2616.2	10	0	0
DP34	INCA GOLD	N/A (Component)	253	253	2532.3	10	0	0
DP35	DEEP BLUE	N/A (Component)	0	0	3194.1	0	0	0
DP36	LIME GREEN	N/A (Component)	0	0	3194.1	0	0	0
DP37	RICH PINK	N/A (Component)	0	0	3309.2	0	0	0
DP38	BLUE GREEN	N/A (Component)	0	0	3377.6	0	0	0
DP39	LAVENDER	N/A (Component)	256	256	2561.1	10	0	0
DP40	GRAPHITE	N/A (Component)	0	0	3095.8	0	0	0
DP41	RUSTY RED	N/A (Component)	0	0	3369.2	0	0	0
DP42	BLUEBERRY	N/A (Component)	0	0	3035.9	0	0	0
DP43	SEA GREEN	N/A (Component)	0	0	3421.9	0	0	0
DP45	PURPLE HAZE	N/A (Component)	0	0	3133.0	0	0	0
DP46	BLUEGRASS	N/A (Component)	0	0	3330.8	0	0	0
DR01	WHITE SPARKLE	N/A (Component)	230	230	2297.3	10	0	0
IP01	ICE GOLD	N/A (Component)	0	0	2541.9	0	0	0
IP02	ICE WHITE	N/A (Component)	0	0	2541.9	0	0	0
IP03	ICE RED	N/A (Component)	0	0	2541.9	0	0	0
IP04	ICE VIOLET	N/A (Component)	0	0	2541.9	0	0	0
IP05	ICE BLUE	N/A (Component)	0	0	2541.9	0	0	0
IP06	ICE GREEN	N/A (Component)	0	0	2541.9	0	0	0
IP07	ICE TURQUOISE	N/A (Component)	0	0	2541.9	0	0	0
KOP1	PURPLE PASSION	N/A (Component)	225	225	2248.1	10	0	0
KOP2	MAPLE-NUT	N/A (Component)	192	192	1918.4	10	0	0
KOP3	DORADO DREAMS	N/A (Component)	280	280	2797.3	10	0	0
KOP4	TEQUILA SUNRISE	N/A (Component)	233	233	2326.1	10	0	0
KPF100	GREEN TO BLUE (90 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF100SF	GREEN TO BLUE (40 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF101	GOLD TO GREEN (90 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF101SF	GOLD TO GREEN (40 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF102	COPPER RED TO GREEN (90 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF102SF	COPPER RED TO GREEN (40 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF103	SAPPHIRE (90 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF103SF	SAPPHIRE (40 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF104	AQUARIUS (90 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KPF104SF	AQUARIUS (40 Microns)	N/A (Component)	0	0	1294.9	0	0	0
KDP2001	SILVER STREAK	N/A (Component)	291	291	2906.4	10	0	0
KDP2002	GOLD RUSH	N/A (Component)	291	291	2906.4	10	0	0
KDP2003	BLUSHING RED	N/A (Component)	291	291	2906.4	10	0	0
KDP2004	COPPER PENNY	N/A (Component)	291	291	2906.4	10	0	0
KDP2005	SUMMERTIME GREEN	N/A (Component)	291	291	2906.4	10	0	0
KDP2006	OCEAN BLUE	N/A (Component)	291	291	2906.4	10	0	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

VOC OF COMPONENTS AS PACKAGED

Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	Actual VOC (g/L)	Regulatory VOC (g/L)	Density (g/L)	Wt. % Volatiles	Wt. % Exempt Volatiles	Wt. % Water
FLAKES								
F14	RAINBO (1/64)	N/A (Component)	0	0	2637.8	0	0	0
F15	SILVER (1/64)	N/A (Component)	0	0	998.8	0	0	0
F16	LITE GOLD	N/A (Component)	0	0	1398.0	0	0	0
F17	DARK GOLD	N/A (Component)	0	0	1398.0	0	0	0
F18	ORANGE	N/A (Component)	0	0	998.8	0	0	0
F19	APRICOT	N/A (Component)	0	0	1398.8	0	0	0
F20	RED	N/A (Component)	0	0	998.8	0	0	0
F21	FUSCHIA	N/A (Component)	0	0	998.8	0	0	0
F22	ROYAL BLUE	N/A (Component)	0	0	1398.0	0	0	0
F23	GREEN	N/A (Component)	0	0	1398.0	0	0	0
F24	ABALONE	N/A (Component)	0	0	998.8	0	0	0
F28	KAMEN BLUE	N/A (Component)	0	0	1298.5	0	0	0
F31	RICH GOLD	N/A (Component)	0	0	998.8	0	0	0
F32	FIREBALL	N/A (Component)	0	0	998.8	0	0	0
F33	FINE RAINBO	N/A (Component)	0	0	998.8	0	0	0
F34	PINK ROSE	N/A (Component)	0	0	998.8	0	0	0
F61	MINI KAMEN BLUE	N/A (Component)	0	0	998.8	0	0	0
F64	MINI RICH GOLD	N/A (Component)	0	0	998.8	0	0	0
F65	MINI FIREBALL	N/A (Component)	0	0	998.8	0	0	0
F66	MINI PINK ROSE	N/A (Component)	0	0	998.8	0	0	0
F70	TRANSLUCENT RED GOLD	N/A (Component)	0	0	998.8	0	0	0
F71	TRANSLUCENT GREEN GOLD	N/A (Component)	0	0	998.8	0	0	0
F72	TRANSLUCENT BLUE GREEN	N/A (Component)	0	0	998.8	0	0	0
F73	TRANSLUCENT VIOLET RED	N/A (Component)	0	0	998.8	0	0	0
MF01	GOLD MINI FLAKE	N/A (Component)	0	0	1398.0	0	0	0
MF02	SILVER MINI FLAKE	N/A (Component)	0	0	1398.0	0	0	0
UMF01	ULTRA GOLD MINI	N/A (Component)	0	0	1398.0	0	0	0
UMF02	ULTRA SILVER MINI	N/A (Component)	0	0	1398.0	0	0	0
UMF03	ULTRA RAINBO MINI (1/256TH")	N/A (Component)	0	0	1398.0	0	0	0
UMF04	ULTRA MINI RAINBO (1/500TH")	N/A (Component)	0	0	1398.0	0	0	0
LONG GLO								
KL100	GREEN	N/A (Component)	0	0	3645.0	0	0	0
KL101	BLUE GREEN	N/A (Component)	0	0	3896.8	0	0	0
KL102	BLUE	N/A (Component)	0	0	3992.7	0	0	0
KL103	VIOLET	N/A (Component)	0	0	2996.3	0	0	0
CATALYSTS / HARDENERS								
KU150	EXEMPT CATALYST	N/A (Component)	0	0	1273.3	66.5	66.5	0
KU151	SLOW EXEMPT CATALYST	N/A (Component)	0	0	1268.5	66.5	66.5	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

VOC OF COMPONENTS AS PACKAGED

Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	Actual VOC (g/L)	Regulatory VOC (g/L)	Density (g/L)	Wt. % Volatiles	Wt. % Exempt Volatiles	Wt. % Water
REDUCERS & KONVERTOR								
RU300	VOC EXEMPT REDUCER	N/A (Component)	0	0	1229.0	100	100	0
RU310	FAST REDUCER	N/A (Component)	702	702	862.1	100	18.52	0
RU311	MEDIUM REDUCER	N/A (Component)	874	874	874.1	100	0	0
RU312	SLOW REDUCER	N/A (Component)	890	890	889.7	100	0	0
RU313	VERY SLOW REDUCER	N/A (Component)	788	788	871.7	100	9.56	0
RU315	RETARDER	N/A (Component)	941	941	941.2	100	0	0
KV1	KOSMIC VOC CONVERTER	N/A (Component)	39	108	943.6	63.1	59	0
OTHER COMPONENTS								
AX01	ACCELERATOR	N/A (Component)	795	794	883.7	90	0	0
FA01	FLATTENING AGENT	N/A (Component)	757	757	1001.2	75.6	0	0
KE170	KRATOR ELIMINATOR	N/A (Component)	832	832	889.2	93.5	0	0
CLEANERS								
KC20	POST SANDING CLEANER	Cleaning Solvent	24	N/A	997.6	99.52	0	97.1
KCA100	AEROSOL WAX & GREASE REMOVER	Cleaning Solvent	700.8	700.8	700.8	100	0	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
PRIMERS & SEALERS									
KD2000	DIRECT TO METAL PRIMER	Primer	4 Parts KD2000 to 1 part KDA2000 to 10% RU300	164.4	250	1417	40.5	28.9	0
KS210	KO-SEAL® II 2.1 VOC WHITE SEALER	Primer	4 Parts KS210 to 1 part KU150 to 1 part RU300	123.3	249	1451	51.4	42.9	0
KS211	KO-SEAL® II 2.1 BLACK SEALER	Primer	4 Parts KS211 to 1 part KU150 to 1 part RU300	122.2	246	1438	51.5	43	0
KS212	KO-SEAL® II 2.1 VOC SILVER METALLIC SEALER	Primer	4 Parts KS212 to 1 part KU150 to 1 part RU300	101.5	240	1209	66.9	58.5	0
SHIMIRIN® BC & FBC METALLIC BASE COAT									
BC01	SOLAR GOLD	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	204.0	392	1028	67.55	47.7	0
BC02	ORION SILVER	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	206.1	397	1025	67.9	47.8	0
BC03	GALAXY GREY	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	207.9	400	1019	68.5	48.1	0
BC04	STRATTO BLUE	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	209.4	403	1022	68.4	47.9	0
BC05	LAPIS BLUE	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	207.6	400.8	1023	68.3	48	0
BC06	METEOR MAROON	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	209.4	395.2	1022	68.4	47.9	0
BC07	GAMMA GOLD	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	207.1	399	1025	68	47.8	0
BC08	NOVA ORANGE	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	206.8	399.8	1024	68.1	47.9	0
BC09	PLANET GREEN	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	207.1	398.2	1025	68	47.8	0
BC10	PAVO PURPLE	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	208.2	400.9	1020	68.4	48	0
BC11	CINDER RED	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	206.3	397.4	1026	67.9	47.8	0
BC12	ZENITH GOLD	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	206.3	397	1026	67.9	47.8	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
SHIMRIN® BC & FBC METALLIC BASE COAT									
FBC01	SOLAR GOLD	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	204.2	393.6	1026	67.7	47.8	0
FBC02	ORION SILVER	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	221.4	407	1035	68.8	47.4	0
FBC03	GALAXY GREY	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	206.2	398.5	1016	68.6	48.3	0
FBC04	STRATTO BLUE	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	204.3	393	1023	67.92	47.94	0
FBC05	LAPIS BLUE	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	208.8	387	1022	68.34	47.9	0
FBC06	METEOR MAROON	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	209.6	389	1020	68.54	48	0
FBC07	GAMMA GOLD	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	209.2	403	1023	68.4	47.95	0
FBC08	NOVA ORANGE	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	206.6	398	1025	67.99	47.84	0
FBC09	PLANET GREEN	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	196.1	397	1025	67.97	48.84	0
FBC10	PAVO PURPLE	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	207.6	401	1022	68.3	47.98	0
FBC11	CINDER RED	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	202.7	392	1024	67.7	47.9	0
FBC12	ZENITH GOLD	Color Coating	2 parts KV1 to 1 part FBC to 1 part KU150	207.1	400	1026	67.98	47.8	0
MBC SHIMRIN® METAJUL™ BASE COAT									
MBC01	PALE GOLD	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	209.1	401.3	1025	68.2	47.8	0
MBC01CF	PALE GOLD (Coarse)	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	206.8	400.2	1024	68.1	47.9	0
MBC01FF	PALE GOLD (Fine)	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	209.2	402.4	1020	68.5	48	0
MBC02	PLATINUM	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	206.8	399.8	1024	68.1	47.9	0
MBC02CF	PLATINUM (Coarse)	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	207.1	400.3	1025	68.1	47.9	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
MBC SHIMRIN® METAJULS™ BASE COAT									
MBC02FF	PLATINUM (Fine)	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	188.8	402.4	921	68.5	48	0
MBC03	BLACK DIAMOND	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	206.8	399.7	1024	68.1	47.9	0
MBC03FF	BLACK DIAMOND (Fine)	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	209.2	402.4	1020	68.5	48	0
MBC03CF	BLACK DIAMOND (Coarse)	Color Coating	2 parts KV1 to 1 part MBC to 1 part KU150	206.8	399.5	1024	68.1	47.9	0
PBC SHIMRIN® DESIGNER PEARL BASE COAT									
PBC30	SUNRISE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.5	396.9	1028	67.8	47.7	0
PBC31	SUNSET	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	207.3	399	1026	68	47.8	0
PBC32	TANGELO	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.1	401.4	1025	68.1	47.8	0
PBC33	PERSIMMON	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.6	398.1	1023	68.2	48	0
PBC34	RAZBERRY	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.4	392.6	1022	68.4	48	0
PBC35	PINK	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	207.1	398.8	1025	68	47.8	0
PBC36	TRUBLEUE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.1	398.1	1025	68	47.9	0
PBC37	MAJIK BLUE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	209.7	403.9	1023	68.5	48	0
PBC38	LIMETIME	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	207.6	400.5	1028	67.9	47.7	0
PBC39	HOT PINK	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.3	397	1026	67.9	47.8	0
PBC40	VIOLETTE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	207.3	398.7	1026	68	47.8	0
PBC41	SHERWOOD	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.8	398.4	1024	68.1	47.9	0
PBC42	PLATINUM	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.1	401.5	1025	68.2	47.9	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight	
PBC SHIMRIN® DESIGNER PEARL BASE COAT										
PBC43	BLACK	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.2	398.2	1016	68.6	48.3	0	
PBC44	SNOWWHITE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	207.3	401	1026	68	47.8	0	
PBC46	KOPPER	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	205.8	396.5	1024	68	47.9	0	
PBC47	GOLDMINE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.6	401.2	1028	68	47.7	0	
PBC48	CINNAMON	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.6	400.2	1028	68	47.7	0	
PBC49	SILVERWHITE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.1	401	1025	68.2	47.9	0	
PBC50	COCOA PEARL	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	204.3	394.7	1022	68	48	0	
PBC52	CHERRY	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	203.3	391.3	1022	67.9	48	0	
PBC53	LIME GOLD	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.6	399.3	1023	68.2	48	0	
PBC55	DARK TEAL	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	207.4	400.4	1022	68.3	48	0	
PBC56	MEDIUM TEAL	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	207.6	401.3	1023	68.3	48	0	
PBC57	LITE TEAL	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.6	402.1	1023	68.4	48	0	
PBC58	REAL TEAL	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.1	396.8	1025	67.9	47.8	0	
PBC59	EMERALD GREEN	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.8	399	1024	68.1	47.9	0	
PBC60	BLUE GREY	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.9	401.3	1019	68.6	48.1	0	
PBC61	STARLITE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.2	400.3	1020	68.4	48	0	
PBC62	KNOX GOLD	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	205.9	397.3	1019	68.3	48.1	0	
PBC63	LAKE VIOLET	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.6	398.8	1023	68.2	48	0	

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
PBC SHIMIRIN® DESIGNER PEARL BASE COAT									
PBC64	ULTRA ORANGE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	205.3	394.6	1026	67.8	47.8	0
PBC65	PASSION	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	205.3	396.5	1026	67.8	47.8	0
PBC66	BITTERSWEET II	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.1	394.5	1026	67.78	47.7	0
PBC67	RED II	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.4	401.1	1022	68.4	48	0
PBC68	MAGENTA II	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	208.6	400.4	1023	68.3	47.9	0
PBC100	BLACK SPARKLE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.4	396.2	1017	68.5	48.2	0
PBC102	BLACK GOLD	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	205.9	396.4	1014	68.6	48.3	0
PBC103	CORTEZ BLUE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.6	397.1	1023	68.1	47.9	0
PBC104	MIDNITE BLUE	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	207.4	399.9	1022	68.3	48	0
PBC107	DEEP LILAC	Color Coating	2 parts KV1 to 1 part PBC to 1 part KU150	206.8	398.1	1024	68.1	47.9	0
NE SHIMIRIN® NEON BASE COAT									
NE501	YELLOW	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	173.2	334	1037	64	47.3	0
NE502	PINK	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.7	336	1037	64.14	47.3	0
NE503	ORANGE	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.2	336	1037	64.1	47.3	0
NE504	RED	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.7	336	1037	64.14	47.3	0
NE505	MAGENTA	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.7	336	1037	64.14	47.3	0
NE506	BLUE	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.7	336	1037	64.14	47.3	0
NE507	GREEN	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	171.7	330	1031	64.15	47.5	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
NE SHIMIRIN® NEON BASE COAT									
NE508	CHARTREUSE	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.0	336	1036	64.1	47.3	0
NE509	HONEY	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.5	336	1036	64.14	47.3	0
NE510	VERMILLION	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.7	336	1037	64.14	47.3	0
NE511	ROSE	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.6	336	1036	64.15	47.3	0
NE512	VIOLET	Color Coating	2 parts KV1 to 1 part NE to 1 part KU150	174.4	335	1035	64.25	47.4	0
SG SHIMIRIN® GRAPHIC COLORS & BC SOLID COLOR BASE COAT									
SG101	LEMON YELLOW	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	166.8	322	1062	61.9	46.2	0
SG102	CHROME YELLOW	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	163.1	313.9	1066	61.3	46	0
SG103	MOLLY ORANGE	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	191.6	369	1043	65.4	47.03	0
SG104	EURO RED	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	186.2	358	1025	65.96	47.8	0
SG105	BLUE BLOOD	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	184.4	354	1028	65.65	47.7	0
SG106	MALTISE MAROON	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	185.8	357	1032	65.5	47.5	0
SG107	MAGENTA	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	181.9	350	1032	65.12	47.5	0
SG108	SO-BLUE	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	177.6	343	1062	62.92	46.2	0
SG109	BURPLE	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	179.0	344	1041	64.3	47.1	0
SG110	MARINE BLUE	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	168.9	325	1076	61.2	45.5	0
SG111	TURQUOISE	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	190.0	366	1035	65.76	47.4	0
SG112	LAVENDER	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	187.0	360	1028	65.9	47.7	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAGMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
SG SHIMRIN® GRAPHIC COLORS & BC SOLID COLOR BASE COAT									
SG113	GREEN	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	182.1	350	1041	64.6	47.1	0
SG114	PINK	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	187.9	362	1032	65.7	47.5	0
SG115	KOSMOS RED	Color Coating	2 parts KV1 to 1 part SG to 1 part KU150	187.0	358.5	1028	65.9	47.7	0
BC25	BLACK	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	193.3	373	1023	66.9	48	0
BC26	WHITE	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	182.6	352	1080	62.3	45.4	0
KBC SHIMRIN® KANDY BASE COAT									
KBC01	BRANDYWINE	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	199.3	384	1022	67.51	48	0
KBC02	LIME GOLD	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	171.2	355.9	1019	68	51.2	0
KBC03	WILD CHERRY	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	209.7	406	1018	68.8	48.2	0
KBC04	ORIENTAL BLUE	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	207.7	401.1	1018	68.6	48.2	0
KBC05	COBALT BLUE	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	205.6	395.5	1018	68.4	48.2	0
KBC06	BURGUNDY	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	207.6	400	1018	68.59	48.2	0
KBC07	ROOT BEER	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	197.4	380	1024	67.16	47.88	0
KBC08	TANGERINE	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	205.6	396	1018	68.4	48.2	0
KBC09	ORGANIC GREEN	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	200.5	387	1018	67.9	48.2	0
KBC10	PURPLE	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	207.3	400	1018	68.56	48.2	0
KBC11	APPLE RED	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	209.2	402.3	1020	68.5	48	0
KBC12	PAGAN GOLD	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	205.6	396.4	1018	68.4	48.2	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
KBC SHIMRIN® KANDY BASE COAT									
KBC13	BURPLE	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	202.8	392	1019	68.1	48.2	0
KBC14	SPANISH GOLD	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	208.4	400	1017	68.7	48.2	0
KBC15	TEAL	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	208.2	400.7	1016	68.8	48.3	0
KBC16	MAGENTA	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	207.9	401	1018	68.62	48.2	0
KBC17	VIOLETTE	Color Coating	2 parts KV1 to 1 part BC to 1 part KU150	204.8	395	1024	67.9	47.9	0
KBC18	PINK	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	207.1	399	1019	68.42	48.1	0
KBC19	SCARLET	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	210.7	405.7	1018	68.9	48.2	0
KBC20	PERSIMMON	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	208.4	399.6	1017	68.7	48.2	0
KBC21	MAJESTIC	Color Coating	2 parts KV1 to 1 part KBC to 1 part KU150	195.1	374.4	1049	65.3	46.7	0
UC25 / KK KANDY MIX									
01 Series UK	Brandywine Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK01	238.6	418	1150	70.05	49.3	0
02 Series UK	Lime Gold Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK02	227.2	410	1153	70.3	50.6	0
03 Series UK	Wild Cherry Urethane Kandy Mix	Color Coating	32 oz. UC32 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK03	239.2	418	1150	70.1	49.3	0
04 Series UK	Oriental Blue Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK04	229.8	411	1155	70.4	50.5	0
05 Series UK	Cobalt Blue Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK05	232.1	413	1155	70.1	50	0
06 Series UK	Burgundy Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK06	230.4	409	1152	70	50	0

*** VOC Values reported as theoretical values based on calculations using EPA Test Method 24 and SCAQMD Method 303 for determination of exempt compounds

READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
UC25 / KK KANDY MIX									
07 Series UK	Root Beet Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK07	231.9	413	1159	70.2	50.2	0
08 Series UK	Tangerine Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK08	228.0	410	1163	70.3	50.7	0
09 Series UK	Organic Green Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK09	236.9	416	1156	70.1	49.6	0
10 Series UK	Purple Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK10	244.6	416	1138	69.2	47.7	0
11 Series UK	Apple Red Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK11	229.1	410	1157	70.2	50.4	0
12 Series UK	Pagan Gold Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK12	234.1	412	1153	70.1	49.8	0
13 Series UK	Burple Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK13	235.1	412	1158	69.8	49.5	0
14 Series UK	Spanish Gold Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK14	228.4	410	1153	70.5	50.7	0
15 Series UK	Teal Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK15	234.3	415	1149	70.1	49.7	0
16 Series UK	Magenta Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK16	232.1	415	1155	70.6	50.5	0
17 Series UK	Violette Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK17	242.8	420	1163	69.25	48.37	0
18 Series UK	Pink Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK18	235.6	418	1161	70.4	50.1	0

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READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
UC25 / KK KANDY MIX									
19 Series UK	Scarlet Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK19	237.6	418	1153	70.4	49.8	0
20 Series UK	Persimmon Urethane Kandy Mix	Color Coating	32 oz. UC25 to 16 oz. KU150 to 12 oz. RU310, 11, or 12 to 3 oz. RU300 to 10 oz. KK20	229.8	411	1155	70.4	50.5	0
KF SHIMIRIN® KAMELEON® BASE COAT									
KF01	RED TO GOLD	Color Coating	2 parts KV1 to 1 part KF to 1 part KU150	211.0	405	1019	68.8	48.1	0
KF02	CYAN TO PURPLE	Color Coating	2 parts KV1 to 1 part KF to 1 part KU150	211.0	405	1019	68.8	48.1	0
KF03	SILVER TO GREEN	Color Coating	2 parts KV1 to 1 part KF to 1 part KU150	210.9	405	1019	68.79	48.1	0
KF04	GREEN TO PURPLE	Color Coating	2 parts KV1 to 1 part KF to 1 part KU150	210.9	405	1019	68.79	48.1	0
KF05	MAGENTA TO GOLD	Color Coating	2 parts KV1 to 1 part KF to 1 part KU150	210.9	405	1019	68.79	48.1	0
KF06	GOLD TO SILVER	Color Coating	2 parts KV1 to 1 part KF to 1 part KU150	210.9	405	1019	68.79	48.1	0
KF08	BLUE TO RED	Color Coating	2 parts KV1 to 1 part KF to 1 part KU150	210.9	405	1019	68.79	48.1	0
INTERCOAT PRODUCTS									
SG150	Intercoat Pearl & Flake Karrier	Color Coating	2 Parts KV1 to 1 Part SG150 (premixed w/ Pearl or Flake) to 1 Part KU150	196.6	378.5	1019	67.42	48.13	0
USG100	Low VOC Intercoat Clear	Clear	3 Parts USG100 to 1 Part KU150 to 1/2 Part RU312 to 1/2 Part RU300	88.8	250	1234	76.1	68.9	0
KLEARS									
UC35	KOSMIC ACRYLIC URETHANE KLEAR	Clear	2 Parts UC35 to 1 Part KU150 to 1/4 Part RU312 to 3/4 Part RU300	72.4	191	1228	71.8	65.9	0
UFC19	KOMPLY KLEAR® II (1.9 VOC)	Clear	2 Parts UFC19 to 1 Part KU150 to 1 Part RU300	94.8	226	1181	69.73	61.7	0
UFC35	POLYURETHANE FLO-KLEAR	Clear	2 Parts UFC35 to 1 Part KU150 to 1/4 Part RU312 to 3/4 Part RU300	117.4	196	1097	71.2	60.5	0

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READY TO SPRAY VOC, Rules 1151, 4602, 4612 Phase II

ITEM NUMBER	DESCRIPTION	CATEGORY	MIXING RATIO	Actual VOC Ready for Use (g/L)	Regulatory VOC Ready for Use (g/L)	Density (g/L)	% Volatiles by Weight	% Exempt Compounds by Weight	% Water by Weight
ADHESION PROMOTERS									
AP01	ADHERETO® - For Metals & Plastics	Adhesion Promoter	Use as supplied	828.0	828	874	94.73	0	0
AP02	ADHERETO® - For Polyethylenes	Adhesion Promoter	Use as supplied	769.0	769	879	87.5	0	0

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