

HOUSE OF KOLOR

TECHNICAL DATA INFORMATION

IMPORTANT NOTE: This document includes information on UC-1 and UFC-1. 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.

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 manufacturers' 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 painters' 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

(601) 798-4229

PREPARATION

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 KP-2CF, or KP-21 catalyzed primers over body work and for build at deep sanded areas.

1. BODY WORK

Prepare vehicle using normal custom painting methods.

- A. Before any sanding, use KC-10 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 KP-2CF, or KP-21 Primers. Allow proper cure time to prevent shrinkage.
- F. Guide coat your primer with Tempo 827 so when you block sand, your sand scratches or low spots are revealed. Final sand the primer with 240-P grit dry or 400-P grit wet sandpaper.

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 KP-2CF Chromate Free Kwikure Epoxy Primer or KP-21 Low VOC Epoxy Primer. **See tech sheets for more information on KP 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 KC-10 Wax & Grease Remover prior to any sanding. For post-sanding, use our KC-20 to remove any sanding residue for final wash.

Please refer to the sanding recommendation chart, and apply 1-2 coats of KO-Seal II (sealer). Let dry for 1 hour before top coating.

NOTE: Do not re-coat existing paint finishes in excess of 6 mils, as paint failure can result from excessive film build.

BC & FBC SHIMRIN[®] METALLIC 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. 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 KP-2CF Chromate Free Kwikure Epoxy Primer, KD-2000 Direct To Metal Epoxy Primer or our KP-21 Kwikure Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**

2. GROUND COAT:

- Primer (KP-2CF, KD-2000, KP-21)
- Sealer (KO-SEAL II)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Primers and sealers are commonly used as a 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 primer application and tech sheet for 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.

3. MIXING SHIMRIN[®] BASES (BC & FBC)

Stir SHIMRIN[®] Base well. Reduce 50% (2 parts paint to 1 part reducer). Mix well and reduce only with RU-310, RU-311, or RU-312, based on booth temperature. **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 reducers.**

When blending, you may slightly over-reduce SHIMRIN[®] Bases or mix them with SG-100 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. Splitting or cracking may also occur when painting too fast without allowing proper dry time or by spraying on the base too wet and heavy.

4. APPLYING SHIMRIN[®] BASES (BC & FBC)

After reducing, strain the paint into the paint gun. Air pressure varies, use Gun Mfgs. Recommendations for fluid tip size and air pressure. 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.

Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 12 hours). Topcoat within 12 hours or apply SG-100 Intercoat Clear (see step 5).

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

NOTE: DO NOT APPLY HEAVY WET COATS OF BC & FBC 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, 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.)

BC & FBC SHIMRIN[®] METALLIC BASES

(continued)

5. 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 SG-100 Intercoat Clear (for urethane enamel topcoats) or C-1 Kustom Clear (for acrylic lacquer topcoats). 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 CLEAR. See tech sheet for more information on SG-100 Intercoat Clear.**

NOTE: DO NOT SAND SHIMRIN[®] METALLIC BASES DIRECTLY. Apply SG-100 Intercoat Clear for base coat protection if sanding is required. If you directly sand the SHIMRIN[®] metallic, you must re-base.

NOTE: SG-100 Intercoat Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE SG-100 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 KC-20 Post Sanding Cleaner for cleanup.

6. KANDY COAT (optional)

SHIMRIN[®] BC and FBC Bases may be Kanded 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 SG-100 Intercoat Clear for Kandy graphics. See tech sheet for more information.

7. 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 Kosmic Kolor Kandys to ease touch-ups or for additional creative effects. Simply catalyze and reduce by volume as usual.