

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 (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

- 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

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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® 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.