

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.

F, MF, UMF FLAKES

GENERAL INFORMATION

Flakes may be added to any of our SHIMRIN® Universal Bases, Kandys, Clears or Kustom Bases. 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 smoothes 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, a medium Flake look without the extra work associated with flake.*

1. MIXING FLAKES

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 SG-100 Intercoat Clear. *Use SG-100 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 4-5 shades darker than the flake color, to create the illusion of coverage in 2 coats.

NOTE: With a gravity feed gun, remove flakes between coats, simply stir and add for next coat or purchase an agitator gun cup.

FLAKE AMOUNTS - PER MIXED QUART OF CLEAR		
Type of Flake	For Dark Base	For Light Base
1/64" Flake (F) F14 & F15	1 - 3 oz.	3 oz.
1/128" Flake (F) F16 thru F25	2 level tsp. - 1 oz	1 oz.
1/64" Kameleon Flake (F) F27 thru F36 except F33	1 - 3 oz.	3 oz.
1/128" Kameleon Flake (F) F33, F60 thru F68	2 level tsp. - 1 oz	1 oz.
1/250" Mini Flake (MF) MF1, MF2, UMF3	2 level tsp. - 1 oz	1 oz.
1/500" Ultra-Mini Flake (UMF) UMF1, UMF2, UMF4	2 level tsp. - 1 oz.	1 oz.

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 UB-4, UB-5, BC-25 or BC-26 as these high pigmented bases will diminish the flakes.)

2. APPLYING FLAKES

WHEN USING LARGE FLAKES - BE SURE YOUR SPRAY GUN HAS A LARGE ENOUGH FLUID TIP TO ALLOW PASSAGE OF THE FLAKE. (1.8 TO 2.0)

Strain the paint into the paint gun, then add the Flake. Air pressure varies gun to gun, but low pressure works to reduce overspray. Apply 1-3 medium coats with 50% pattern overlap. Gun distance while spraying should be 4-6 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 flash time between coats.

NOTE: *DO NOT APPLY MORE THAN 3 COATS.* Succeeding coats add greatly to increased surface roughness and will require more clear and sanding to smooth out.

F, MF, UMF FLAKES

(continued)

3. KANDY COAT (optional)

Once you are satisfied with the flake application, allow flash time, then topcoat with 3 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 C-1 or SC-1 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 religiously for maximum merging of coats.*

Apply 2-4* coats of our UC-1 or UC-35 Clear. **See tech sheet for clear coat application.** Do not use SG-100 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.

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°.

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.