SG SHIMRIN® GRAPHIC KOLORS & BC25 & BC26 SOLID COLOR BASES

1. SUBSTRATE
   - K0-Seal ll
   - SG100 Interoat 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 fibers, 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 K2000 Direct To Metal Epoxy Primer. See tech sheets for more information on KP & KD Primers.

3. GROUND COAT
   - K510, 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
   - K0-Seal ll (see tech page on K0-Seal ll)
   - GS100, Cured Top Coat Clear & OEM Finishes (artwork only)
   - Dry Sandpaper = 260P to 320P grit
     (CAMI grade = 240 to 260 grit)
   - Wet Sandpaper = 400 to 500 grit
     (TFPA grade 600P to 800P grit)
   - Maroon soft pad

5. COMPONENTS
   - Shimrin® base coat
   - RUS10 fast, RUS11 medium urethane reducer,
   - Air Brush application: RUS11 (medium) RUS12 (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® Graphics 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: Spitting 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)
   - Paint the parts 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 painting is clear (usually about 1.5 to 60 minutes and not longer than 4 hours). Airwork 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 ml, leaving a minimal edge. (Tape pull away leaving a clean, low edge)

9. ARTWORK & INTERCOAT CLEAR (optional)
   Shimrin® Graphic Kolors, with their low solids, are an excelent 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 Interoat Clear (for urethane enamel topcoats) or SCO1 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Shimrin® Base from missteps. See tech sheet for more information on SG100 Interoat Clear.

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

NOTE: SG100 Interoat Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE SG100 AS A BUILD-UP OR TO 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 K202 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® clear. We have high amounts of UV Absorber, 2 times more than others for a 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 Shimrins, 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).