

Candy's, Pearls & Tri-Coats

For many years, these names have been the most beautiful paints and scared many a painter. This is because if you are not very consistent with your gun pattern and techniques, you will be doing this job over and over.

YOU MUST BE LIKE A ROBOT.

When painting all tricoats you must know exactly:

What basecoat color was used?

Which midcoat (candy or pearl) was used and exactly how many coats were used?

Even with a picked out color I recommend that you spray a test panel for the customer to see before you paint. If you check out our tri-coat blending section, it will show you how to do a letdown panel. Many times I have seen customers say "That isn't exactly the color I wanted" or "It looks different on the car than on the paint chip". Now it is too late. You can also keep the test panel to show to other customers.

Before shooting any Pearl, Candies or Tri-Coats, go to our tech sheet area and print out tech sheets or P-sheets (product bulletins) for every product that you will be using. I keep a file of all of these for reference when I am painting. I don't keep a computer in the garage.

Here is a part of a tech sheet from House of Kolor about spraying urethane Kandys. You will notice that these sheets include:

- ▶ Preparation before painting
- ▶ Sanding grit recommendations
- ▶ Mixing ratios
- ▶ Numbers of coats
- ▶ Pattern recommendations
- ▶ Dry times between coats
- ▶ Primer & Clear recommendations
- ▶ Special Tips & Techniques for each product
- ▶ Cure times

If you follow these sheets you will significantly improve your the quality of your paint jobs.

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 Catalyst is 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.

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 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.

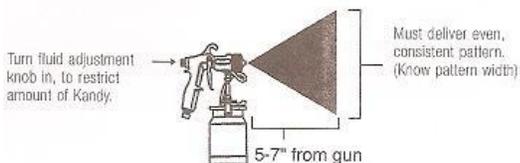


Diagram One

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)

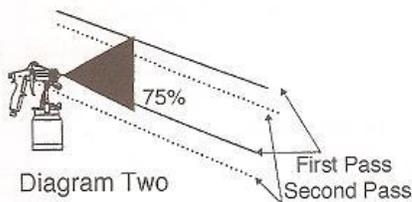


Diagram Two

Spray in straight lines.

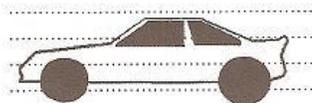


Diagram Three

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 SG100 Intercoat Clear. This is a base coat material. Use our Catalyzed UC or UFC Clear only.



10. 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.