



**GENERAL INFORMATION**

Shimrin® Designer Pearls (PBC) are universal base coats that may simply be cleared for a final finish, or used as a base coat for Kandys or other Pearls. 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® Pearl is top coated with an acrylic lacquer Kandy, it must also be cleared with an acrylic lacquer clear.



**1. SUBSTRATE**

- Ko-Seal® II
- SG100 Intercoat Clear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



**2. PREPARATION**

Read 'TECH PREP' thoroughly before you begin painting. Shimrin® Pearl 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 KP2CF Chromate Free Kwikure Epoxy Primer or our KD2000 Direct To Metal Epoxy Primer. **See tech sheets for more information on KP&KD Primers.**



**3. GROUND COAT**

- Sealer (Ko-Seal® II)
  - Shimrin® Solid Color Bases (BC25, BC26, SG, NE)
- VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF PEARL BASE COAT. Use BC26, KS10 or KS210 as a ground coat for white or light colored pearls (as shown on our Kustom Coatings color card). The color of the ground coat will vary the final pearl color. This is an excellent place for creativity. You may also use any of our Cosmic Kolor® Shimrin® Bases, Graphic Kolors or Neons, for the ground coat. Follow label instructions. Allow flash time on each coat of ground color.
- NOTE:** House of Kolor® sealers may also be used as a ground coat.
- 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.



**4. SANDING THE SUBSTRATE**

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100, 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



**5. COMPONENTS**

- PBC Shimrin® Designer Pearl base coat
- RU310 (fast), RU311 (medium) urethane reducer,
- Air Brush application: RU311 (medium) RU312 (slow)



**6. MIXING SHIMRIN® DESIGNER PEARLS (PBC)**

- 1 part Shimrin® PBC Designer Pearl base coat
  - 1 part RU- reducer
  - Air Brush Application: 1 part Shimrin® base, 1 part RU-reducer
- NOTE:** All Shimrin® Designer Pearls can be mixed at 2 parts PBC to 1 part Reducer, but a 1 to 1 ratio is recommended for ease of control, especially with lighter shaded PBC's.
- Stir Shimrin® Pearl well. Reduce 100% (1 parts paint to 1 part reducer). Mix well. **REDUCE ONLY WITH OUR KOSMIC REDUCERS.** Use the reducer best suited to your shop temperature. Shimrin® Designer Pearls are formulated to self-orient the pearl platelets and freeze them into position so no mottling occurs when top coated. **See tech sheet for more information on reducers.** When blending, you may slightly over-reduce Shimrin® Designer Pearls or mix them with SG100 Intercoat Clear for undetectable blends.
- NOTE:** Even though Shimrin® Designer Pearls are the easiest to apply, equipment, spray technique and air pressure can affect the pearl distribution. A full trigger pull is normally not recommended. Leave the fan wide but reduce the material sprayed with the spray gun's trigger restricter or material control knob.
- NOTE:** Splitting or cracking is possible when using other companies' reducers or by using a reducer that is too slow for your shop conditions.



**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® DESIGNER PEARLS (PBC)**

Strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 2-3 medium coats with 75% pattern overlap to achieve coverage, color, and effect. Walk long objects. Avoid dry spraying, as loss of adhesion or mottling is possible with pearls. Again, medium coats work best. Allow flash time between coats. **NOTE:** Splitting, wrinkling, or cracking may occur when painting too fast without allowing proper flash time or by applying the base too wet and heavy.



**9. DRY TIME**

Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 4 hours). Topcoat within 4 hours or apply SG100 Intercoat Clear (see step 10).

**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 sand Shimrin® Pearls without re-basing as the scratches on the pearl platelets are permanent. Use SG100 for protection if sanding is required or artwork is planned.

**NOTE:** 3 coats of Shimrin® Graphic Kolor or Designer Pearl Base Coat equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge) as with all Shimrin® Basecoats.

**10. 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 SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistapes. Plus you can use a grey scuff pad or 600 grit wet when SG100 is used. **See tech sheet for more information on SG100 Intercoat Clear.**

**NOTE:** SG100 Intercoat Clear is designed to protect the base coats for artwork tape-outs and blends only. **DO NOT USE SG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS.**

**CAUTION:** Shimrin® Base coats can be removed by final wash solvents. Use water or KC20 Post Sanding Cleaner for cleanup. RU, UFC, UC & UK Urethane – Kandys, Klears & Reducers are chemically designed to merge with the Shimrin® Basecoats – "Use No others" Avoid Problems. Other companies' products simply do not work with House of Kolor's system.

**11. KANDY COAT (optional)**

Shimrin® Designer Pearls 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 tech sheet for Kandy application.** Our Kandy Concentrates may be mixed with SG100 Intercoat Clear for base coat Kandys or for graphics. **See tech sheet for more information.**

**12. 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. **See tech sheets for more information on clear coat application.**

## ADDITIONAL INFORMATION

Shimrin® Designer Pearls may be intermixed for hundreds of color combinations. The Pearls may also be mixed with other Shimrin®, including the Neons, Graphic Kolors BC & FBC Metallic Base Coats. 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.

## 13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).



## NOTES