

# Tech Sheet – Kustom Shop KKU

## DESCRIPTION

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### **Katalized Kandy Urethane Series (KKU)**

Is a state-of-the-art, Urethane Kandy/clearcoat system designed with exceptionally clean depth and brightness.

**KKU** features outstanding color depth, rapid dry times and excellent flow and leveling.

**KKU** is an excellent choice as a Kandy over UMB Metallic basecoat, PCB Pearl Color basecoat, and all Kustom Shop Flakes. **KKU** is available in 18 outstanding colors.

## SURFACE PREPARATION

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### **USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING THESE PROCEDURES.**

- Properly Prepared Urethane Basecoat – see Tech Sheet for Basecoat color application.

## GROUND COAT

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Project being painted with **KKU Katalized Kandy Urethane** must be one even color before application of base color to assure consistent background tone for the base and subsequent kandy coats.

Kustom Shop **KEP** Epoxy Primer / Sealer is recommended as a ground coat for all basecoat colors. **KEP** Epoxy Primer sealer is available in Gray, White, Black and Red and is 2.1 Lb./Gal VOC.

## BASECOAT

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Any Kustom Shop UBC series basecoat may be used under **KKU Katalized Kandy Urethane**. **UMB Metallics** work great as the base to a great kandy job. Follow the tech sheet recommendation for basecoat application.

## COMPONENTS NEEDED

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- **KKU** Katalized Kandy Urethane
- **KH211** Fast or **KH212** Overall Hardener

Select best **KR** reducer for Shop or Booth temperature at the time of spraying.

- **KR60** – Fast Reducer for 55-70 Degrees F
- **KR70** – Medium Reducer for 65-80 Degrees F
- **KR85** – Slow Reducer for 80-95 Degrees F

## MIXING RATIO

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**Mixing Ratios: 4 : 1 : 1** 4 parts **KKU** Color – 1 Part **KH** Hardener and up to 1 part **KR** Reducer.

- Stir **KKU** Katalized Kandy Urethane well before reducing.
- Select best **KR** reducer for Shop or Booth temperature at the time of spraying:
  - **KR60** – Fast Reducer for 55-70 Degrees F
  - **KR70** – Medium Reducer for 65-80 Degrees F
  - **KR85** – Slow Reducer for 80-95 Degrees F

**NOT recommended for airbrush application.**

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## GUN SETUPS

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**HVLP Guns** = 10 PSI at the Cap

(Refer to spray gun manufactures recommendation for your particular gun)

**Conventional Guns** = 45-55 PSI

(Refer to spray gun manufactures recommendation for your particular gun)

**Needle / Nozzle** = 1.3 to 1.5 set up

**Trigger Pull Distance** = 50% to 75%

## APPLICATION

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**KKU** may be applied over any **UBC** series basecoat. Allow basecoat a minimum of 30 minutes and a maximum of 24 hours dry time before **KKU** application.

Always spray a test panel over the same basecoat color to determine the number of candy coats required to achieve the desired effect and color darkness before starting the entire job.

### Applying KKU

- After KKU color has been catalyzed and reduced, strain the mixed paint into the paint gun cup. (190 micron Nylon strainer is recommended)
- Spray 2 medium-wet coats with an overlap of 75% overlap. Followed by 2-3 full wet coats with a 50% overlap pattern.
- Allow 10-15 minutes @ 70° F flash time between coats
- Dry mils 2.0 to 3.0 mils. Wet mils 4.0 to 6.5 mils.
- Surface temperature should be 55-90°F with less than 80% ambient humidity preferred.
- Allow adequate flash times between coats -- approximately 5-10 minutes
- Remember to keep gun distance approximately 6 inches from surface while spraying.
- Avoid dry spraying, as it can produce a rough surface on subsequent coats and loss of adhesion.

**NOTE:** Depth of color or color darkness will vary on the base color used, number of candy coats and general spray gun technique.

## FLASH / DRY TIMES

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Dust-free: 20–30 minutes

Hard dry: Overnight

Full cure: 7 days

Dry to sand & polish: 6 to 8 hours

Force dry: Flash-off time – 15 minutes

Forced Dry time: 20 minutes @ 140°F

**Note:** If the basecoat is allowed to dry more than 24 hours, it must be scuffed and new basecoat applied.

## CLEARCOAT

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**KC210** Urethane Speed Clear with **KH212** Overall Hardener or **KC310** Super Flow Polyurethane Clear with **KH311** Hardener.

**Note:** The KKU may be clearcoated wet on wet in 30-45 minutes. If you exceed 45 minutes you must wait at least 12 hours and lightly scuff with gray scuff pad to remove gloss or lightly wet sand with 600-800 grit. Be careful when scuffing, if you are too aggressive you can cause light and dark spots in the candy. Be careful not to sand through to the basecoat color below when sanding.

**Note:** If KKU Kolor is more concentrated than you require, KKU is 100 percent compatible with KC210 Clearcoat. You may let down KKU candy to any level you desire. Make sure to katalize the KC210 clear with the same hardener used in the KKU color at a 4-1 ratio.

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## EQUIPMENT CLEANING

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Clean spray guns and coating application equipment in an enclosed equipment cleaner. Use KT-912 Compliant Solvent. Follow your local air quality regulations for solvent VOC requirements.

## TECHNICAL DATA

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**VOC:** ..... Less than 2.8 lb/gal (combined components) when sprayed at 4-1-1 ratio  
sprayed at 4-1-1 ratio  
**Color:** ..... Clear  
**Finish:** ..... High Gloss “wet look”  
**Solvent:** ..... Toluene, Ketones, Parachlorobenzotrifluoride, and Xylene.  
**Flash Point:** ..... 1°F TCC  
**Dust-free:** ..... 30 minutes  
**Dry-to-Touch:**..... 1 – 2 hours  
**% Solids by Volume:** ..... 31  
**% Solids by Weight:** ..... 33  
**Coverage:** ..... 500 sq. ft. per gallon @ 1 mil DFT  
**Viscosity:** ..... 14–15 seconds in #2 Zahn cup @ 77°F  
**Recoat Time:**..... 1 – 2 hours or wait 12 hours and scuff if over 2 hours.

## SAFETY

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**NOTE:** Before using any Kustom Shop product, be sure to read all MSDS and application instructions and warnings. Always wear a properly fitted air purifying respirator with organic vapor cartridges and particulate filter or a fresh air respirator (depending on product selection), eye protection, gloves and protective clothing during application and until vapors are exhausted. Do not permit anyone without protection in the painting area. This product is intended for use by a professionally trained painter.

**Keep out of the reach of children.**

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