Tech Sheet - Custom Shop UBC-LV 3.5 VOC Compliant

1. DESCRIPTION
Custom Shop UBC-LV Low VOC Urethane Basecoat
Custom Shop UBC-LV Urethane Basecoat is a state-of-the-art, basecoat/clearcoat system designed to reproduce the hi-tech O.E.M. finishes found on today’s vehicles. It features outstanding coverage, rapid dry time, excellent metallic control and optimum repairability. UBC-LV provides an environmental friendly solvent solution.

2. COMPONENTS
- UBC-LV Low VOC Base Coat
  For 3.5 VOC Must Use XR Series Reducer
  • XR85 Fast Reducer - Up to 55-70 F (24 C)
  • XR70 Medium Reducer - 70-85 F (24 C - 32 C)
  • XR60 Slow Reducer - 85 F and Above

For National Rule VOC May use KR Series Reducers
KR60, KR70, KR85 or UR60, UR70, and UR85

3. POT LIFE @ 77°F
When Properly Covered at 77°F / 25°C UBC-LV Basecoat will maintain a sprayable viscosity indefinently.
With KH211 or KH212: 2 Hours

4. MIXING RATIO
Mixing Ratios: 2 : 1 2 Parts UBLV Color - 1 Part XR, KR, or UR Reducer
Mix One Part Base Color with One Half Part Reducer (2-1 By Volume).
Optional: Add 5% Max. of KH211 or KH212 Activator per Sprayable Quart for Enhanced Performance.

5. CLEAN UP
KT-025 Compliant Solvent Cleaner

6. SUBSTRATES
- Epoxy Primer
- Properly Prepared OEM Surface
- Properly Prepared Aluminum and Steel.
Note: Do Not Apply Over Self Etching Primer

SURFACE PREPARATION
USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING RECOMMENDED PROCEDURES.
Wipe with KW901 Grease and Wax Remover or
For National Rule Areas KW902 Anti-Static Panel Cleaner
Abrade with 400 grit then 500 grit sandpaper or equivalent.
Wipe again with KW901 Grease and Wax Remover or KW902 Anti-Static Panel Cleaner
For best results apply anti-corrosive primer such as KEP Series epoxy primers over bare metal. KEP Epoxy May also be used as excellent sealer over all substrates and old finishes.

OEM Blend Areas
- Option 1: Clean blend area with KW901 or KW902. Scuff blend area with gray scuff pad and sanding paste. Sanding paste must be thoroughly washed away.
  Re-clean blend area with KW901 or KW902 prior to topcoating.
- Option 2: Clean blend area with KW901 or KW902. Sand blend areas with P800 - P1000 grit paper, for hard to reach areas scuff with gray scuff pad.
  Re-clean blend area with KW901 or KW902 prior to topcoating.
Note: Option 1 and 2 the OEM Blend area must be scuffed or sanded completely dull.

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7. APPLICATION
• Spray two (2) to three (3) medium-wet coats with an overlap of 75% until hiding and color match are achieved.
• Allow each coat 5-10 minutes flash or until finish is dull.
• Dry mils 2.0 to 3.0 mils (20-75 μm).
• Wet mils 4.0 to 6.5 mils (100-165 μm).
• Surface temperature should be 70-100°F / 21-35°C with less than 80% ambient humidity preferred.

8. FLASH / DRY TIMES
AIR DRY @ 77°F (25°C)

<table>
<thead>
<tr>
<th></th>
<th>Flash between coats</th>
<th>To Tape</th>
<th>To Clearcoat</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>5-10 Minutes</td>
<td>10-15 Minutes</td>
<td>30 Minutes</td>
</tr>
</tbody>
</table>

NOTE: If basecoat is allowed to dry more than 24 hours before clearcoating, scuff and respray basecoat.

9. GUN SET UP

CONVENTIONAL GUN

- Gravity Feed: 1.3 mm - 1.4 mm
- Siphon Feed: 1.6 mm - 1.7 mm

HVLP

- Fluid Tip: 1.3 mm - 1.4 mm tip

AIR PRESSURES

<table>
<thead>
<tr>
<th>Conventional @ Gun</th>
<th>Gravity Feed</th>
<th>Siphon Feed</th>
<th>HVLP Inlet Air</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>15-20 psi (1.0-1.5 bar)</td>
<td>30-40 psi (2.0-2.8 bar)</td>
<td>6-8 psi (0.41-0.55 bar)</td>
</tr>
</tbody>
</table>

See spray gun manufacturer info.

10. PHYSICAL DATA

<table>
<thead>
<tr>
<th>RTS REGULATORY DATA:</th>
<th>1:1</th>
</tr>
</thead>
<tbody>
<tr>
<td>(XR Series Reducers)</td>
<td></td>
</tr>
<tr>
<td>LBS./GAL g/L</td>
<td></td>
</tr>
<tr>
<td>Actual VOC 1.25 Max. 150 Max.</td>
<td></td>
</tr>
<tr>
<td>Regulatory VOC (less water and exempt solvents) 3.5 Max. 420 Max.</td>
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</tr>
<tr>
<td>Density 7 - 12 840 - 1440</td>
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<tr>
<td>WT.% VOL.%</td>
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</tr>
<tr>
<td>Total Volatile Content 70 - 95 70 - 95</td>
<td></td>
</tr>
<tr>
<td>Water Content 0 0</td>
<td></td>
</tr>
<tr>
<td>Exempt Compound Content 50 - 90 50 - 90</td>
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</tr>
<tr>
<td>Coating Category Coating Component</td>
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</table>

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