

# Tech Sheet – Kustom Shop UMB

## DESCRIPTION

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### **UMB Urethane Metallic Basecoat Series (UMB)**

Is a state-of-the-art, kustom basecoat/clearcoat system designed with exceptionally clean sparkle and brightness.

**UMB** features outstanding coverage, rapid dry times, excellent metallic control and optimum repairability.

**UMB** is an excellent choice as a basecoat for Kandy colors and for producing outstanding graphic designs. UMB is available in 18 outstanding colors plus a fine silver.

## SUBSTRATES

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**UMB Series Urethane Basecoat may be applied over:** Cleaned, sanded and primed OEM or Refinish topcoat.

Kustom Shop **KEP** Epoxy Primer / Sealer.

Kustom Shop **KUP** Urethane Primer.

Kustom Shop **KFP** Hi-Build 2K Primer Surfacer

Kustom Shop **KPP** Polyester Primer,

- Properly Prepared OEM Surface
- Properly Prepared Aluminum and Steel.

## SURFACE PREPARATION

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

- Wipe with KW901 Grease and Wax Remover or KW902 Anti-Static Panel Kleaner
- Abrade for DRY Sanding use a final grit sandpaper of 320 to 400. For WET-Sanding use 600-800 grit P-Grade wet sanding paper. A Maroon scuff pad may also be used.



- Wipe again with KW901 Grease and Wax Remover or KW902 Anti-Static Panel Kleaner
- For best results apply anti-corrosive primer such as KEP Series epoxy primers over bare metal and old OEM finishes.

## MIXING RATIO

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**Mixing Ratios: 2 : 1 2 parts UMB Color – 1 part KR Reducer.**

**For AIRBRUSH application may be reduced up to 1 part UMB color with 1 part KR Reducer.**

- Stir UMB Urethane Metallic Basecoat 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
- UBC825 Urethane Midcoat Clear Basecoat may be blended for less opacity and blending of colors. Reduce any added amount of UBC 825 Midcoat at the same reduction ratio 2-1 for spray guns or up to 1 to 1 for airbrush use

## 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%

**AIRBRUSHES** – Many different types of Airbrushes may be used.

(Refer to Airbrush manufactures recommendation for your particular Airbrush set-up)

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## APPLICATION

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### **For Air Spray**

- Spray 2 - 3 medium-wet coats with an overlap of 50% until full hiding is achieved
- Allow 5-10 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.
- After UMB color has been reduced, strain the mixed paint into the paint gun cup. (190 micron Nylon strainer is recommended)
- Allow adequate flash times between coats. Color should flash dry dull 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.
- DO NOT apply HEAVY WET COATS of UBC Basecoat products. Wrinkling and splitting may occur with subsequent coats. Only apply medium coats, if further hiding is needed you may spray extra medium coats for full hiding.

## FLASH / DRY TIMES

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**POT LIFE**.....When properly covered at 77°F UB Basecoat will maintain a sprayable viscosity indefinitely

**FLASH / DRY TIMES**.....AIR DRY @ 77°F

Flash Between Coats.....5-10 Minutes

To Tape.....20-40 Minutes

To Clearcoat.....30 Minutes

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

## KANDY OVER UMB BASECOAT

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**UMB** Urethane Metallic Basecoat may be used under both UKK Kandy Basecoats and KKY Katalized Kandy Urethane.

**UKK** Universal Kandy Koncentrate may be added up to 20% into UBC825 Midcoat clear base and into any UMB colors for extra color brilliance and effect. Please note that adding UKK to basecoat will have some degree of bleeding and color brightening when clearcoat is applied.

## GRAPHICS AND ARTWORK AND USING UBC825 MIDCOAT CLEAR

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UMB Urethane Metallic Basecoat are an excellent choice for graphic tape outs and airbrushing artwork. When airbrushing artwork, it is recommended that 1-2 coats of UBC825 Midcoat clear be applied over UMB Metallic base to protect the metallic from tape marks and allow for cleanup of some mistakes. UBC825 should be allowed to dry for a minimum of 4 hours and then abraded with a gray scuff pad for best adhesion of art work and clearcots.

## CLEAR COATING

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

## 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.

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## TECHNICAL DATA

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VOC (Volatile Organic Content).....5.69 lbs/gal (682 g/l)

VOC KR Reducers.....7.52 lbs/gal (902 g/l)

Flash Point .....27°F

## 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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