



[VMRPaints.com](http://VMRPaints.com)

# Premium Urethane Basecoat Technical Data Sheet

## PLEASE READ BEFORE YOU PAINT

VMR Paints has formulated a custom match to the OEM manufacture color based upon the correct base color, flake size and color mixture. Candy/Tri-Coat colors may be darkened or lightened based upon the number of coats applied. Candy/ Tri-Coats are a very unique paint because of the different contrast when viewed under different light conditions. Failure to comply with this Technical Data Sheet may result in a poor finish and/or void any warranty. Some mid-coats only contain an interclear used to apply pearls and/or flakes.



Always perform a spray out test prior to your application. Have an original OEM paint or paint chip available for comparison.



VMR Paints will not accept and returns and/or refunds once the paint has been applied to the part. The painter agrees the color, shade and/or flake color/size are correct as described once applied.

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## Premium Urethane Basecoat

### POT LIFE

- 4-8 Hours @ 70deg / 50% Relative Humidity

### MIX RATIO (check label)

- RFS (Ready for Spray)
- 1:1 (Mix one-part basecoat with one-part reducer)

### SURFACE PREPARATION

- Prepare all surfaces to be painted using recommended undercoat systems, following recommended procedures. Finish sand area with 400 P DA grit paper or finer (dry or wet).

### SPRAY GUN SETUP

- Conventional  
Siphon Feed: 1.4mm – 1.6mm (.055" - .063")
- Gravity Feed: 1.4mm – 1.5mm (.055" - .059")
- HVLP  
Siphon Feed: 1.4mm – 1.6mm (.055" - .063")  
Gravity Feed: 1.4mm – 1.6mm (.055" - .063")

### AIR PRESSURE

- Conventional Spot/Panel Overall.  
Siphon Feed: 45 psi @ the gun.
- Gravity Feed 35 – 45 psi @ the gun.  
- HVLP  
6-8 psi @ the gun cap. 7-9 @ the gun.

### APPLICATION

- Apply 2-3 medium coats.

### FLASH TIME

- Air Dry
- Flash Between Coats: 5-10 minutes.
- Flash Before Clear Coat: 15-30 minutes.
- Flash Before Tape: 30 minutes.
- Flash Before Two-Toning: 30 minutes.
- Maximum Allowable Dry Before Clear Coating: 24 hours.
- Force Dry Not Recommended.

### RECOATING / REPAIRS

- Basecoat may be recoated with itself within 24 hours.

### SANDING

- Basecoat dries to a smooth matte finish and SHOULD NOT be sanded. Nib sanding of small areas to remove dirt must be Following by the application of more color before clear coating.

### REQUIREMENTS

- Clearcoat

### CLEANUP

- Clean spray equipment immediately after use with Lacquer Thinner.

## Urethane Tri-coat System (if applicable)

Our products are Urethane Enamel Candys that provide fantastic gloss and depth. Available in many stunning translucent colors. They are crack resistant and can be applied over any of our Universal Base Systems.

### MIX RATIO (check label)

- 1:1 (1-part Urethane Tri-coat with 1-part reducer)
- 3:1 (3 Parts Urethane Tri-coat with 1-part Catalyst)
- RFS (1-part Urethane Tri-coat ready for spray)

### GUN SETUP

- Candys may be applied over any of our bases.
- Always spray a test panel before committing to the job.
- NOTE: Catalysts are 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 multiple coats to achieve proper color. Start with two medium wet coats first, with 75% spray overlap. Finish with two to three full wet coats or until desired shade of color is achieved with 50% spray pattern overlap. Gun distance while spraying should be approximately six inches. Walk long objects. Allow flash time between coats. Some darker colors may take additional coats.

URETHANE FLASH TEST – PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.

NOTE: To long of a dry time between coats may cause lifting. If finish feels dry. Allow 12 hours at 70 deg F before re-coating. Scuff with maroon scuff pad to remove gloss or lightly wet sand with .500 or .600 wet sandpaper. Use caution as too aggressive of sanding can cause light and dark spots in the Candy.

### CANDY APPLICATION TECHNIQUES

- The application of "Candy Type" finishes are among the most demanding of all finishes applied. Great attention must be paid to spray gun settings, number of coats and basic spray gun techniques. The following steps, when observed. Provide consistent results.

### FINISHING AND POLISHING

- In a 70 deg shop, allow 24 hours for dry time before polishing.
- After 60 days, the vehicle may be waxed. We recommend using A quality non-abrasive Carnauba way.

### DRYING TIME

- Air Dry at 70 deg = 24 hours.
  - Force dry at 140 deg = 30 minutes flash time, 2 hours bake, with 1 hour cool down.
- NOTE: Based on weather conditions, number of coats, solvents speed, etc.

### FLASH TIME

- 10-15 min between candys
- 30-60 min before Clear

### POT LIFE

- 2 hours @ 70 deg
- 50% Relative Humidity

- It is not unusual for the Candy job to remain soft for extended period 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.

### REQUIREMENTS

- Clearcoat

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## Urethane Clear

Our clearcoat is a 2k Urethane clearcoat designed for fast spot and panel applications. It is designed for those shops seeking a productive clearcoat that is easy to spray while delivering excellent gloss and distinctness of image. Recommended for use over properly applied basecoats and Candys.

### POT LIFE

- 2 hours @ 70 deg
- 50% Relative Humidity

### MIX RATIO

- 2 parts Urethane Clear
- 1-part Clearcoat Hardener

### GUN SETUP

- Conventional 35-45 psi at the gun
- Gravity Feed 30-40 psi at the gun
- HVLP: 8-10 psi
- Conventional & HVLP: 1.3mm – 1.6mm

### APPLICATION

- Apply 2-3 medium wet coats of clear

### FLASH TIME

- 5-10 min flash between coats  
(allow additional time per coats)

### DRYING TIME

- Out of dust: 5-7 minutes
- Tack Free: 1-2 hours
- To Tape: Overnight
- Force Dry: 140 deg x 30 min

### BUFFING

- If force dried, wait 3-6 hours @ 70 deg F before buffing.
- If air dried, wait 6-10 hours, depending on temperature and activator, before buffing.
- Remove dust with soft, dampened cloth and sand with 1500 grit or finer paper. Then polish with medium duty compound and finish with a soft polishing pad to remove any swirl marks. Operate at 1700-2000 rpm.

### CLEANUP

- Clean equipment thoroughly with lacquer thinner or Urethane Reducer (check local regulations).