



**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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**Urethane Primer**

Properly treat bare fiberglass, metal, steel and aluminum, as well as thoroughly sand painted surfaces. Clean surface thoroughly with mild detergent and water. For substrates, other plastic or fiberglass, wipe surface with Wax and Grease remover or locally permitted cleaner. Sand and featheredge according to the following minimum grit requirements:

**MIX RATIO (check can label)**

- 4 Parts Epoxy Primer
- 1 parts Primer Activator

**GUN SETUP**

- Conventional Siphon Fee:  
34-45 psi
- Gravity Feed 35-45 psi  
35-45 psi

**FLASH TIME**

- 5-10 minutes
- Apply 2-3 medium wet coats to achieve desired build.

**DRY TIME TO SAND**

- Air Dry: 2-3 hours @ 70 deg
  - Force Dry: 30 minutes @ 140 deg after 10 minute flash.
  - Sand wet/dry with #400 or finer paper.
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**Premium Urethane Basecoat**

**POT LIFE**

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

**MIX RATIO (check can label)**

- 1 part base coat Ready to Spray
- 1:1 (Mix one-part basecoat with one-part reducer)
- 2:1 (Mix 2 parts base coat with 1 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 followed by the application of more color before clear coating.

## REQUIREMENTS

- Clearcoat

## CLEANUP

- Clean spray equipment immediately after use with Lacquer Thinner.

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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 (check can label)

- 4 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).