



VMRPaints.com

Urethane Tri-Color System 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.

Midcoats containing a lot of pearl and/or flake make take as few as (1-2) coats or multiple coats. Don't overspray!

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 4:1

- 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.

Universal Base System

DO NOT APPLY HEAVY WET COATS OF UNIVERSAL BASES AND EXPECT THEM TO FLOW, THIS WILL TYPICALLY RESULT IN WRINKING AND SPLITTING. They behave very much like lacquer, so apply medium coats only and avoid heavy build. Do not dry spray or lack of adhesion is possible. Apply medium coats, 50% pattern overlap. Flash between coats.

MIX RATIO 4:1

- 2:1, 2 parts base coat, 1 part reducer
- RFS, Ready for Spray

GUN SETUP

- Conventional Gun = 45-55 psi
- HVLP Gun = 10 psi at the cap (refer to spray gun manufacturer recommendations)
- Needle/Nozzle = 1.3 to 1.5 for basecoats
- Needle/Nozzle = 1.5 for Flake Metallic Basecoats (depending on the size of the object being painted)
- Trigger Pull = 50% to 75%
- Air Brush: Follow gun manufacturer recommendations.

Flash Time

- 10-15 minutes

APPLYING BASECOAT

- After reducing, strain the paint into the paint gun. Gun distance while spraying should be approx. 6 in. Apply 1-2 MEDIUM coats with 50% pattern overlap. Walk long objects. Avoid dry spraying, as a loss of adhesion is possible.

APPLYING FLAKE BASECOATS

- Use 1.5 tip to prevent clogging. It is very important to keep the flake mixed well at all times while applying paint. Course flakes will settle at the bottom, preventing an equal distribution while spraying the basecoat. When spraying flake basecoats, many painters choose to remove the screen at the hopper to prevent clogging.

DRY TIME

Allow dry time before Candy or clear is applied (usually about 30-45 minutes and not longer than 4 hours). Topcoat within 4 hours.

NOTE: If dry time exceeds 4 hours, the basecoat must be lightly sanded or scuffed with 400-600 grit paper and re-coated prior to being top coated.

REQUIREMENTS

- Dry Sandpaper = 280p-320p grit (CAMI grade = 240-280 grit)
- Wet Sandpaper = 400-500 grit
- (FEPA grade 600p-800p grit)
- Maroon scuff pad

Urethane Tri-coat System (Candys - Midcoats)

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)

- 2:1:1 (2 parts Urethane Tri-Coat, 1-part reducer, 1-part Catalyst)
- 3:1 (3 Parts Urethane Tri-coat with 1-part Catalyst)
- 1:1 (1-part Urethane Tri-coat with 1-part reducer)
- RFS (1-part Urethane Tri-coat ready for spray)

GUN SETUP

- Conventional Gun = 55-65 psi
- HVLP Gun = 10 psi at the cap
(Refer to spray gun manufacturer's recommendation)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of the object being painted)

APPLYING CANDYS

- Candys may be applied over any of our base paint.
- Always spray a test panel before committing to a job.
- NOTE: Catalysts are moisture sensitive and will not keep for long period once opened. When doing small jobs, purchase 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: Too long of a dry time between coats may cause lifting. If finish feels dry, allow 12 hours at 70 deg 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 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 coat 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 wax.

FLASH TIME

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

POT LIFE

- 2 hours @ 70 deg
- 50% Relative Humidity

DRYING TIME

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