

SPECTRA Series

Urethane Candy Color System



TECHNICAL DATA SHEET

Kirker's SPECTRA Series is an innovative custom refinish system that combines vibrant pure-tone candy colors with advanced high-solids urethane coatings technology in a simple, user-friendly design. SPECTRA Series candy colors are made with a unique set of transparent automotive-grade pigments rather than dyes, eliminating bothersome bleed through and the need for intercoat clears. More important, these special pigments are lightfast, so they won't fade out when exposed to sunlight like other candy colors do.

- National Rule Compliant
- Easy 4:1 mix ratio, no additional reduction required
- Completely interchangeable – Mix to make new colors
- Exceptional value compared with other candy systems
- Vibrant, lightfast colors won't fade
- Ideal for overall paint jobs or custom accent work

COATING TYPE:

Acrylic Urethane Paint (Single-stage)

PRODUCT CODE:

"UC" prefix; Factory-pack colors (see color chart)

ACTIVATORS:

0175 Universal Candy Activator

REDUCERS:

Additional reduction is not required.
UR-9065 / UR-8065 Fast (Low temp)
UR-9075 / UR-8075 Medium (Mid temp)
UR-9085 / UR-8075 Slow (High temp)
UR-9095 / UR-8095 Super slow (Very high temp)
UE-8000 Universal Zero-VOC Reducer



PHYSICALS:

Appearance: Paint (color varies)
Weight per gallon: Candy (UC10-UC90): 8.02 lbs
Metallic Base (UCB01): 8.49 lbs
Package measure: 1 U.S. quart / 32 fl. oz.
RTS viscosity: 18-20 seconds in #2 Zahn Cup
RTS VOC: Maximum VOC of 5.0 lbs/gallon
(National Rule Compliant)

SUITABLE SUBSTRATES:

PERFECT PRIME – 2K Primer Surfacer (Overall)
(UP731 / UP732)
RAPID PRIME – 2K Primer Surfacer (Spot / Panel)
(UP711 / UP712)
ENDURO PRIME – Epoxy Primer
(EP611 / EP612)
SUPER RUST STOP – Non-Sanding Primer
(201, 202, 1260, 1262, 1264)

Well-prepped OE finishes and other automotive-grade primer systems may also be suitable

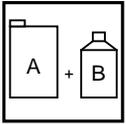


SURFACE PREP:

Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Abrade substrate with 600-800 grit, to ensure sufficient adhesion. Re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

Kirker's SPECTRA Series base may also be applied "wet on wet" over certain freshly applied undercoats including Kirker's PERFECT Prime (2K urethane primer surfacer – overall) and RAPID Prime (Kirker's 2K urethane primer surfacer – spot/panel) after approximately 30 minutes flash time; or ENDURO Prime (Kirker's 2-part epoxy primer) after 30-45 minutes flash time.

Be sure to mask all adjacent panels to prevent dry overspray.



MIXING:

Please note that while every attempt for color consistency is made, there may be some difference in shade from one batch to the next. If using multiple cans of the same color, for the same job, be sure to check for a common batch code before starting. This can be identified by the five-digit number marked either on the lid or face of the can. If batches are not the same, all materials should be blended prior to use to ensure color consistency.

No additional reduction is required. If necessary, use one of Kirker's urethane-grade reducers (chosed from the list below depending on the anticipated shop temperature at the time of application), or Universal Zero-V.O.C. Reducer (UE-8000). **WARNING:** With further reduction beyond the recommended 3:1 mix ratio, ULTRA-GLO may no longer be VOC compliant for your area.

Temperature range	Less than 70° F	70° F - 80° F	80° F – 90° F	Above 90° F
Reducer (Gallon)	UR-9065 (Gal)	UR-9075 (Gal)	UR-9085 (Gal)	UR-9095 (Gal)
Reducer (Quart)	UR-8065 (Qt)	UR-8075 (Qt)	UR-8085 (Qt)	UR-8095 (Qt)
Speed	FAST	MEDIUM	SLOW	SUPER SLOW

If necessary, Kirker's UFE8 Universal Fish Eye Eliminator may be added to the mix (1/2 ounce of UFE8 per ready-to-spray quart of SPECTRA Series candy color or base).

See sperate Technical Data Sheet for UCC500 CUSTOM Clear for additional details on mixing and applying that component.

Caution: Mix only as much material as you will need to complete the immediate job.

4:1

Base / Candy / Clear	4 oz.	12 oz.	24 oz.	36 oz.
0175 Activator	1 oz.	3 oz.	6 oz.	9 oz.
TOTAL MIXTURE	5 oz.	15 oz.	30 oz.	45 oz.



POT LIFE:

Approximately 2 hours at 70°F.

CAUTION: Pot life is significantly shorter at elevated temperatures and in humid conditions. These environmental factors also may affect flow and leveling during the application process.



GENERAL GUN SETTINGS:

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon Feed:	1.4 mm – 1.6mm	40-50 psi at the gun
Conventional Gravity Feed:	1.4 mm – 1.6 mm	40-50 psi at the gun
HVLP	1.2 mm – 1.4 mm	8-10 psi at the cap

These are general gun setting recommendations. Always refer to gun manufacturer's recommendations for more specific and additional details on suggested tip size, air pressure and other adjustments.



APPLICATION:

Urethane Candy Base (UCB) Colors

Apply metallic base in even coats with consistent overlap as necessary to achieve full hiding (coverage) while maintaining even distribution of aluminum. Be sure to allow at least ten (10) minutes flash time between coats (+/- depending on airflow and temperature). Insufficient flash times will result in a re-floating of the extra coarse metallic, causing a mottled finish. In most cases, three wet coats will be enough to provide sufficient coverage. A final Drop Coat may be applied lightly, to help even out the aluminum distribution and conceal any mottled areas.

Consistent application technique is important with UCB Series colors, because they will become increasingly rich as more material is applied. UCB Series colors are made with the same intense pigments used in the candy colors, so it is possible to achieve a darker shade by applying the base in heavy wet coats, or in additional coats.

Because it will be topcoated with candy, UCB01 does not have to be applied wet. It is more critical to ensure the metallic base is applied evenly, without mottling.

UC10 - UC90 Candy Colors

Once final coat of UCB color has flashed and all metallic has setup (10-15 minutes; +/- depending on air flow and temperature), apply SPECTRA Series candy colors in medium wet coats as necessary to achieve desired shade. Be sure to allow at least ten (10) minutes flash time between coats. SPECTRA Series candies will become increasingly deeper in color as the film builds. By adjusting the number of coats, it is possible to change the shade to appear lighter or darker than the color chip, which approximates 3-4 coats applied over UCB01 Quicksilver Metallic Base.

When applying candy colors, consistent spray pattern and application technique are critical. Inconsistent application will result in uneven color, splotchy finish and/or stripes.

SPECTRA Series candy colors may be clearcoated with any of Kirker's urethane clear systems after final coat has flashed, but before 18 hours have passed. After 18 hours, surface must first be abraded with 800 grit to promote sufficient adhesion.

See separate Technical Data Sheet for UCB-Series Metallic Base Colors, or UCC500 CUSTOM Clear for additional details on mixing and applying those components of the SPECTRA Series candy color system.



DRY TIMES:

	AIR DRY	FORCE DRY (Bake for 40 minutes at 140° F after five-minute flash)
Dust free:	15-20 minutes	End of cycle
Tack free:	1 hour	End of cycle
Tape:	8 hours	20 minutes after cycle
Polish:	8 hours	20 minutes after cycle
Full cure:	18-24 hours	20 minutes after cycle
Stripe:	Next day	20 minutes after cycle
Deliver:	24 hours	20 minutes after cycle
Decal:	48 hours	20 minutes after cycle

Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70° - 75°F



CLEANUP:

Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

Shelf life of 0175 Activator is limited once can has been opened. These products are extremely susceptible to oxygenation and exposure to moisture. Therefore, containers should be closed tightly after each use, with a clean seal, as quickly as possible. Also, activators should be stored at a consistent temperature to prevent the formation of potentially damaging condensation inside of the can.



RECOAT WINDOW:

SPECTRA Series candy colors may be recoated for up to 18 hours (at 70° - 75°F). After 18 hours (air dry; or 40-minute bake cycle), surface must first be abraded with 600-800 grit to promote sufficient adhesion before recoating.



POLISH:

It is strongly recommended that SPECTRA Series candy colors be clearcoated for the extra measure of protection and higher gloss that a clear coat can provide, though it is not necessary, as candy colors are made from a single-stage formula that will exhibit excellent gloss and may be polished.

After eight (8) hours dry time or 40-minute bake cycle, SPECTRA Series candy colors may be sanded with 1500 grit or finer to abrade surface and/or remove dust nibs and other imperfections such as orange peel, then with 2000 grit or finer sand paper to remove all 1500-grit scratches.

Use a wool pad or foam pad in combination with a high-quality finishing compound, following material manufacturer's instructions. Follow with a high-quality finishing glaze applied either by hand, or variable-speed buffer.



HEALTH / SAFETY PRECAUTIONS:

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted fresh-air-supplied NIOSH/MSHA-approved respirator (TC19C or equivalent) as directed by the manufacturer. Protect hands with impervious nitrile gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. **READ ALL WARNINGS ON ALL LABELS BEFORE USING.**

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Material Safety Data Sheets for additional health and safety information.

WARRANTY:

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. It is the responsibility of the purchaser to determine the suitability of this product for its intended use. Since the methods of use, conditions of application, and the application itself are beyond manufacturer's and sellers' control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

FOR ADDITIONAL INFORMATION:



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