

# BC & FBC SHIMRIN® METALLIC COLOR BASES

## GENERAL INFORMATION

Shimrin® Metallic Color Bases (BC & FBC) are universal base coats that may simply be cleared for a final finish, or used as a base coat for Kandys. Due to their unique chemistry make-up, they may be top coated with either acrylic lacquer or urethane enamel. Once a system is chosen (acrylic lacquer or urethane enamel) use only products within that system. Intermixing of these two systems, after the base coat, is not recommended. For example: If Shimrin® Base is top coated with an acrylic lacquer Kandy, it must also be cleared with an acrylic lacquer clear.



### 1. SUBSTRATE

- Ko-Seal® II
- SG100 Intercoat Clear (artwork only)
- Properly cured top coat clears and OEM finishes (artwork only)



### 2. PREPARATION

Read 'TECH PREP' thoroughly before you begin painting. Please be aware that Shimrin® bases can be susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, Please refer to the tech pages on KP & KD epoxy primers.



### 3. GROUND COAT

- Sealer (Ko-Seal® II)

VEHICLE MUST BE ONE EVEN COLOR BEFORE APPLICATION OF BASE COAT. Ko-Seal® II Sealers are commonly used and recommended as the ground coat for BC and FBC Metallic Bases. Use Ko-Seal® II sealer for faster coverage of base coats. When using sealer, allow flash time. **See tech sheet for information on Ko-Seal® II application.**

**NOTE:** *Sealer is not a cure-all for poor preparation and does not prevent discoloration or bleeding. The main purpose of the sealer is to increase adhesion of topcoats, to make the object one color (nearest to the base for faster coverage), and to improve color holdout.*



### 4. SANDING THE SUBSTRATE

- Ko-Seal® II (see tech page on Ko-Seal® II)
- SG100, Cured Top Coat Clears & OEM Finishes (artwork only)
- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Maroon scuff pad



### 5. COMPONENTS

- BC, FBC Shimrin® base coat
- RU310 (fast), RU311 (medium) urethane reducer
- Air Brush application: RU311 (medium), RU312 (slow)



### 6. MIXING SHIMRIN® BASES (BC & FBC)

- 2 parts Shimrin® base coat
- 1 part RU series reducer
- Air Brush application: 1 part Shimrin® base, 1 part RU-reducer



Stir Shimrin® Base well. Reduce 50% (2 parts paint to 1 part reducer). Mix well and reduce only with RU310 or RU311 reducer, based on booth temperature. **IMPORTANT NOTE: No catalyst is used in Shimrin® bases.** REDUCE ONLY WITH OUR KOSMIC REDUCERS. Use the reducer best suited to your shop temperature. **See tech sheet for more information on RU reducers.** **Note:** *For Air Brush application reduce 100% (1 part paint to 1 part RU311 reducer).*

When blending, you may slightly over-reduce Shimrin® Bases or mix them with SG100 Intercoat Clear for undetectable blends.

**NOTE:** *Splitting or cracking is possible when using other companies' reducers or by using a reducer that is too slow for your shop conditions.*

### 7. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLG Gun = 10 PSI at the cap (Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5 (Depending on the size of object being painted)
- Trigger Pull = 50% to 75%
- Air Brush: Follow gun manufacturer's recommendations



### 8. APPLYING SHIMRIN® BASES

After reducing, strain the paint into the paint gun. Gun distance while spraying should be approximately 6 inches. Apply 2-3 **MEDIUM** coats with 50% pattern overlap. Walk long objects. Avoid dry spraying, as loss of adhesion is possible. Again, **MEDIUM** coats work best. Allow flash time between coats.

**NOTE:** *DO NOT APPLY HEAVY WET COATS OF BC & FBC BASES AND EXPECT THEM TO FLOW, THIS WILL TYPICALLY RESULT IN WRINKLING 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 dull between coats.*

**NOTE:** *3 coats of Shimrin® BC or FBC Bases equals 1/2 to 3/4 mil, leaving a minimal edge. (Tape pulls away leaving a clean, low edge.)*



### 9. DRY TIME

Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 4 hours). Topcoat within 4 hours or apply SG100 Intercoat Clear (see step 10).

**SHIMRIN® FLASH TEST - ALL SHIMRIN® BASES WILL DRY DULL AND SHOULD FEEL DRY TO THE TOUCH BEFORE THE NEXT COAT IS APPLIED.**

Monitor closely for maximum merging of coats.



### 10. ARTWORK & INTERCOAT CLEAR (optional)

Shimrin® Bases, with their low solids, are an excellent choice for artwork paint jobs. DO NOT TAPE DIRECTLY ONTO THIS SHIMRIN® BASECOAT. If artwork is planned, apply 1 or 2 medium coats of SG100 Intercoat Clear (for urethane enamel topcoats) or SC01 Sunscreen Clear (for acrylic lacquer topcoats). The clear coat will protect the Shimrin® Base from tape marks and allow cleanup of mistakes. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR FINAL SANDING INTERCOAT CLEAR. See tech sheet for more information on SG100 Intercoat Clear.**

**NOTE:** *DO NOT SAND SHIMRIN® METALLIC BASES DIRECTLY. Apply SG100 Intercoat Clear for base coat protection if sanding is required. If you directly sand the Shimrin® metallic, you must re-base. NOTE: SG100 Intercoat Clear is designed to protect the base coats for artwork tape-outs and blends only. DO NOT USE SG100 AS A BUILD-UP OR TOPCOAT CLEAR, AS IT IS NOT WEATHER RESISTANT OR DESIGNED TO EXCEED 4 COATS. CAUTION: Shimrin® Base coats do not have any chemical resistance until cleared. Final wash solvents will remove base coats. Use KC20 Post Sanding Cleaner for cleanup.*

### 11. KANDY COAT (optional)

Shimrin® BC and FBC Bases may be Canded with either acrylic lacquer or urethane enamel. Remember if you Kandy with acrylic lacquer, you must also clear with acrylic lacquer. (If you Kandy with urethane enamel, you must also clear with urethane enamel). See appropriate tech sheets for Kandy application. For artwork, our Kandy Koncentrates may be mixed with SG100 Intercoat Clear for Kandy graphics. See KK & SG100 tech sheets for more information.

### 12. CLEAR COAT

ALL SHIMRIN® BC AND FBC BASES MUST BE CLEAR-COATED (with either urethane enamel or acrylic lacquer). Once a system is chosen, after the base coat, stay with that system. We recommend that you use House of Kolor® clears for best results. See appropriate tech sheets for more information on clear coat application.

### ADDITIONAL INFORMATION

Shimrin® BC and FBC Bases may be intermixed for hundreds of color combinations. BC and FBC Bases may also be mixed with other Shimrin®'s, including the Designer Pearls, Neons, and Graphic Colors. The possibilities are endless. Create your own one-of-a-kind custom finish.

Shimrin® Pearl and Metallic Bases may also be added, in small amounts (no more than 25%), directly to the Cosmic Kolor® Kandys to ease touch-ups or for additional creative effects. Simply catalyze and reduce by volume as usual.

### 13. CLEAN UP

Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).

