

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.

- ◆ 2.8 VOC meets even the most stringent regulations
- ◆ Brilliant, rich hues deliver maximum impact
- ◆ Mix and match for unique shades and new tones
- ◆ Easy 4:1 mix ratio
- ◆ 8 colors available in quarts

COATING TYPE:

Low-VOC Urethane Topcoat (single-stage)

PRODUCT CODES:

UC Prefix for Candy Colors
UCB01 Quicksilver Metallic Base

ACTIVATOR:

0175

WEIGHT PER GALLON:

Varies by color

PACKAGE MEASURE:

1 US Quart / 32 fl. oz. / 0.946 Liters

RTS VOC:

Varies by color (will not exceed 2.8 lbs/gallon)

RTS Viscosity:

18-20 seconds, #2 Zahn cup



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).

SPECTRA Series Urethane Candy Base may be applied "wet on wet," over certain freshly applied undercoats including Kirker's DIRECT PRIME, PERFECT Prime and RAPID Prime 2K Urethane Primer Surfacer after approximately 30 minutes flash time; or ENDURO PRIME DTM Epoxy Primer after 30-45 minutes flash. Be sure to mask all adjacent panels to prevent dry overspray.

COLOR

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.

SPECTRA SERIES URETHANE CANDY TOPCOAT

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MIXING

Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts SPECTRA SERIES Urethane Candy Topcoat with one (1) part SPECTRA Series Activator (0175).

TO MIX	12 oz	25 oz	35 oz
CANDY PAINT	8 oz	20 oz	28 oz
ACTIVATOR	2 oz	5 oz	7 oz

No additional reduction is required, though reducing the 4:1 mix may improve sprayability.

SPECTRA Series Urethane Candy Colors may be reduced with any of Kirker's ULTRA-GLO Urethane-Grade Reducers or BLACK DIAMOND Low-VOC Reducers (choose from the list below depending on the anticipated shop temperature at the time of application).

BELOW 70°	70-80°	80-90°	ABOVE 90°
FAST	MEDIUM	SLOW	SUPER SLOW
UA-1600M	UA-1600M	UA-1600S	UA-1600S
UR-9065	UR-9075	UR-9085	UR-9095
UR-8065	UR-8075	UR-8085	UR-8095
LVR-565	LVR-575	LVR-585	LVR-595

ULTRA-LOCK OPTION

SPECTRA Series Urethane Candy colors may be converted to spray and perform more like basecoat by integrating Kirker's ULTRA-LOCK (UA-2400) Metallic Control Additive/Basecoat Converter into the mix. ULTRA-LOCK significantly improves sprayability and ease-of use while converting single-stage urethane topcoats into fast-drying, basecoat-like finishes. Anti-Mottle Technology stabilizes metallic and pearl particles, locking these effect pigments in place for an even, streak-free finish.

To use, mix three (4) parts SPECTRA Series Urethane Candy Color with one (1) part Activator (0175), and one (1) part UA-2400 ULTRA-LOCK.

See Technical Data Sheet for ULTRA-LOCK for more specific information and details about application procedures.

POT LIFE

Approximately two hours at 70°F.

Mix only as much material as is needed to complete the immediate job.

GUN SETTINGS

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon	1.4-1.6 mm	40-50 psi
Conventional Gravity	1.2-1.5 mm	40-50 psi
HVLP	1.2-1.4 mm	8-10 psi

Always refer to gun manufacturer's recommendations for additional details on suggested tip size, air pressure and other adjustments.

APPLICATION

Urethane Candy Base (UCB)

Apply metallic base in even, wet 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, UCB color does not have to be applied wet for a gloss finish. It is more critical to ensure the metallic base is applied evenly, without mottling.

Urethane Candies may also be applied over other ULTRA-GLO SSU and BLACK DIAMOND Low-VOC Urethane Basecoat colors. Smaller metallic and pearl particles will give different appearance through the transparent candy film.

Urethane Candy Colors (UC)

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, patchy 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.

Another option includes integrating one of Kirker's urethane clearcoats into the final coat of SPECTRA Series Urethane Candy Color for increased gloss and durability in a single-stage application. This step is not necessary when planning to apply a separate clearcoat. Kirker's clears and SPECTRA Series colors may be mixed at any ratio, as long as care is taken to first properly mix both the paint and the clear with their correct activators, at the correct ratios.

DRY TIMES

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.

	AIR DRY	FORCE DRY (bake 40 min. at 140°F)
Dust Free:	15-20 min.	End of cycle
Tack Free:	1 hours	End of cycle
Tape:	8 hours	20 minutes after cycle
Polish:	8-12 hours	20 minutes after cycle
Full Cure:	18 hours	20 minutes after cycle
Stripe:	Next Day	20 minutes after cycle
Deliver:	Next Day	20 minutes after cycle
Decal:	48 hours	20 minutes after cycle

RECOAT

SPECTRA Series Urethane Candy Colors may be recoated for up to 18 hours (at 70-75°F). After 18 hours have elapsed, surface must first be abraded with 600-800 grit to promote sufficient adhesion before recoating.

POLISH

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

In single-stage applications: After eight (8) hours dry time, SPECTRA Series Urethane 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 to remove 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.

CLEANUP

Close all containers tightly after each use. Clean gun and spray equipment with Kirker's VOC Compliant Gun Wash (670) or other appropriate solvent products immediately after application to prevent damage.

HEALTH / SAFETY

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY. 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 Safety Data Sheet 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. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

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