

# UFC19 URETHANE KOMPLY KLEAR® II



## GENERAL INFORMATION

UFC19 URETHANE KOMPLY KLEAR® II is a 1.9 VOC polyurethane clear coat with application properties of low solids clear coats such as UFC01. UFC19 is 33% solids as applied and buffs easily the next day. UFC19 delivers the low VOC needed for air quality regulations yet handles like conventional clear coats currently used. URETHANE KOMPLY KLEAR® II may be used to topcoat any of our Kosmic Kolor® urethane or polyurethane enamel finishes, or any of our Shimrin® Base coats. UFC19 features excellent gloss, long flow out, very good D.O.I. (Distinctness of Image), and good chemical and water resistance. UFC19 has excellent weathering and ultraviolet resistance, and easily color sands and polishes from 24 up to 72 hours.



## 1. PREPARATION

Read "TECH REP" thoroughly before you begin painting. To prevent filler bleed through, apply 3 coats of our KP2CF Chromate Free Kwikure Epoxy Primer, KD2000 Direct To Metal Epoxy Primer, or our KP21 Kwikure Epoxy Primer. **See tech sheets for more information on KP & KD Primers.**



## 2. SUBSTRATE

- Shimrin® Base Coats
- UK Kandys
- Properly cured and prepared OEM finishes



## 3. SANDING THE SUBSTRATE

- UK's and Shimrin® Base Coats,
  - See tech sheets on UK Kandys and Shimrin® Base Coats
- OEM Finishes
  - Dry Sandpaper = 280P to 320P grit (CAMI grand = 240 to 280 grit)
  - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
  - Maroon scuff pad



## 4. COMPONENTS

- UFC19 Urethane Komply Klear® II
- RU300 Exempt Reducer only
- KU150 Exempt or KU151 Hi temp Catalyst
- Air Brush application: Not recommended



## 5. MIXING KOMPLY KLEAR® II (MIX ONLY WHEN READY TO SPRAY)

- 2 parts UFC19 Urethane Komply Klear® II
- 1 part RU300 reducer
- 1 part KU150 Catalyst or KU151 Hi Temp Catalyst
- Air Brush Application: Not recommended

Mix well. Pot life is approximately 3 hours depending on shop conditions.

**NOTE:** No reducer other than RU300 VOC Exempt Reducer can be used to remain at 1.9 VOC.

**NOTE:** AX01 accelerator may be used to speed up flash times.

**NOTE:** We have designed specific catalysts to work with each of our clears. The catalysts are NOT interchangeable. Use only the catalyst specified for the specific clear you are using.

**NOTE:** KU150 & KU151 catalyst are moisture sensitive and will not keep for long periods once opened. When doing many small jobs, buy smaller containers to prevent spoilage. Keep container tightly sealed. Clean the catalyst container's pour spout by wiping the threads with reducer for easy reopening.



## 6. GUN SET UP

- Conventional Gun = 55 to 65 PSI
- HVLV 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 = Not recommended



## 7. APPLYING KOMPLY KLEAR® II (UFC19)

Apply one medium wet coat with 50% pattern overlap, wait approximately 5-10 minutes (do "URETHANE FLASH TEST" below). Follow with a full wet coat, wait approximately 10-15 minutes. Allow flash time between coats (do "URETHANE FLASH TEST" below). Apply a second wet coat. Gun distance while spraying should be approximately 6 inches.

**URETHANE FLASH TEST - PAINT SHOULD BE STICKY AND NOT STRING WHEN TOUCHED AT THE WETTEST POINT BEFORE NEXT COAT IS APPLIED.**

(When using the flash test, always touch a new spot.) Monitor closely for maximum merging of coats.



## 7. APPLYING KOMPLY KLEAR® II (continued)

Dry time between coats is approximately 10-20 minutes depending on shop conditions. High heat or high humidity conditions will accelerate cure time. Always check dry time using the string test.

**CAUTION:** Too long a wait between coats can cause wrinkling or lifting. Also too fast a re-coat can cause pinholes or solvent popping during cure. If excessive dry time has elapsed and clear coat feels dry to touch, allow 24 hours before sanding and re-coating to avoid lifting problems.



## 8. DRY TIME

- Air dry at 70 degrees = 24 hours
- Force dry at 140 degrees = 30 minutes flash time, 2 hours bake, with 1 hour cool down.

**NOTE:** Based upon weather conditions, number of coats, solvent speed, etc. It is not unusual for the Klear to remain soft for extended periods 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.



## 9. COLOR SANDING

IF NOT FLOW COATING, GO TO STEP 11 POLISHING. After clear coats have cured, (approximately, 24 hrs.), color sand wet (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Add a small amount of mild liquid detergent to the water and soak the sandpaper for 15-20 minutes. This prevents sandpaper loading. Sand the entire vehicle flat, leaving no glossy spots. Dry as you go, soap residue can bite the fresh paint. After sanding, wipe the vehicle with a clean rag and water. Wipe dry. Use a tack rag to remove lint before re-coating. (Chemical washes at this stage are not recommended). Use clean rags and KC20 Post Sanding Cleaner if contaminated.

**NOTE:** Avoid touching the vehicle with your bare hand as the oil from your skin may impair flow coats.

**CAUTION:** DO NOT SAND THROUGH THE KLEAR AND RUIN ALL THAT YOU HAVE DONE. Look for colored water, this will indicate you sanded through the clear.



## 10. FLOW COATS (optional)

RE-TAPING THE VEHICLE, AFTER COLOR SANDING, WILL GIVE YOU A CLEANER FINISH WHEN FLOW COATS ARE APPLIED.

After color sanding, re-clear using UFC19 mixed at 2-1-1-1/2 (30% to 50% additional RU300 reducer to a premixed quart of clear) works best for flow coats. Begin with a medium coat, allow flash time, and then follow with 1-2 wet coats. Keep gun close and wet it out, use a 50% pattern overlap. Allow flash time between coats. For improved hardness the next day, add 1 extra oz. of KU150 Exempt Catalyst per mixed quart of clear.

**NOTE:** With this method, polishing is not required unless you desire a show quality finish, or to remove minor dirt particles. Polish after 24-48 hours.



## 11. FINISHING AND POLISHING

- In a 70 degree shop, allow 24 hours for dry time before polishing.
- **See tech sheet for information on Polishing & Finishing.**



## 12. CLEAN UP

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