

SG100 INTERCOAT CLEAR



GENERAL INFORMATION

SG100 Intercoat Clear is designed as a protective intermediate clearcoat for artwork tape outs on Shimrin® Base Coats. USE ONLY WHEN TOP COATING WITH URETHANE ENAMEL. SG100 Intercoat Clear prevents the tape from marking or pulling the metallic and splitting when top coated, provided only a minimum of medium coats has been applied. Do your art tape outs, spray, and remove tape as soon as possible to reduce tape marks and adhesive tracks.

SG100 Intercoat Clear may be used to blend Shimrin® Pearl and Metallic Base Coats, to mix Pearl and Kandy Koncentrates, and to cut the Shimrin® Base for touch-ups and blends.

IMPORTANT NOTE

DO NOT USE SG100 AS A TOPCOAT CLEAR, THIS IS A BASE COAT MATERIAL! SG100 is designed to protect base coats for artwork tape outs and blends only. DO NOT USE SG100 AS A BUILD-UP CLEAR. Do not apply more than 4 medium coats of SG100 as wrinkling and splitting may occur. If over reduced, more coats are acceptable.

NOTE: SG100 may be applied over basecoats, over cured catalyzed urethanes for additional tapeouts. However, use fast reducer and allow dry time between coats to prevent lifting.



1. SUBSTRATE

- All Shimrin® Bases
- Marblizer®s
- Properly cured top coat clears and OEM finishes (artwork only)



2. PREPARATION

Prior to applying SG100 Intercoat Clear, it is advised to wipe down the Shimrin® Base with KC20 Post Sanding Cleaner.



3. COMPONENTS

- SG100 Intercoat Clear
- RU310 (fast), RU311 (medium) urethane reducer,
- Air Brush application: RU311 (medium) RU312 (slow)



4. MIXING SG100 INTERCOAT CLEAR

- 2 part SG100 Intercoat Clear
 - 1 part RU- reducer
 - Air Brush Application: 1 part Shimrin® base, 1 part RU-reducer
- Stir SG100 prior to use, as a separation of ingredients will occur.

NOTE: Use fast drying reducer RU310, or as fast a dry as your conditions allow.

NOTE: Intercoat Clear is a base coat resin system, DO NOT ADD CATALYST. See tech sheet for more information on reducers.

NOTE: Maximum recommended over reduction is 1 part SG100 to 1 part reducer. This ratio is always used when Kandy Koncentrates are mixed with SG100.



5. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP 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



6. APPLYING SG100 INTERCOAT CLEAR

Apply 1 or 2 medium coats of SG100 Intercoat Clear after the last coat of SHIMRIN® base has flashed dull, with 50% spray pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats and approximately 1 hour before taping (tape time will vary with weather and shop conditions). In many instances SG100 may be taped in less than 30 minutes. Always allow flash time between coats.

SG100 FLASH TEST - SG100 WILL DRY TO A SEMI-GLOSS AND FEEL DRY TO THE TOUCH.

NOTE: DO NOT APPLY MORE THAN 4 COATS OF SG100. It is not designed for hi-build.

NOTE: If 12 hours of dry time has elapsed, scuff Intercoat Clear (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR SG100**) to insure proper adhesion of topcoats. Do artwork with a minimum of tape contact and remove quickly for topcoats. Although we have let hours elapse on many jobs without a problem, common sense tells us that topcoats will merge better if the base is somewhat less than dry.



7. TOUCH UP & BLENDS

SG100 Intercoat Clear may also be used to blend SHIMRIN® Pearl and Metallic Base Coats. Apply 1 medium coat of SG100 beyond the blend point. Metallics will not darken as they normally would at the blend.



7. TOUCH UP & BLENDS (continued)

Then simply topcoat with any of our Kosmic Kolor® clears.

NOTE: SG100 may also be added to SHIMRIN® Bases for undetectable blends on touch ups.

8. KANDYS

SG100 Intercoat Clear may also be used to make low solid Kandys by mixing any of our Kandy Koncentrates with SG100. Excellent when many Kandy tape outs are required under urethane topcoats. Perfect for small parts or graphics when speed is a factor. This method is actually faster than lacquer.

See tech sheet for more information on using Kandy Koncentrates.

9. PEARLS

Although SG100 may be used to make Pearls, It is recommended the use of SG150 Intercoat Pearl & Flake Karrier for this application (**please refer to the tech page on SG150 Intercoat Pearl and Flake Karrier**). Double the amount of reducer in the SG100 for Pearls. Mix 1 part SG100 to 1 part reducer.

When using dry pearl, begin with 1/2 teaspoon lots of dry pearl until desired concentration is achieved per mixed quart.

When using pearl paste, begin with 1/4 teaspoon lots of pearl paste until desired concentration is achieved per mixed quart.

These mixtures are designed as starting points for light colored bases. Darker bases may require much less pearl, depending on the effect required.

NOTE: Do not add too much pearl as clouding, mottling, streaking and bunching from too much pearl can occur. Pearl platelets must have room to sparkle. Overcrowding reduces their effect and increases the chance of mottling and streaking.

As with Kandys, use a 75% spray pattern overlap. Do not apply more than 4 coats. **See tech sheet for more information on the use of pearl concentrates.**



10. DRY TIME

Allow dry time before Kandy or clear is applied (usually about 15 to 60 minutes and not longer than 12 hours). If 12 hours of dry time has elapsed, scuff Intercoat Clear (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR SG100**) to insure proper adhesion of topcoats. **SG100 FLASH TEST** - SG100 WILL DRY TO A SEMI-GLOSS AND FEEL DRY TO THE TOUCH. Monitor closely for maximum merging of coats.

NOTE: If SG100 is being used as the carrier for pearls. Do not sand directly as you will darken the pearls. You will need to apply 1 or 2 coats of properly reduced SG100 before sanding.

11. CLEAR COAT

DO NOT USE SG100 AS A TOPCOAT CLEAR. SG100 must be top coated with Kosmic Kolor® UC01, UFC01, UFC19, UFC35, or UC35.



12. CLEAN UP

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