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

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 Surfacers 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.
**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).

<table>
<thead>
<tr>
<th>TO MIX</th>
<th>12 oz</th>
<th>25 oz</th>
<th>35 oz</th>
</tr>
</thead>
<tbody>
<tr>
<td>CANDY PAINT</td>
<td>8 oz</td>
<td>20 oz</td>
<td>28 oz</td>
</tr>
<tr>
<td>ACTIVATOR</td>
<td>2 oz</td>
<td>6 oz</td>
<td>7 oz</td>
</tr>
</tbody>
</table>

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 (chose from the list below depending on the anticipated shop temperature at the time of application).

<table>
<thead>
<tr>
<th>BELOW 70°</th>
<th>70-80°</th>
<th>80-90°</th>
<th>ABOVE 90°</th>
</tr>
</thead>
<tbody>
<tr>
<td>FAST</td>
<td>MEDIUM</td>
<td>SLOW</td>
<td>SUPER SLOW</td>
</tr>
<tr>
<td>UA-1600M</td>
<td>UA-1600M</td>
<td>UA-1600S</td>
<td>UA-1600S</td>
</tr>
<tr>
<td>UR-9065</td>
<td>UR-9075</td>
<td>UR-9085</td>
<td>UR-9095</td>
</tr>
<tr>
<td>UR-8065</td>
<td>UR-8075</td>
<td>UR-8085</td>
<td>UR-8095</td>
</tr>
<tr>
<td>LVR-565</td>
<td>LVR-575</td>
<td>LVR-585</td>
<td>LVR-595</td>
</tr>
</tbody>
</table>

**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 motting.

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, 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.

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.
DUST 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.

<table>
<thead>
<tr>
<th>AIR DRY</th>
<th>FORCE DRY (bake 40 min. at 140°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust Free:</td>
<td>15-20 min.</td>
</tr>
<tr>
<td>Tack Free:</td>
<td>1 hour</td>
</tr>
<tr>
<td>Tape:</td>
<td>8 hours</td>
</tr>
<tr>
<td>Polish:</td>
<td>8-12 hours</td>
</tr>
<tr>
<td>Full Cure:</td>
<td>18 hours</td>
</tr>
<tr>
<td>Stripe:</td>
<td>Next Day</td>
</tr>
<tr>
<td>Deliver:</td>
<td>Next Day</td>
</tr>
<tr>
<td>Decal:</td>
<td>48 hours</td>
</tr>
</tbody>
</table>

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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