



GENERAL INFORMATION

Kosmic Urethane Flo-Klear UFC35 is a National Rule and SCAQMD Rule 1151 compliant product. See mixing directions below. UFC35 may be used to topcoat any of our Kosmic Kolor® urethane or polyurethane enamel finishes, or any of our Shimrin® Base Coats. UFC35 is a medium solids Klear that has application properties similar to conventional Klear UFC01. UFC35 features excellent flow out for better D.O.I. (Distinctness of Image), ultra-high gloss, good chemical and water resistance, good abrasion, and stone bruise resistance, is extremely flexible and polishes, and buffs easily.



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 or our KD2000 Direct To Metal 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 grade = 240 to 280 grit)
 - Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - Maroon scuff pad



4. COMPONENTS

- UFC35 Kosmic Urethane Flo-Klear
- RU310 (fast), RU311 (medium), RU312 (slow), RU313 (very slow) urethane reducer, RU300 Exempt Reducer (California only)
- KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush application: Not recommended



5. MIXING UFC35 FLO-KLEAR (MIX ONLY WHEN READY TO SPRAY)

- 2 parts Kosmic Urethane Flo-Klear
- 1 part RU- reducer
- 1 part KU150 Catalyst or KU151 Exempt Hi Temp Flo-Catalyst
- Air Brush Application: Not recommended

For National Rule compliance:

For a 3.5 VOC National Rule compliant Klear, mix 2 parts UFC35 Flo-Klear to 1 part KU150 or KU151 Exempt Catalyst to 1 part Kosmic Reducer. Mix well. Reduce only with Kosmic Reducers. Use a reducer best suited to your shop conditions.

For a 4.2 VOC National Rule compliant Klear, mix 2 parts UFC35 Flo-Klear to 1 part KU100 or KU151 Exempt Catalyst to 1 part Kosmic Reducer. Mix well. Reduce only with Kosmic Reducers. Use a reducer best suited to your shop conditions. **See tech sheet for more information on reducers.**

For SCAQMD Rule 1151 compliance:

For a 0.57 VOC SCAQMD Rule 1151 compliant Klear, mix 2 parts UFC35 Flo-Klear to 1 part KU150 or KU151 Exempt Catalyst to 1 part RU300 Exempt Reducer. Mix well. Must reduce with RU300 to remain at 0.57 VOC.

For a 1.90 VOC SCAQMD Rule 1151 compliant Klear, follow directions above except in place of RU300 use a 70% by volume RU300/ 30% by volume Kosmic Reducer blend. **See tech sheet for more information on reducers.**

NOTE: UFC35 has a pot life of 3 hours at 70°F. Shop conditions can vary pot life.

NOTE: We have designed specific Catalysts to work with each of our clears. Use only the Catalyst specified for the specific Klear you are using. Never use another company's Catalyst in our products.

NOTE: KU150 and KU151 Exempt Catalysts 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
- 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: Not recommended



7. APPLYING UFC35 FLO-KLEAR

First coat should be a medium wet coat with gun close. Apply 2-3 wet coats with 50% pattern overlap. Gun distance while spraying should be approximately 6 inches. Allow flash time between coats.

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.

NOTE: Waiting too long between coats can cause re-coat problems. If excessive dry time has elapsed and clear coat feels dry to the touch, allow 24 hours before sanding and re-coating to avoid lifting problems.

NOTE: Over spray from any catalyzed topcoat material such as UFC35 may lift when basecoats are applied. Mask carefully to prevent this over spray when painting door jambs, etc. If basecoats are applied over UFC35, a 24-hour dry time at 70°F is required, then wet sand (**PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR URETHANE CLEARS**). Use Fast Reducer, allow Flash between coats to prevent lifting.



8. DRY TIME

- Air dry at 70°F = 24 hours
- Force dry at 140°F = 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 UFC35 mixed at 2-1-1.5 (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 or KU151 Exempt Hi Temp Flo-Catalyst per mixed quart of clear.

UFC35 KOSMIC URETHANE FLO-KLEAR (continued)

10. FLOW COATS (optional) (continued)

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. UFC35 polishes easy after cure time.



11. FINISHING AND POLISHING

- In a 70°F 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).



ADDITIONAL INFORMATION

When clear coating UFB04 Jet Set Black: mix equal amounts of UFB04 and UFC35 Kosmic Urethane Flo-Klear, then catalyze with KU150 and reduce as usual, for improved gloss and jetness.

NOTES