

PRIMA™ Acrylic Urethane Primer Surfacer

K36

K36 is a premium quality primer surfacer for today's advanced technology finishes. K36 is a gray, high build, fast drying product that has superior sanding characteristics and excellent gloss holdout. It may also be used as a tintable primer surfacer and as a wet-on-wet sealer. For use as a wet-on-wet sealer see bulletin P-169S.

K36 can be used over sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic substrates. K36 must be mixed with K201 hardener for use as a primer surfacer.



Features

- High Solids
- User Friendly
- Tintable

Advantages

- Easy Drying
- Easy Mixing
- Fills Quickly
- VOC Compliant

Benefits

- Increased Productivity
- Labor Savings
- High Hiding
- Better Leveling
- National Rule Compliant

Compatible Surfaces

K36 may be applied over:

- Properly cleaned and sanded OEM finishes
- Refinish Lacquer (Complete panels only) *
- Properly cleaned, sanded and treated aluminum *
- Properly cleaned, sanded and treated steel *
- Properly cleaned, sanded and treated galvanized steel *
- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded E-Coat
- DF Body Filler cured and sanded
- DPLF Epoxy Primer *
- DPX170 Wash Primer *
- DPX171 Non-Chrome Self Etching Primer *
- DS1002 UV Cured Primer Surfacer *
- DX1791 Self Etching Primer *
- DPX801 Universal Plastics Adhesion Promoter *
- SX/SXA1050 Plastic Adhesion Promoter (Specialty Performance Products) *

* Prime complete panels or extend K36 surfacer application well beyond the first primer (or exposed substrate) and maintain a minimum dry film of 2.0 mils after sanding. Insufficient K36 films may result in lifting on color applications.

Required Products

	Hardener
Primer Surfacer Catalyst	K201
	DT Reducer
Cool, Medium, Warm and Hot Temperature Ranges	DT860, DT870, DT885, DT895 and DT898

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Directions for Use

Surface Preparation:



- Wash the area to be painted with soap and water, then clean with DX330 ACRYLI-CLEAN® Wax and Grease Remover, DX393 0.6 Low VOC Cleaner or DX394 1.4 Low VOC Cleaner.
- Sand the bare metal areas completely with 180 – 240 grit abrasive. Sand old finishes by hand or machine with 320 – 400 grit dry or 600 grit wet.
- Re-clean with DX320, DX330, DX393 or DX394. Final wipe with a clean damp cloth to remove any DX393 or DX394 cleaner residue.
- Steel and aluminum substrates **must** have a two-step metal treatment, wash primer or epoxy primer coating before applying K36.
- Prime aluminum within 8 hours. Prime carbon steel immediately after cleaning.

Mix Ratio:



K36	:	DT Reducer (Optional)	:	K201
5	:	0 – 1	:	1

The use of the product without reducer will increase film builds and sanding times. The addition of reducer is optional. Pot life without reducer is 30 minutes at 70°F (21°C). The reducer addition will increase pot life to 1 hour and improve application and flow characteristics.



		DMD*, DMC Bases or DCC Color	:	DT Reducer	:	K201
K36	:	1	:	1/2	:	1

* DO NOT USE BASECOAT ONLY BASES

Pot life without reducer is 30 minutes at 70°F (21°C).

Pot life with reducer is 1 hour at 70°F (21°C).

Pot life of Flexibilized K36 is 1 hour at 70°F (21°C).

Pot life is shortened as temperatures increase.



Additives:



DX76 Super Accelerator may be added up to 1 oz per RTS QT.

DX84 Enhancer™ Accelerator may be added up to 1 oz per RTS QT.

DX814 Universal Flexibilizer may be added to RTS K36 reduced (5 : 1 : 1) or tinted (2 : 1 : 1/2 : 1). Add 10% DX814 to the Tinted or Reduced RTS K36. *Apply a maximum of 3 coats, to a dry film maximum of 5.0 mils.*

Spraygun Set-up:



Apply:	2 – 4 wet coats
Fluid Tip:	1.4 – 1.6 mm or equivalent
Air Pressure:	10 PSI at the cap for HVLV 40 – 50 PSI at gun for conventional guns

Directions for Use

Dry Times:



Between Coats: 10 – 15 minutes

Dry to Sand: 4 hours at 70°F (21°C) without reduction
1 – 2 hours 70°F (21°C) tinted or reduced



Purge Time: 10 minutes 70°F (21°C)

Force Dry: 30 minutes at 140°F (60°C)
Force dry only tinted or reduced K36



IR (Infrared): 20 minutes for Medium Wave
10 minutes for Short Wave

Compatible Topcoats:

DPLF Epoxy Primer
DPU35 *DURETHANE*® Primer/ Hardener
DPW1840 Low VOC Sealer
DPW1847 Waterborne Primer Surfacer (as a sealer)
DX54 *ROADGUARD*® Chip Resistant Coating
K36 *PRIMA*™ Acrylic Urethane Wet-on-Wet Sealer
K93 Tintable Primer (as a sealer)
NCS2000 Series Sealers
NCS1990 Compliant Wet-On-Wet Sealer
CONCEPT® (DCC) Acrylic Urethane
CONCEPT® LV (CLV) Acrylic Urethane Color
DELSTAR®/*DELTHANE*® (DAR/DXR80) Polyurethane Acrylic Enamel
DELTRON® 2000 (DBC) Basecoat*
DELTRON® (DBU) Universal Basecoat
SX1056 Flexible 2K Sealer (Specialty Performance Products)

*K36 MUST be sealed before applying DBC Black

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc. should be cleaned thoroughly after each use with DX590 All Purpose Clean-up Solvent, or DTL DURACRYL® Lacquer Thinners.

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Technical Data:

	K36 (5 : 1 : 1)	K 36 (5 : 1)	K 36 (2 : 1 : 1/2 : 1)
VOC (PKG) per U.S. Gal	4.12	4.12	4.12
VOC (RTS) per U.S. Gal	4.63	4.22	4.62
Total Solids by Weight (RTS)	57.8%	63.5%	52.4%*
Total Solids by Volume (RTS)	34.3%	40.0%	34.6%*
Sq. Ft. Coverage/ US Gal. (RTS) (1 mil 100% transfer efficiency)	550	640	555*
Recommended wet film build per coat	4.0 mils	4.0 mils	4.0 mils
Recommended dry film build per coat	1.5 – 2.0 mils	1.7 – 2.25 mils	1.5 – 2.0 mils

*These are typical values. Depending on the tint chosen, the calculated values can vary.

Important:

The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (304) 843-1300; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.



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