KP2CF CHROMATE FREE KWIKURE EPOXY PRIMER

GENERAL INFORMATION
KP2CF is a hi-solids, activated, Chromate Free Epoxy Sandable Primer. KP2CF primer may be applied to the existing OEM finish, bare steel, aluminum, fiberglass, and galvanized surfaces. Its tenacious adhesion, hi-build, excellent durability, water and corrosion resistance, and ease of sanding make it a logical choice for the basis of a long lasting paint job. KP2CF Epoxy Primer:
- resists cracking for years and years
- cures for sanding and finishing in 12-24 hours at 70°F
- prevents plastic filler staining or bleed through
- will not stain, shrink, or swell from sand scratches

1. SUBSTRATE
- OEM finish
- Body fillers
- Bare steel
- Bare aluminum
- Bare fiberglass
- Galvanized surfaces

2. PREPARATION
Read "TECH PREP" thoroughly before you begin painting. Surface to be primed should be free of wax, grease, rust, etc. Clean with KC10 prior to sanding.
Do not apply KP2CF over uncatalyzed primers. KP2CF may be applied over properly prepared OEM factory primers and finishes, but for maximum adhesion and corrosion protection it is best to apply KP2CF directly to the bare substrate. Ko-Seal® II may be applied over properly prepared previously painted surfaces. See Ko-Seal® II Tech Sheet for application information.
NOTE: PLEASE REFER TO SANDING GRIT RECOMMENDATIONS FOR BARE METAL AND OLD FINISH SANDING.
NOTE: DO NOT USE ANY ACID BASE PRODUCTS SUCH AS SELF ETCHING PRIMER, ETC UNDER THE KP2CF PRIMER. THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.
NOTE: IF YOU FIND IT NECESSARY TO USE A METAL CONDITIONER TO REMOVE RUST, ETC., BE SURE TO THROUGHLY CLEAN AND NEUTRALIZE THE TREATED AREA FOLLOWING THE CONDITIONER MANUFACTURER'S RECOMMENDATIONS, USING OUR KC20 POST SANDING CLEANER WITH A MAROON SQUEEZE PAD TO INSURE ALL ACID RESIDUE HAS BEEN REMOVED BEFORE PRIMING. IF NOT, THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.

3. SANDING
Striping the old finish
- Minimum 80 grit DA sandpaper
Bare metal
- Minimum 80 grit DA sandpaper
Body fillers
- Minimum 40 grit UNDER the areas being filled
- 80 grit over the body filler
OEM Finish
- 80 to 180 grit DA Sandpaper

4. COMPONENTS
- KP2CF part A (Yellow Primer)
- KP2CF part B (Blue Activator)
- RU310 Fast or RU311 (Medium) Reducer

5. MIXING KP2CF EPOXY PRIMER
- 1 part KP2CF (Yellow)
- 1 part KP2CF (Blue)
- Up to 10% RU Reducer (optional)

KP2CF Epoxy Primer is a two part system. Aggressively mix KP2CF Part A Primer and KP2CF Part B Activator thoroughly before mixing the two parts together. Add up to 10% RU reducer for improved sprayability and flow. A 10% reduction will give approximately 1 mil dry film thickness per coat. Always measure, do not guess. Stir mixed components well to ensure a thorough cure, use a paint shaker for best results. No incubation time is needed. Pot life is 3 hours at 70°F. Shop conditions can vary pot life.

6. GUN SET UP
- Conventional Gun = 45 to 55 PSI
- H.V.L.P. Gun = 10 PSI at the cap
  (Refer to spray gun manufacturer’s recommendations)
- Needle/Nozzle = 1.5 to 1.8
  (Depending on the size of object being painted)
- Trigger Pull = Full
- Air Brush = Not Recommended

NOTE: Most gun manufacturers make inexpensive primer guns that can be dedicated for primer surferc use only.

7. APPLYING KP2CF EPOXY PRIMER
Shall mixed primer into gun. Apply 2:3 wet coats with 50% pattern overlap. Apply 2 extra coats over body work. Allow flash time between coats (flashes dry). KP2CF FLASH TEST - Allow Primer to dry until before next coat is applied. Typically 5-10 minutes.

NOTE: KP2CF PREVENTS BLEED THROUGH OF STAINS IF MILLLAGE IS 2 MILS AFTER SANDING. APPROXIMATE BUILD IS 1 MIL PER COAT WITH 10% REDUCTION USING A PRIMER GUN.

8. GUIDE COAT
Prior to sanding, apply a Guide Coat. During the sanding process, the contrasting color of the guide coat will remain in pits and scratches and become a guide telling you how much sanding is required to smooth the KP2CF. Retrieve the guide coat and a few more sanding strokes and move on. Be careful so you don't expose any body filler. If the primer is less than 2 mils after sanding, bleed through of filler is possible.

9. SANDING
- Initial Block Sanding (optional, see info below)
- 100 to 150 grit dry sandpaper
- Finish Sanding
- Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
- Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
- Tigh Areas (door jambs, etc.) = Maroon squeegee
- Block sand wet or dry. IF BODY FILLER IS EXPOSED, RE-PRIME WITH KP2CF TO PREVENT STAINING. May dry sand KP2CF with 100 or 150 grit, then re-prime with 2 or 3 more coats of KP2CF. KP2CF may also be wet sanded. Then simply seal coat with our Ko-Seal® II and apply topcoats.

NOTE: Do not use alkali or synthetic sealers or primers with House of Kolor® products as lifting may occur.

10. DRY TIME
Allow dry time. We recommend 12-24 hours before sanding and finishing when 3 coats of KP2CF is used at 70°F. Longer dry times are needed if more than 3 coats are applied. KP2CF may also be forced dry at 140°F for 45 minutes for faster sanding. After finish sanding, the vehicle is ready for Ko-Seal® II, followed by base coats and topcoats.

11. CLEAN UP
Clean equipment thoroughly with lacquer thinner or urethane reducer (check local regulations).
NOTE: KP2CF has toxicous adhesion and is highly recommended the needle and fluid tip be removed and thoroughly cleaned. This will assure the gun will work properly when used the next time.