



GENERAL INFORMATION

The KD3000 Series is a hybrid epoxy, two-component primer system, designed to be used as Direct to Substrate (DTS) high or medium build surfacer and sealer. Available in 6 colors, this primer series can be intermixed to produce a wide range of colors. The KD3000 Series has excellent adhesion, corrosion resistance, durability, productive dry times, and ease of sanding. The KD3000 Series DTS Surfacer/Sealers have high build capabilities and may be applied to the existing OEM finishes, bare steel, aluminum, fiberglass, galvanized surfaces, and various plastics.



SUBSTRATE

Properly Prepared

- Original finish
- Ferrous and non-ferrous metals
- Fiberglass and composites
- Plastics (pre-test adhesion and compatibility)
- Body fillers



SANDING THE SUBSTRATE

Bare Metal

- Minimum 80P-grit DA sandpaper

Body Fillers

- Minimum 80P

OEM Finish

- 320P dry or 500 wet

Final Sand

- Allow proper solvent flash between each coat to ensure proper build.
- Final sand with sealer 320p-360p dry or 400 wet
- Final sand without sealer 500-600 wet



COMPONENTS

KD SERIES PRIMER SURFACER / SEALER		HARDENER
KD3000 GRAY	KD3003 YELLOW	KDA3000
KD3001 BLACK	KD3004 RED	
KD3002 WHITE	KD3005 BLUE	
LV SERIES REDUCER	RU SERIES REDUCER	
RU300	RU310	RU313
RU301	RU311	RU315
	RU312	

Note: HOK1052015 Color Check Panel is a must have color tool. This innovative spray-out panel consists of 62 KD3000 Series DTS color variations. Color styling has never been faster. Simply apply basecoats over the panel to achieve an instant library of colors and effects.



PREPARATION

The surface to be primed should be free of wax, grease, rust, etc. **IMPORTANT:** Clean with KC10 prior to sanding. Do not apply KD3000 Series DTS Surfacer/Sealers over uncatalyzed primers. KD3000 Series DTS Surfacer/Sealers may be applied over properly prepared OEM factory primers and finishes, but for maximum adhesion and corrosion protection it is best to apply them directly to the properly prepared bare substrate.



GUN SETUP

Refer to spray gun manufacturer's settings for fluid tip size & P.S.I. air pressure designed for primer application.



MIXING RATIO

For 2.1 lb/gal (250 g/L) VOC Compliance (Low VOC & National Rule)
(4:1 by volume)

High Build Surfacer

- 4 parts KD3000 Series DTS Surfacer/Sealer
- 1 part KDA3000 DTS Hardener

For 4.6 lb/gal (550 g/L) VOC Compliance (US National Rule)
(4:1:1 by volume)

Medium Build Surfacer / High Build Sealer

- 4 parts KD3000 Series DTS Surfacer/Sealer
- 1 part KDA3000 DTS Hardener
- 1 part RU310 - 313 Reducers

For 2.1 lb/gal (250 g/L) VOC Compliance (Low VOC)
(4:1:1 by volume)

Medium Build Surfacer / High Build Sealer

- 4 parts KD3000 Series DTS Surfacer/Sealer
- 1 part KDA3000 DTS Hardener
- 1 part RU300 or RU301 Exempt Reducers

For 4.6 lb/gal (550 g/L) VOC Compliance (US National Rule)
(4:1:2 by volume)

Sealer

- 4 parts KD3000 Series DTS Surfacer/Sealer
- 1 part KDA3000 DTS Hardener
- 2 parts RU310 - 313 Reducers

For 2.1 lb/gal (250 g/L) VOC Compliance (Low VOC)
(4:1:2 by volume)

Sealer

- 4 parts KD3000 Series DTS Surfacer/Sealer
- 1 part KDA3000 DTS Hardener
- 2 parts RU300 or RU301 Exempt Reducers

Notes:

- Reducer selection should be based on the size of the area to be painted, air movement, and temperature. For example, match the Reducer for the booth conditions. mix the KD3000 Series primers thoroughly before activating or reducing. Use a paint shaker for best results.
- Thoroughly stir your ready-to-spray mixture to ensure optimal coatings performance. Do not exceed high build recommendations.



APPLICATION

Used as a High Build/Medium Build Surfacer

Strain mixture. Apply 2 to 3 full wet coats with a 50% pattern overlap. Apply an additional 2 full wet coats over polyester fillers and spot and glazing putties. Allow flash time between coats (flashes dull approx. 10 to 15 minutes).

Used as a Sealer

Strain mixture. Apply 1 to 2 medium wet coats with a 50% pattern overlap. Allow flash time between coats (flashes dull, approx. 5 to 15 minutes).

Note: All spot and glazing putties must be catalyzed products.



DRY TIME

Used as a High Build /Medium Build Surfacers

At 70°F, allow to cure approx. 90-120 minutes before sanding. If you exceed more than 3 coats, the cure time may be longer. For higher production you can bake the surfacer at 140°F for 30 minutes. Allow the surfacer to flash 15 minutes prior to baking with a 30-minute cool-down prior to sanding. Overnight dry time is best.

Used as a Sealer

Sealers are designed to create a chemical bond between the surfacer and the base coat. Allow the sealer to dry 15-30 min. but not to exceed 4 hours prior to top coating. Thoroughly sand sealed surfaces with 500 to 600 wet sand paper if top coating window extends more than 4 hours.

NOTE: Flash and Dry Times will be longer in cool temperatures, slow air movement or when applied in heavier coats.



FINISH SANDING

Used as a High Build /Medium Build Surfacers

- Initial Block Sanding
- 100P to 150P 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)
- Tight Areas (door jams, etc.) = Maroon scuff pad (Sand paper preferred if possible)

NOTES:

- To prevent bleeding or discoloration of base coats caused by body fillers, at least 2 mils of primer must remain after sanding. (1 coat equals approximately 1 mil when sprayed with production equipment using 4:1 mixing ratio).
- If body filler is exposed, re-prime with KD3000 to prevent staining.
- You may dry-sand KD3000 with 100 or 150 grit, then re-prime with 2 or 3 more coats of KD3000. KD3000 may also be wet sanded.



TECHNICAL DATA

FOR USA (National Rule & Low VOC) / Canada

RTS Regulatory Data	4 : 1		4 : 1 : 1		4 : 1 : 1		4 : 1 : 2		4 : 1 : 2	
	No Reduction		RU310-313 Series Reducers		RU300 & 301 LV Series Reducers		RU310-313 Series Reducers		RU300 & 301 LV Series Reducers	
	LBS/GAL	g/L	LBS/GAL	g/L	LBS/GAL	g/L	LBS/GAL	g/L	LBS/GAL	g/L
Actual VOC	1.3 Max.	158 Max.	3.2 Max.	380 Max.	1.1 Max.	133 Max.	3.4 Max.	407 Max.	0.95 Max.	115 Max.
Regulatory VOC (less water & exempt solvents)	2.1 Max.	250 Max.	4.6 Max.	550 Max.	2.1 Max.	250 Max.	4.6 Max.	550 Max.	2.1 Max.	250 Max.
Density	11-13	1320-1560	11-13	1320-1560	11-13	1320-1560	11-13	1320-1560	11-13	1320-1560
	Weight %	Volume %	Weight %	Volume %	Weight %	Volume %	Weight %	Volume %	Weight %	Volume %
Total Solids Content	57-61	42-46	50-54	35-39	50-54	35-39	46-50	30-34	42-46	30-34
Total Volatile Content	39-43	54-58	46-50	61-65	46-50	61-65	50-54	66-70	54-58	66-70
Water	0	0	0	0	0	0	0	0	0	0
Exempt Compound Content	30-34	37-41	27-31	31-35	40-44	47-51	24-29	26-30	47-51	54-58
Category	Primer Surfacers / Sealers									

NOTE: US/Canadian Regulations allow for the use of exempt compounds for VOC calculations.

FOR REST-OF-WORLD

RTS Regulatory Data	4 : 1		4 : 1 : 1		4 : 1 : 2	
	No Reduction		RU310-313 Series Reducers		RU310-313 Series Reducers	
	LBS/GAL	g/L	LBS/GAL	g/L	LBS/GAL	g/L
VOC	5.6 Max.	675 Max.	6.5 Max.	780 Max.	7.0 Max.	840 Max.
Density	11-13	1320-1560	11-13	1320-1560	11-13	1320-1560
	Weight %	Volume %	Weight %	Volume %	Weight %	Volume %
Total Solids Content	57-61	42-46	50-54	35-39	46-50	30-34
Total Volatile Content	39-43	54-58	46-50	61-65	50-54	66-70
Water	0	0	0	0	0	0
Category	Primer Surfacers / Sealers					

NOTE: ROW considered areas outside US/Canada.



TIPS AND TRICKS

- Apply a light contrasting primer guide coat over primed bodywork prior to blocking of the surface to identify high / low spots and pinholes in body filler.
- Do not use any acid-based products, such as self-etching primers, under KD3000 Series. This may affect adhesion properties.
- KD3000 Series is designed to prevent staining problems as long as the fillers / putties are mixed and applied properly.
- Non-catalyzed putties are never recommended for use with KD3000 series.
- A dedicated primer gun with gun nozzle needle set up 1.7 is recommended.
- Disassembly of entire gun is advised after use.
- Let KD fully dull before re-coat, to avoid any possibility of cracking.