



GENERAL INFORMATION

KD2000 Direct to Metal Epoxy Primer was formulated with a hybrid of epoxy and acrylic polymers, which provide excellent adhesion, good corrosion resistance, productive dry times, and ease of sanding. These primers emit very low amounts of Volatile Organic Compounds (VOCs), Hazardous Air Polluting Solvents (HAPS), and contain no isocyanates.

KD2000 may be applied to the existing OEM finish, bare steel, aluminum, fiberglass, and galvanized surfaces. Its tenacious adhesion, hi-build, excellent durability, and water and corrosion resistance make it a logical choice for the basis of a long lasting paint job. KD2000 Epoxy Primer:

- resists cracking for years and years
- cures for sanding and finishing in 3 hours at 70°F.
- prevents plastic filler staining or bleed through
- will not stain, shrink, or swell from sand scratches

KD2000 Direct to Metal Epoxy Primer is the first step to a great long lasting custom finish.



1. SUBSTRATE

- OEM finish
- Body fillers
- Bare steel
- Bare aluminum
- Bare fiberglass
- Galvanized surfaces



2. PREPARATION

Read "TECH PREP" thoroughly before you begin painting. Prepare vehicle using normal methods for acrylic lacquer or urethane. Surface to be primed should be free of wax, grease, rust, etc. Clean with KC10 prior to sanding. Do not apply KD2000 over uncatalyzed primers. KD2000 may be applied over properly prepared OEM factory primers and finishes, but for maximum adhesion and corrosion protection it is best to apply KD2000 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 KD2000 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 THOROUGHLY CLEAN AND NEUTRALIZE THE TREATED AREA FOLLOWING THE CONDITIONER MANUFACTURERS RECOMMENDATIONS, THEN USING OUR KC20 POST SANDING CLEANER WITH A MAROON SCUFF 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 80P grit DA sandpaper



Bare metal

- Minimum 80P grit DA sandpaper

Body fillers

- Minimum 40P grit UNDER the areas being filled
- 80P grit over the body filler

OEM Finish

- 80P to 180P grit DA Sandpaper



4. COMPONENTS

- KD2000 (Primer)
- KDA2000 (Activator)
- RU310 (Fast), RU311 (Medium) Reducer, or RU300 Exempt Reducer



5. MIXING KD2000 EPOXY PRIMER

- 4 part KD2000 (Primer)
- 1 part KDA2000 (Activator)
- Up to 10% RU Reducer (optional)

KD2000 Epoxy Primer is a two part system. Aggressively mix KD2000 Primer thoroughly before mixing the two parts together. Add up to 10% RU reducer for improved sprayability and flow out. 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 2-3 hours at 70°F. Shop conditions can vary pot life.



6. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP 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



7. APPLYING KD2000 EPOXY PRIMER

Strain 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 dull).

KD2000 FLASH TEST - - Allow Primer to dry dull before next coat is applied. Usually 5-10 minutes.

NOTE: KD2000 PREVENTS BLEED THROUGH OF STAINS IF MILLAGE IS 2 MILS AFTER SANDING OR ABOVE. 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 KD2000. Remove 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)
 - 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



Block sand wet or dry. IF BODY FILLER IS EXPOSED, RE-PRIME WITH KD2000 TO PREVENT STAINING. May dry sand KD2000 with 100 or 150 grit, then re-prime with 2 or 3 more coats of KD2000. KD2000 may also be wet sanded. Then simply seal coat with our Ko-Seal® II and apply topcoats.

PLEASE REFER TO SANDING GRIT RECOMMENDATIONS (PAGE 59).

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

NOTE: 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 10% reduction).



10. DRY TIME

Allow dry time. We recommend 3-6 hours before sanding and finishing when 3 coats of KD2000 is used at 70°F. Longer dry times are needed if more than 3 coats are applied. KD2000 may also be force dried at 140°F for 45 minutes for faster sanding. After finish sanding, the vehicle is now 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).