DELTRON®

P-169S

PRIMA™ Acrylic Urethane Wet-on-Wet Sealer

K36

K36 is a premium quality primer sealer for today's advanced technology finishes. K36 is a fast drying sealer that has superior flow properties and excellent gloss holdout. It may also be used as a primer surfacer or a tintable primer surfacer. For use as a primer surfacer refer to bulletin P-169P.

K36 can be used over sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic substrates. K36 must be tinted with, DCC, DMD, DMC tint bases or DCU2021 before adding DCX8 or DCX61 hardener, when applying as a wet-on-wet sealer.



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 Wet-on-Wet Sealer may be applied over:

- Properly cleaned, sanded and treated aluminum*
- Properly cleaned and sanded fiberglass
- Properly cleaned, sanded and treated steel*
- Properly cleaned E-Coat
- Properly cleaned, sanded and treated galvanized steel*
- Properly cleaned and sanded OEM finishes (Except Lacquer)
- DF Body Filler cured and sanded*
- DPLF Epoxy Primer*+
- DPX170 Wash Primer*#
- DPX171 Non-Chrome Self-Etching Primer*#
- DPX801 Universal Plastics Primer*
- DS1002 UV Cured Primer Surfacer*
- DX1791 Wash Primer*
- K36 PRIMA™ Acrylic Urethane Primer Surfacer, cured and sanded
- K38 High Solids Primer Surfacer, cured and sanded
- K93 Tintable Primer Surfacer, cured and sanded
- NCP250 NCT® Primer Surfacer, cured and sanded
- NCP270/271 Corrosion Resistant Primer, cured and sanded
- NCP272 Tintable Corrosion Resistant Primer, cured and sanded
- NCP280 2.1 VOC Primer Surfacer, cured and sanded
- SX1060 Brushable 2K Primer Surfacer (Specialty Performance Products), cured and sanded
- SX/SXA1050 Plastic Adhesion Promoter (Specialty Performance Products)*

* Prime complete panels or extend K36 sealer application well beyond the first primer. Maintain a minimum 1.0 mil dry film build of the K 36 sealer.

To avoid potential lifts over DPX170/171, K36 Sealer must be topcoated within a wet-on-wet time frame (15 – 45 minutes at 70°F) or after a 16-hour dry.

+ Caution: DPLF Primer allowed to dry less than 16 hours before application of K36 may result in lifting upon color application. Use of DP402LF catalyst is strongly recommended if unable to flash DPLF overnight.

Required Products

	Hardener
Primer Surfacer Catalyst	DCX8 and DCX61
	DT Reducer
Cool, Medium, Warm and Hot Temperature Ranges	DT860, DT870, DT885, DT895 and DT898

K36

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	:	DMD*, DMC Bases, DCC Color or DCU2021	:	DT Reducer	:	DCX8/DCX61
4	:	2	:	2	:	1

* DO NOT USE BASECOAT ONLY BASES. The VOC of the base chosen must be 4.6 or less to attain a RTS VOC of 4.6 or less.



Pot life of K36 Sealer 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:



DX814 Universal Flexibilizer may be added to ready-to-spray K36. Add 10% DX814 to the RTS K36 Sealer.

Spraygun Set-up:



Apply:	1 wet coat
Fluid Tip:	1.4 – 1.6 mm or equivalent
Air Pressure:	10 PSI at the cap for HVLP 40 – 50 PSI at gun for conventional guns

Directions for Use

Dry Times:







Dust:	10 minutes 70°F (21°C)
Tack:	20 minutes 70°F (21°C)
Tape:	2 hours 70°F (21°C)
Dry to Topcoat:	15 minutes 70°F (21°C)
Force Dry:	45 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

After 72 hours, K36 Sealer must be scuffed before applying basecoat or topcoat.

Compatible Topcoats:

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*

*K36 must flash a minimum of 2 hours at 70°F (21°C) before DBU application.

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 with DCX8	K 36 with DCX61
VOC (PKG) per U.S. Gal		
VOC (RTS) per U.S. Gal	4.59	4.59
Total Solids by Weight (RTS)	53.4%*	53.9%*
Total Solids by Volume (RTS)	38.2%*	38.1%*
Sq. Ft. Coverage/ US Gal. (RTS) (1 mil 100% transfer efficiency)	612*	611*
Recommended wet film build per coat	3.0 mils	3.0 mils
Recommended dry film build per coat	1.0 – 1.2 mils	1.0– 1.2 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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PPG Industries
19699 Progress Drive
Strongsville, OH 44149

PPG Canada Inc.
1330 Castlefield Avenue
Toronto, Ontario M6B 4B3

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