

COMPLIANT COATING SYSTEM

2K HIGH BUILD ISO-FREE PRIMER



VOC: 250 g/l, 2.1 lb/gal (Combined Components) Meets Air Quality Regulations

2K HIGH BUILD ISO-FREE PRIMER is a high quality, direct to metal chromate and isocyanate free high build primer surfacer that is formulated to provide excellent corrosion resistance and adhesion. When applied over properly prepared steel, galvanized, aluminum and fiberglass, 2K HIGH BUILD ISO-FREE PRIMER is easy to sand and topcoat with all current base coats. It can be used as a sealer and applied wet-on-wet when reduced with a compliant reducer.

ADVANTAGES:

- ▼ Excellent hide and adhesion
- ▼ Corrosion resistant
- ▼ Isocyanate free
- ▼ Chromate free
- ▼ Easy to sand



Product Numbers:

KFP-305 (Part A), KFP-306 (Part B)

DIRECTIONS FOR USE

2K HIGH BUILD ISO-FREE PRIMER must be prepared by mixing 3 parts of part A- KFP-305 base with 1 part of part B -KFP-306 Hardener (by volume). Any mixture of 2K HIGH BUILD ISO-FREE PRIMER A & B will have the hazards of both components. Before opening the packages, READ ALL WARNING LABELS. FOLLOW ALL PRECAUTIONS.

SURFACE PREPARATION

Prior to application, the surface must be dry, clean and free from wax, grease, oil, rust, dirt or any other foreign matter. Use a surface cleaner on unpainted surfaces. Sand and featheredge original finish with 220 or 320 wet or dry sandpaper. Use a metal etching primer over bare metal for optimum adhesion.

MIXING - IMPORTANT

Contents must be mixed thoroughly. Do not mix more material than can be used in one application. No induction time is required.

MIXING RATIO:

- If used as a primer surfacer, mix and spray as follows: 3 parts of Part A - KFP 305 Base to 1 part of Part B - KFP 306 Hardener (by volume).
- If used as a sealer, reduce and spray as follows: 3 parts of Part A-KFP 305 Base to 1 part of Part B - KFP 306 Hardener to 1 part of a compliant reducer (by volume).

POT LIFE

The usable pot life of the mixture is 2 hours at 77°F. The pot life will shorten at higher temperatures.

THINNING

No thinning is required when used as a primer/surfacer. When used as a Sealer, please see MIXING instructions for thinning the catalyzed mixture.

APPLICATION

When used as a primer/surfacer, apply a wet coat with 5 minutes flash off time. Follow with a medium wet coat. Allow 15 minutes between subsequent coats. Do not apply more than 3 medium coats. When used as a sealer, apply 1 wet coat.

SANDING

Depending on temperature, 2K HIGH BUILD ISO-FREE PRIMER can be sanded after 2 hours. For optimum results, dry sand using 320 to 400 grit paper. If wet sanding is preferred, surface must be completely dry prior to applying topcoat.

CLEANING

Equipment should be cleaned immediately after use with KT912 compliant solvent in an enclosed system.

TECHNICAL DATA

Product Number:	KFP-305 (Base), KFP-306 (Hardener)
VOC:	Less than 250 g/l, 2.1 lb/gal
Color:	Gray
Finish:	Flat
Solvent(s):	Ketones, Parachlorobenzotrifluoride, Ester, Xylene, and Alcohol
Flash Point:	1°F/TCC (Base), 60°F/TCC (Hardener)
Solids by Weight:	Primer 74%; Sealer 64%
Solids by Volume:	Primer 55%; Sealer 44%
Theoretical Coverage (Primer):	882 square feet per gallon @ 1 mil DFT
Theoretical Coverage (Sealer):	706 square feet per gallon @ 1 mil DFT
Viscosity (Primer):	16-17" Zahn Cup #2 @ 77°F
Viscosity (Sealer):	13-14" Zahn Cup #2 @ 77°F
Dry-To-Touch:	30 minutes
Recoat time:	2 hours
Shelf Life:	2 years from date of manufacture

NOTE: FOR USE BY PROFESSIONAL, TRAINED PERSONNEL, USING PROPER EQUIPMENT WITH STANDARD SAFETY PROCEDURES. NOT INTENDED FOR SALE TO THE GENERAL PUBLIC. FOR PROFESSIONAL USE ONLY. NOT FOR RESIDENTIAL USE.
REFER TO THE PRODUCT LABEL AND MATERIAL SAFETY DATA SHEET (MSDS) FOR CAUTIONS AND WARNINGS PERTAINING TO THIS PRODUCT.

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