

HOUSE OF KOLOR

TECHNICAL DATA INFORMATION

IMPORTANT NOTE: This document includes information on UC-1 and UFC-1. These products are for sale outside the United States only.

READ ALL INSTRUCTIONS THOROUGHLY BEFORE YOU BEGIN. Our products are for use by trained professional personnel using proper production automotive spray equipment suitable for the paint to be sprayed. Proper spray booth, air system, respirator and basic spray painting ability are required.

We do not recommend painting in temperatures below 70°F.

NOT INTENDED FOR USE BY THE GENERAL PUBLIC.

For controlled results, House of Kolor recommends products be used as a "total system". We do not recommend the intermixing of various manufacturers' products. This is only asking for trouble. No professional or amateur should run the risk of a job failure. Custom painting is complicated enough without gambling on untested product compatibility.

Apply only over House of Kolor primers/sealers and/or properly prepared OEM paint.

Do not apply House of Kolor products over alkyd or synthetic enamels, uncatalyzed acrylic enamel, primers, sealers or topcoats that may be coated with lacquer. You must control every step of the preparation including the products used for a successful paint job. Any unknowns such as existing primer, old paint, etc. can become the weak link in the custom painters' chain.

IMPORTANT: The data in this manual represent typical values obtained by the methods indicated. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. Unless Valspar agrees otherwise in writing, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. Unless Valspar agrees otherwise in writing, Valspar's only obligation for any defect in this product under any warranty that Valspar provides or under any other legal theory will be to replace the defective product, or to refund its purchase price, at Valspar's option.

CAUTIONS

Read Cautions and Warnings on all product can labels!

TECHNICAL DATA

Material Safety Data sheets available upon request.

TECHNICAL ASSISTANCE

(601) 798-4229

PREPARATION

BEFORE YOU BEGIN

READ ALL INSTRUCTIONS THOROUGHLY.

We do not recommend painting in temperatures below 70°F.

GENERAL INFORMATION

Poor preparation can cause future topcoat problems. Sand the original finish well. Use our KP-2CF, or KP-21 catalyzed primers over body work and for build at deep sanded areas.

1. BODY WORK

Prepare vehicle using normal custom painting methods.

- A. Before any sanding, use KC-10 Wax & Grease remover to remove any tar, wax, or grease.
- B. Grind away paint and primer in areas requiring body work.
- C. Always be aware that your hands can transfer body oil, so keep a rag between you and the surface to be primed or painted and avoid touching the vehicle with your bare hand.
- D. Use power tools to get close when sanding filler. Then block sand. Keep the block front to rear, but crossing to prevent flat spots.
- E. Always prime with our KP-2CF, or KP-21 Primers. Allow proper cure time to prevent shrinkage.
- F. Guide coat your primer with Tempo 827 so when you block sand, your sand scratches or low spots are revealed. Final sand the primer with 320- 400 grit sandpaper.

2. PRIMERS

Many bases are susceptible to staining or bleeding from plastic fillers, putties, fiberglass resins and some primers. To prevent staining, strip bare (or to OEM primer) and prime with our KP-2CF Chromate Free Kwikure Epoxy Primer or KP-21 Low VOC Epoxy Primer. ***See tech sheets for more information on KP Primers.***

NOTE: OEM (Original Equipment Manufacturer) coatings work well as a base for your paint job.

3. FOR EXISTING FINISHES

Surface should be free of wax, grease and foreign materials. Use KC-10 Wax & Grease Remover prior to any sanding. For post-sanding, use our KC-20 to remove any sanding residue for final wash.

Sand the surface with 320-400 grit wet or 240-320 grit dry with a D.A. Sander (wet is best), and apply 1-2 coats of KO-Seal II (sealer). Let dry for 1 hour before top coating.

NOTE: Do not re-coat existing paint finishes in excess of 8 mils, as paint failure can result from excessive film build.

KP-21 KWIKURE EPOXY PRIMER SURFACER -SCAQMD Rule 1151 Compliant Primer-

GENERAL INFORMATION

KP-21 is a 2.1 VOC hi-solids catalyzed Epoxy Primer that meets all current air quality regulations. It is a National Rule and SCAQMD Rule 1151 compliant primer.

KP-21 is designed to be the first primer applied to bare steel, aluminum, fiberglass, magnesium and galvanized surfaces. Its tenacious adhesion, hi-build, and excellent durability, water and corrosion resistance makes it a logical choice for the basis of a long lasting paint job.

KP-21 Epoxy Primer:

- resists cracking for years and years
- cures for sanding and finishing in 6 hours
- prevents plastic filler staining or bleed through
- will not stain, shrink or swell from sand scratches
- is proven in frigid, salty winters, and hot humid summers

KP-21 Epoxy Primer is the first step to a great long lasting custom finish.

1. 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. Use an appropriate cleaner such as KC-10 Wax and Grease Remover on steel or aluminum and follow label instructions.

NOTE: Substrate to be primed should be dry sanded with minimum 80 grit sandpaper.

Do not apply KP-21 over old paint or uncatalyzed primers. KP-21 may be applied over sanded OEM factory primers, but for maximum adhesion and corrosion protection it is best to apply KP-21 directly to substrate. Be sure to use 80 grit dry sandpaper when sanding. KO-SEAL II may be applied over properly prepared previously painted surfaces. **See KO-SEAL II tech sheet for application information.**

2. MIXING KP-21 EPOXY PRIMER

KP-21 Epoxy Primer is a two-part system. Aggressively mix KP-21 Base thoroughly before mixing the two parts together. KP-21B Activator is an unpigmented amber colored liquid. Mix (by volume) 2 parts KP-21 Base (Gray) to 1 part KP-21B Activator. Always measure, don't guess.

Stir mixed components well to ensure a thorough cure, use a paint shaker for best results. No incubation time is needed.

May be reduced up to 10% with Urethane Reducer to improve sprayability and flow out. (RU-300 VOC Exempt Reducer must be used to stay at 2.1 VOC.) Stir well to be sure of a thorough blend. Pot life is 3 hours at 70°F. Shop conditions can vary pot life.

3. APPLYING KP-21 EPOXY PRIMER

Strain mixed primer into gun. Apply 2-3 wet coats with 50% pattern overlap. Apply 2 extra coats over body work. With a production gun use approximately 50 psi at the gun, with a HVLP gun, 10 psi at nozzle. Allow flash time between coats.

KP-21 FLASH TEST- Allow Primer to dry dull before FLASH next coat is applied, usually 10 to 15 minutes. Allow to dry a minimum of 6 hours at 70°F to dry or wet sand. Then apply KO-SEAL II and finish coats. **See appropriate tech sheet for products used.**

NOTE: IF MORE THAN 3 COATS ARE APPLIED INCREASE DRY TIME TO AVOID SHRINKING.

NOTE: KP-21 PREVENTS BLEED THROUGH OF STAINS IF MILLAGE IS 2 MILS OR ABOVE.

APPROXIMATE BUILD IS 1 MIL PER COAT.

FOR ADHESION COATS OVER BARE SUBSTRATES AND FOR FAST FILLING OF TOUCH-UPS IN

REPAIR AREAS: Apply 1 medium wet coat, let dry 1 hour and apply KO-SEAL II and finish coats. Can be painted over in 1 hour without sanding using 1 medium wet coat.

IF NOT TOP COATED IN 24 HOURS, SAND PRIMER BEFORE APPLYING TOPCOATS.

**KP-21 KWIKURE
EPOXY PRIMER SURFACER
-SCAQMD Rule 1151 Compliant Primer-
(continued)**

4. FOR FAST FILLING AND TOP COATING OVER BARE SUBSTRATE

Apply one medium wet coat of KP-21 Epoxy Primer to bare metal substrate. Wait one hour and then apply 2 to 3 coats of KO-SEAL II. Allow to dry 2 hours before sanding then apply finish coats. **See KO-SEAL II Tech Sheet for application of KO-SEAL II.**

5. GUIDE COAT

Prior to sanding apply Tempo 827 guide coat. During the sanding process, the contrasting color of the primer will remain in pits and scratches and become a guide telling you how much sanding is required to smooth the KP-21. 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, bleed through of filler is possible.

6. SANDING

Block sand wet or dry. IF BODY FILLER IS EXPOSED, RE-PRIME WITH KP-21 TO PREVENT STAINING. May dry sand KP-21 with 100 or 150 grit no fill sandpaper. Then re-prime with 2 or 3 more coats of KP-21. KP-21 may also be wet sanded. Then simply seal coat with our KO-SEAL II and apply topcoats. FINAL WET SANDPAPER RECOMMENDED IS 320-400 GRIT.

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.)

7. DRY TIME

Allow dry time. We recommend 6 hours before sanding and finishing when 3 coats of KP-21 are used at 70°F. Longer dry times are needed if more than 3 coats are applied. KP-21 may also be force dried at 130°F for 45 minutes for faster sanding. The vehicle is now ready for KO-SEAL II, base coats, and topcoats.