



GENERAL INFORMATION

KD2000 Direct to Metal Epoxy Primer was formulated with a hybrid of epoxy and acrylic polymers, which provide adhesion, corrosion resistance, productive dry times and ease of sanding. These primers emit very low amounts of Volatile Organic Compounds (VOC). KD2000 may be applied to an existing OEM finish, bare steel, aluminum, fiberglass and galvanized surfaces.



SUBSTRATE

Properly Prepared:

- Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel.
- Properly cleaned and sanded fiberglass, SMC, E-coat and OEM finish.
- Properly prepared OEM E-coat.
- Body fillers.



COMPONENTS

DIRECT TO METAL EPOXY PRIMER	HARDENER
KD2000	KDA2000

LV SERIES REDUCER	RU SERIES REDUCER	
RU300	RU310	RU313
RU301	RU311	RU315
	RU312	



PREPARATION

- Wash surface with mild detergent and water
- Rinse and dry surface
- Wipe surface with KC10 Cleaner (aluminum) and wipe dry with clean cloth before product flashes
- Sand and featheredge substrate with P320 grit sandpaper and or body fillers P180 or equivalent
- Clean surface with KC20 Cleaner and wipe dry with clean cloth before product flashes



MIXING RATIO

For 2.1 lb./gal. (250 g/l.) VOC compliance (Low VOC)
(4:1:0-10% by volume)

- 4 parts KD2000 Epoxy Primer
- 1 part KDA2000 activator

Optional: Add up to 10% LV Reducers.

For 4.8 lb./gal. (580 g/l.) VOC compliance (US National Rule)
(4:1:0-10% by volume)

- 4 parts KD2000 Epoxy Primer
- 1 part KDA2000 activator

Optional: Add up to 10% RU Reducers.



POT LIFE

2-3 hours at 77°F (25°C)

Note: Faster reducers will cause the KD2000 to flash quicker.



DRY TIMES

AIR DRY @ 77°F (25°C)	
Flash Time	5-10 Minutes or until finish is dull
To Sand	3-6 Hours
To Topcoat	3-6 Hours
*To Topcoat without sanding	Not Recommended
Force Dry at 140°F	45-60 Minutes



GUN SETUP

Refer to spray gun manufacturer's settings.



TECHNICAL DATA

FOR USA (National Rule & Low VOC) / Canada

RTS Regulatory Data	4 : 1 : 0 -10%		4 : 1 : 0 -10%	
	RU310-313 Series Reducers		LV Exempt Series Reducers	
	LBS/GAL	g/L	LBS/GAL	g/L
Actual VOC	2.1 Max.	255 Max.	1.5 Max.	183 Max.
Regulatory VOC (less water & exempt solvents)	2.8 Max.	340 Max.	2.5 Max.	250 Max.
Density	11-12	1320-1440	11-12	1320-1440
	Weight %	Volume %	Weight %	Volume %
Total Solid Content	60-65	45-50	59-65	45-50
Total Volatile Content	35-40	50-55	35-41	50-55
Water	0	0	0	0
Exempt Compound Content	20-25	25-30	20-30	27-36
Category	Primer Surfacer			

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

FOR REST-OF-WORLD

RTS Regulatory Data	4 : 1 : 0 -10%	
	RU310-313 Series Reducers	
	LBS/GAL	g/L
VOC	4.8 Max.	580 Max.
Density	11-12	1320-1440
	Weight %	Volume %
Total Solid Content	60-65	45-50
Total Volatile Content	35-40	50-55
Water	0	0
Category	Primer Surfacer	

NOTE: Rest-of-World considered areas outside US/ Canada.



TIPS AND TRICKS

- Be sure to let the solvents flash out of the resin before applying additional coats to create high build.