



GENERAL INFORMATION

The first steps in any project are very important to the overall success. The primer or foundation of your House of Kolor paint project is this first step. Our products are engineered to work as a complete system. The solvent and resin systems in House of Kolor are dramatically different from regular aftermarket automotive finishes. Often described as "hotter" our products are designed to be used as a system to virtually eliminate shrinkage. House of Kolor is designed to apply numerous coats or layers to achieve a dramatic finish. This is often described as "Looks a Mile Deep". It is critical not to intermix other manufacturer's products in your paint project. KD3000 is a hybrid epoxy two component primer designed to be used as a DTS or Direct to Substrate High Build High Build Surfacer, Medium Build Surfacer/High Build Sealer, or silky smooth sealer. Available in 6 premixed colors which can be intermixed for a wide range of colors. KD3000 is an industry first and undisputedly the best foundation system available. KD3000 has excellent adhesion, corrosion resistance, productive dry times, and ease of sanding. These DTS surfacer/sealers emit very low amounts of Volatile Organic Compounds (VOCs), Hazardous Air Polluting Solvents (HAPS), and contain no isocyanates. The KD3000 Series DTS surfacer/sealers may be applied to the existing OEM finish, bare steel, aluminum, fiberglass, galvanized surfaces, and various plastics. Its tenacious adhesion, hi-build, excellent durability, and water and corrosion resistance and ease of sanding makes it a superior choice for the basis of a long lasting custom paint job.

KD3000 Series Kustom DTS Foundation Surfacer/Sealer:

- Resists cracking
- Prevents plastic filler staining or bleed through
- Multiple colors greatly improves speed and accuracy of contour sanding when used as a Medium Build Surfacer
- Lay Flat application properties greatly reduce surface prep and consumption of abrasives
- Does not stain, shrink, or swell from sand scratches
- Cures as HB Surfacer for contour sanding in under 2 hours at 70°F
- Cures as Sealer for topcoating in under 30 minutes at 70°F

IMPORTANT NOTES

- DO NOT USE ANY ACID BASE PRODUCTS SUCH AS SELF ETCHING PRIMERS, ETC. UNDER THE KD3000 SERIES DTS SURFACER/SEALERS. THIS WILL ALMOST CERTAINLY CAUSE AN ADHESION PROBLEM.
- 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
- IN CUSTOM PAINTING, IT IS NOT UNCOMMON TO EXPERIENCE POLYESTER STAINING FROM BOTH BODY FILLERS, GLAZING PUTTIES, AND FIBERGLASS RESINS. THE KD3000 SERIES DTS SURFACER/SEALER IS DESIGNED TO PREVENT THIS STAINING PROBLEM AS LONG AS THE FILLERS/PUTTIES ARE MIXED AND APPLIED PROPERLY, AND THE AFTER SANDING MILLAGE REMAINS AT LEAST 2 MILS.



SUBSTRATE

Properly Prepared:

- Original finish
- Ferrous and non-ferrous metals
- Fiberglass and composites
- Plastics (Pre-test adhesion and compatibility)
- Body Fillers
- Miscellaneous unclassified substrates (Pre-test adhesion and compatibility)



PREPARATION

Surface to be primed should be free of wax, grease, rust, etc. IMPORTANT: Clean with KC10 prior to sanding. Do not apply KD3000 Series DTS surfacer/sealers over uncatalyzed primers. KD3000 Series DTS surfacer/sealers may be applied over properly prepared OEM factory primers and finishes, but for maximum adhesion and corrosion protection it is best to apply KD3000 Series DTS surfacer/sealers directly to the bare substrate.



SANDING THE SUBSTRATE

Bare metal

- Minimum 80P grit DA sandpaper



Body fillers

- Minimum 80P

OEM Finish

- 320P dry or 500 wet



COMPONENTS

- HOK1052015 Color Check Panel. A must have color tool. This innovative pray-out panel consists of 62 KD3000 series color variations. Color styling has never been faster. Simply apply basecoats over panel to achieve an instant library of colors and effects.
- KD3000 – Medium Gray
- KD3001 – Black
- KD3002 – White
- KD3003 – Yellow
- KD3004 – Red
- KD3005 – Blue
- KDA3000 – Activator
- RU310 – Fast Reducer 65°F to 75°F
- RU311 – Medium Reducer 75°F to 85°F
- RU312 – Slow Reducer 85°F to 95°F
- RU313 – Very Slow Reducer 95°F to 100+°F
- RU300 - LV Cool Weather Reducer 70°F to 85°F
- RU301 - LV Warm Weather Reducer 85°F to 100+°F



MIXING RATIO (Visit www.housofkolor.com to view formulas and mixing tables)

APPLIED AS A HIGH BUILD (HB) SURFACER

Mix four (4) parts KD3000 Series DTS Surfacers/Sealer to one (1) part KDA3000 Activator. **(4:1 by volume)**



APPLIED AS A MEDIUM BUILD (MB) SURFACER OR HIGH BUILD (HB) SEALER

Mix four (4) parts KD3000 Series DTS Surfacers/Sealer to one (1) part KDA3000 Activator to one (1) part RU Reducer. **(4:1:1 by volume)**

APPLIED AS A SEALER

Mix four (4) parts KD3000 Series DTS Surfacers/Sealer to one (1) part KDA3000 Activator to two (2) parts RU Reducer. **(4:1:2 by volume)**

Note: Cosmic Reducer selection should be based on the size of the area to be painted, air movement, and temperature. For example start and run your spray booth prior to checking temperature. Then match the RU reducer for that temperature. KD3000 Series Kustom DTS Foundation Surfacers/Sealer is a catalyzed two component system. Aggressively mix the KD3000 Series DTS Surfacers/Sealer thoroughly before activating or reducing. Always measure, do not guess. Thoroughly mix components to insure optimal coatings performance; use a paint shaker for best results. No incubation (sweat in) time is required. Shop conditions can vary pot life.



Online
Kwik-Mix

FOR CALIFORNIA 2.1 lbs./gal. (252 g/L)

Reduce with RU300 LV Cool Weather Reducer or RU301 LV Warm Weather Reducer.

POT LIFE

As a Surfacers – 45 to 90 minutes (depending on shop conditions)

As a Sealer – 1 to 2 hours (depending on shop conditions)



GUN SET UP

HVLP Gun

Used as a High Build/Medium Build Surfacers/Sealer = 1.7 to 1.8 tips

Used as a High Build/Medium Build Surfacers = 1.7 to 1.8 tips

Used as a Sealer = 1.3 to 1.5 Needle/Nozzle (Depending on the size of object being painted)

Used as a High Build/Medium Build Surfacers = 100% Trigger Pull

Used as a Sealer = 50% to 75% Trigger Pull

Not Recommended for Air Brush Application



APPLICATION

Used as a High Build/Medium Build Surfacers

Strain mixture. Apply 2 to 3 full wet coats with a 50% pattern overlap. Apply an additional 2 full wet coats over polyester fillers and spot and glazing putties. Allow flash time between coats (flashes dull approx. 10 to 15 minutes).



Used as a Sealer

Strain mixture. Apply 1 to 2 Medium Wet Coats with a 50% pattern overlap. Allow flash time between coats (flashes dull, approx. 5 to 15 minutes).

DRY TIME

Used as a High Build /Medium Build Surfacers

At 70°F, allow to cure approx. 90-120 minutes before sanding. If you exceed more than 3 coats, the cure time may be longer. For higher production you can bake the surfacer at 140°F for 30 minutes. Allow the surfacer to flash 15 minutes prior to baking with a 30 minute cool down prior to sanding. Overnight dry time is best.



Used as a Sealer

Sealers are designed to create a chemical bond between the surfacer and the base coat. Allow the sealer to dry 15-30 min. but not to exceed 4 hours prior to top coating. Thoroughly sand sealed surfaces with 500 to 600 wet sand paper if top coating window extends more than 4 hours.

Note: Flash and Dry Times will be longer in cool temperatures, slow air movement or when applied in heavier coats.

GUIDE COAT

Used as a High Build /Medium Build Surfacers

Multiple color choices of KD3000 series greatly improves speed and accuracy when contour sanding. High and low areas become more visible when using different colors of KD for each coat when used as a High Build or Medium Build surfacer. Prior to sanding, apply a Guide Coat of reduced KD3000 in a contrasting color. During the sanding process, the contrasting color of the guide coat will remain in low areas and become a guide telling you how much sanding is required to smooth the KD3000. Remove the guide coat then continue with 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. Reapply KD3000 to cut through areas.



FINISH SANDING

Used as a High Build /Medium Build Surfacers

- Initial Block Sanding (Optional, see info below)
 - o 100P to 150P grit dry sandpaper
- Finish Sanding
 - o Dry Sandpaper = 280P to 320P grit (CAMI grade = 240 to 280 grit)
 - o Wet Sandpaper = 400 to 500 grit (FEPA grade 600P to 800P grit)
 - o Tight Areas (door jams, etc.) = Maroon scuff pad




FINISH SANDING (Continued)

Block sand wet or dry. IF BODY FILLER IS EXPOSED, RE-PRIME WITH KD3000 TO PREVENT STAINING. May dry sand KD3000 with 100 or 150 grit, then re-prime with 2 or 3 more coats of KD3000. KD3000 may also be wet sanded. Then simply seal coat with the KD3000 mixed as a sealer and apply topcoats. **PLEASE REFER TO SANDING GRIT RECOMMENDATIONS.**

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 4:1 mixing ratio).


CLEAN UP

Clean equipment thoroughly with lacquer thinner, acetone, or urethane reducer (check local regulations).


TECHNICAL DATA

	High Build (4:1) (National Rule)	High Build (4:1) (California Rule) 2.1 lbs./gal. (252 g/L)	Medium Build (4:1:1) (National Rule)	Medium Build (4:1:1) (California Rule) 2.1 lbs./gal. (252 g/L)	Primer Sealer (4:1:2) (National Rule)	Primer Sealer (4:1:2) (California Rule) 2.1 lbs./gal. (252 g/L)
Coatings Category	Primer	Primer	Primer	Primer	Primer Sealer	Primer Sealer
Packaged Density	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)	12.09 lbs./gal. (1451 g/L)
Packaged VOC	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)	2.0 lbs./gal. (240 g/L)
Actual VOC Ready to Spray	1.64 lbs./gal. (197 g/L)	1.64 lbs./gal. (197 g/L)	2.6 lbs./gal. (312 g/L)	1.36 lbs./gal. (163 g/L)	3.28 lbs./gal. (394 g/L)	1.17 lbs./gal. (140 g/L)
Regulatory VOC Ready to Spray less exempt solvents	2.1 lbs./gal. (252 g/L)	2.1 lbs./gal. (252 g/L)	3.18 lbs./gal. (381 g/L)	2.1 lbs./gal. (252 g/L)	3.89 lbs./gal. (467 g/L)	2.1 lbs./gal. (252 g/L)
Total HAPS (g HAPS/L) Packaged	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)	0.42 lbs./gal. (50 g/L)
HAPS Ready to Spray	0.91 lbs./gal. (109 g/L)	0.91 lbs./gal. (109 g/L)	2.86 lbs./gal. (343 g/L)	0.91 lbs./gal. (109 g/L)	4.79 lbs./gal. (575 g/L)	0.91 lbs./gal. (109 g/L)
Total Solids by Volume (Ready to Spray)	41.72%	41.72%	34.77%	34.77%	29.80%	29.80%
Wt % Volatiles (Ready to Spray)	46.09%	46.09%	52.19%	54.18%	57.05%	60.16%
Wt % Exempt Compounds (Ready to Spray)	32%	32%	28.37%	42.19%	25.48%	49.74%
Wt % Water (Ready to Spray)	0%	0%	0%	0%	0%	0%
Viscosity						
#2 Signature Zahn @ 77°F	N/A	N/A	15 to 20 Seconds	15 to 20 Seconds	14 to 18 Seconds	14 to 18 Seconds
DIN 4 @ 77°F	25 to 40 Seconds	25 to 40 Seconds	14 to 20 Seconds	14 to 20 Seconds	12 to 16 Seconds	12 to 16 Seconds
Recommended Dry Film Build per Coat	1.3 mils	1.3 mils	1 mil	1 mil	¾ mils	¾ mils
Sq. Ft. Coverage/gal @ 1 mil	669 Sq. Ft.	669 Sq. Ft.	558 Sq. Ft.	558 Sq. Ft.	478 Sq. Ft.	478 Sq. Ft.

HEALTH AND SAFETY

IMPORTANT The contents of this package have to 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.