

**Tintable Primer Surfacer/Sealer**

# K93

K93 is a translucent, premium quality tintable primer for today's advanced technology finishes. K93 is designed to be tinted with DCC color and DMD & DMC tint bases to reach a wide spectrum of colors. It may be used as a tintable primer surfacer and as a wet-on-wet sealer.

K93 can be used over sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic substrates. K93 must be mixed with K201 hardener for use as a primer surfacer. For use as a wet-on-wet sealer it must be mixed with DCX8 or DCX61 hardener.



**Features**

- User Friendly
- High Solids

**Advantages**

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- Fills Quickly
- VOC Compliant
- Quick Dry Time
- Easy Mixing and Sanding

**Benefits**

- Increased Productivity
- National Law Ready
- Labor Saving

**Compatible Surfaces**

**K93 Tintable primer Surfacer/Sealer:**

- Properly cleaned, sanded and treated aluminum\*
- Properly cleaned, sanded and treated steel\*
- Properly cleaned, sanded and treated galvanized steel\*
- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded OEM finishes
- Properly cleaned and sanded OEM and Refinish Lacquer (Surfacer application only / Complete panels only)
- Properly cleaned and sanded E-Coat (Surfacer application)
- Properly cleaned E-Coat (Sealer application only)
- DF Body Fillers cured and sanded\*
- DPLF Epoxy Primer\* +
- DPX170 Wash Primer\* #
- DPX171 Non-Chrome Self Etching Primer\* #
- DPX801 Universal Plastics Primer\*
- DX1791 Self Etching Primer\*
- SX1060 Brushable 2K Primer Surfacer (Specialty Performance Products), cured and sanded
- SX/SXA1050 Plastic Adhesion Promoter (Specialty Performance Products)\*

\* Prime complete panels or extend K93 application well beyond the first primer (or exposed substrate) and maintain a dry film of 2.0 mils after sanding or 1.0 mils if applied as a sealer. Insufficient K93 films may result in lifting upon color application.

# To avoid potential lifts over DPX170/171, K93 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 K93 may result in lifting upon color application. Use of DP402LF catalyst is strongly recommended if unable to flash DPLF overnight.

**Required Products**

	<b>Hardeners</b>
Primer Surfacer Catalysts	K201, DCX8 and DCX61
	<b>DT Reducers</b>
Cool, Medium, Warm and Hot Temperature Range	DT860, DT870, DT885, DT895 and DT898



# K93

## Directions for Use

### Surface Preparation:



#### K93 Tintable Primer Surfacer/Sealer

- 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 or aluminum substrates **must** have a two-step metal treatment, wash primer or epoxy primer coating before applying K93.
- Prime aluminum within 8 hours. Prime carbon steel immediately after cleaning.

### Mix Ratios:



#### Tinted Primer Surfacer

DCC Color,			
K93	: DMD* or DMC Bases	: DT Reducer	: K201
4	: 1	: 1	: 1

#### Tinted Primer Sealer

DCC Color,			
K93	: DMD* or DMC Bases	: DT Reducer	: DCX8 or DCX61
4	: 2	: 2	: 1

**\* DO NOT USE WITH 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 K93 is 1 hour at 70°F (21°C).

Pot Life of **Flexibilized K93** is 1 hour 70°F (21°C)

*Pot life is shortened as temperatures increase.*

### Additives:



**DX76 Super Accelerator** or **DX84 Enhancer™ Accelerator** may be added up to 1 oz per RTS QT to tinted primer surfacer **ONLY**.

**DX814 Universal Flexibilizer** may be added to RTS K93, 10% DX814 to RTS K93. *Apply a maximum of 3 coats, to a dry film maximum of 5.0 mils.*

### Spraygun Set-up:



Apply: 2 – 4 wet coats when spraying as a Primer Surfacer  
1 wet coat when spraying as a Primer Sealer

Fluid Tip: 1.4 – 1.6 mm or equivalent

Air Pressure: 10 PSI at the cap for HVLP guns  
40 – 50 PSI at the gun for conventional guns

### Surfacer Dry Times:



Between Coats: 10 – 15 minutes (2 – 4 coats)

Dry to Sand: 2 – 3 hours at 70°F (21°C), without reduction



Purge Time 10 minutes at 70°F (21°C)

Force Dry 30 minutes at 140°F (60°)



IR (Infrared) 20 minutes for Medium wave  
10 minutes for Short wave

## Directions for Use

### Sealer Dry Times:



Between Coats:	N/A (1 coat)
Dust:	10 minutes
Tack:	30 minutes
Tape:	3 hours
Dry to Topcoat	15 minutes at 70°F (21°C)
Force Dry	45 minutes at 140°F (60°)
IR (Infrared)	20 minutes - Medium Wave 10 minutes - Short Wave

After 72 hours, K93 Sealer must be scuffed before applying basecoat or topcoat.

### Compatible Topcoats:

- DPLF Epoxy Primer\*
  - DPW1840 *ENVIROBASE*®, Low VOC Sealer\*
  - DPW1847 Waterborne Primer Surfacer (applied as a sealer)\*
  - DPX801 Universal Plastic Primer\*
  - DX54 *ROADGUARD*® Chip Resistant Coating\*
  - K 36 *PRIMA*™ Wet-on-Wet Sealer\*
  - K 93 Tintable Sealer\*
  - NCS1990 Compliant Wet-on-Wet Sealer\*
  - NCS2000 Series *DELTRON*® Sealer\*
  - CONCEPT*® (DCC) Acrylic Urethane
  - CONCEPT*® LV (CLV) Acrylic Urethane
  - DELTRON*® 2000 (DBC) Basecoat\*\*
  - DELTRON*® (DBU) Universal Basecoat\*
  - DELSTAR*®/*DELTHANE*® Ultra (DAR/DXR80) Polyurethane Acrylic Enamel
- \* Recommended over K93 Surfacer (sanded) only
- \*\* When K93 is used as a surfacer it MUST be sealed before applying Black DBC color

### 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.

### Technical Data:

	<b>K93 (4:1:1:1)</b>	<b>K93 (4:2:2:1)</b>
VOC (PKG) per US Gal	4.10 lbs.	4.10 lbs.
VOC (RTS) per US Gal	4.69 lbs.	4.58 lbs.
Total Solids by Weight (RTS)	54.4%*	53.3%*
Total Solids by Volume (RTS)	34.4%*	35.7%*
Sq. Ft Coverage / US Gal (RTS)	552*	573*
Recommended wet film build per coat	3.0 mils	3.0 mils
Recommended dry film build per coat	1.3 – 1.6 mils	1.0 – 1.2 mils

\* These are typical values. Depending on the tint chosen, the calculated values can vary.

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## Tintable Primer Surfacer/Sealer

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**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.

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**See Material Safety Data Sheet and Labels for additional safety information and handling instructions.**

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EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (304) 843-1300; IN CANADA (514) 645-1320

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