

High Build Primer Surfacer

# K38

K38 is a premium quality 2K primer surfacer for today's advanced technology finishes. K38 is a gray, fast drying product which should be used when higher surfacer film builds are required. K38 offers superior sanding characteristics and excellent gloss holdout. K38 may also be used as a flexiblized primer surfacer. K38 can be used over sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic substrates. K38 must be mixed with K201 hardener.



**Features**

- Fills Quickly
- VOC Compliant

**Advantages**

- Quick Dry Time
- Easy Mixing and Sanding

**Benefits**

- Increases Productivity
- National Law Ready
- Labor Savings

**Compatible Surfaces**

K38 may be applied over:

- Properly cleaned and treated aluminum
- Properly cleaned and treated steel
- Properly cleaned and treated galvanized steel
- Properly cleaned and sanded fiberglass
- Cured and sanded OEM finishes
- Cured and sanded OEM and Refinish Lacquer (**Complete panels only**)
- Properly cleaned and sanded E-Coat
- DF Body Fillers cured and sanded
- DP Epoxy Primer/DP401 or DP402 Epoxy Primer Catalyst\*
- DPLF Epoxy Primer/DP401LF or DP402LF Epoxy Primer Catalyst\*
- DPX170/DPX172 Wash Primer/Catalyst \*
- DPX171/DPX172 Non-Chrome Self Etching Primer/Catalyst\*
- DPX801 Universal Plastics Primer\*
- DX1791/DX1792 Wash Primer/Wash Primer Catalyst\*

\* Prime complete panels or extend K38 application well beyond the first primer and maintain a minimum dry film of 2.0 mils after sanding. Avoid sanding K38 too thin as lifting may occur upon topcoating.

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## Directions for Use

### Surface Preparation:



- 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 80 – 180 grit abrasive. Sand old finishes with 320 – 400 grit dry by hand or machine 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.
- Chemical treatment or the use of a conversion coating will enhance the adhesion and performance properties of the finished system.
- Prime aluminum substrate within 8 hours.  
Prime carbon steel immediately after cleaning.

### Mix Ratio:



**K38** : **K201**  
**4** : **1**



Pot Life is 3/4 – 1 hour at 70°F (21°C).

### Spraygun Set-up:



Apply:	2 – 4 wet coats
Fluid Tip:	1.4 – 1.6 mm or equivalent
Air Pressure:	10 PSI at the cap for HVLP guns 40 – 50 PSI at gun for conventional gun

### Dry Times:



Between Coats:	10 – 15 min. dry between coats
Dry to Sand:	2 – 4 hours at 70°F (21°C) for 3 – 6 mils 12 hours 70°F (21°C) for 6 – 10 mils



Purge Time:	10 minutes 70°F (21°C)
Force Dry:	30 minutes at 140°F (60°C) for 3 – 6 mils 45 minutes at 140°F (60°C) for 6 – 10 mils

### Additives:



**DX76 Super Accelerator** or **DX84 ENHANCER™** may be added up to 1 oz. per RTS QT.

**DX 814 Universal Flexibilizer** may be added to ready to spray K38.

**RTS K38** : **DX814** : **DT Reducer**  
**10** : **1** : **1**

Pot Life of flexibilized K38 is 3/4 – 1 hour at 70°F (21°C).

**Apply a maximum of 2 coats keeping the dry film build below 5 mils**

Sand after 4 hours air dry

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## Directions for Use

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### Compatible Topcoats:

DP Epoxy Primer  
DPLF Epoxy Primer  
DPU35/301 *DURETHANE*® Primer/Hardener  
DPW1840 *ENVIROBASE*® Low VOC Sealer  
DP801 Universal Plastic Primer  
DX54 *ROADGUARD*® Chip Resistant Coating  
K36 *PRIMA*™ Wet-on-Wet Sealer  
K93 Tintable Sealer  
NCS1990 Compliant Wet-On-Wet Sealer  
*CONCEPT*® (DCC) Acrylic Urethane  
*CONCEPT*® LV (CLV) Acrylic Urethane  
*DELSTAR*®/*DELTHANE*® (DAR/DXR80) Polyurethane Acrylic Enamel  
*DELTRON*® (DAU) Acrylic Urethane\*  
*DELTRON*® 2000 (DBC) Basecoat\*  
*DELTRON*® (DBU) Universal Basecoat  
*STARBASE*™ (DSB) Acrylic Enamel Basecoat  
*STARHANE*® (STAR) Polyurethane Enamel

\* K38 MUST be sealed before applying Black DAU color or Black DBC color

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### Technical Data:

Properties	K38 (4:1)
VOC LB/US GAL (Ready to Spray)	4.2
Total Solids by Weight (RTS)	62.5
Total Solids by Volume(RTS)	41.1
Sq. Ft. Coverage/ US Gal. (1 mil 100% transfer efficiency)	659
Recommended mils dry film per coat	2.5

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### Important:

The contents of this package may 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.

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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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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## **PPG Automotive Refinish**

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PPG Industries  
19699 Progress Drive  
Strongsville, OH 44149

PPG Canada Inc.  
1330 Castlefield Avenue  
Toronto, Ontario M6B 4B3