

High Build Primer Surfacer

P-222

K38

K38 is a premium-quality, 2K primer surfacer for today's advanced technology finishes. A gray, fast drying product, K38 should be used when higher surfacer film builds are required and may be used as a flexibilized primer surfacer.

This primer surfacer offers superior sanding characteristics and excellent gloss holdout. It 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 Primer Surfacer Catalyst.



Features & Benefits

- High build
- Quick dry time
- Easy mixing and sanding
- Excellent gloss holdout

Required Products

Hardener

K201 Primer Surfacer Catalyst

Compatible Surfaces

K38 may be applied over:

- Properly prepared and treated bare steel, galvanized steel and aluminum*
- Properly cleaned and sanded gel coated fiberglass
- Properly cleaned and sanded OEM finishes
- Refinish Lacquer (complete panels only)*
- Properly cleaned and sanded E-coat
- DF Body Fillers
- DPLF Epoxy Primer*
- DPLV 2.1 VOC Epoxy Primer
- DELTRON® NXT™ Self Etching Primers*
- Deltron NXT Plastic Adhesion Promoter
- ONECHOICE® Plastic Adhesion Promoters
- OneChoice Etch Primers

* Maintain a minimum dry film of 2.0 mils after sanding. Avoid sanding K38 too thin as lifting may occur upon topcoating.

Surface Preparation



- Wash the area to be painted with soap and water, then clean with appropriate PPG 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.
- Reclean with appropriate PPG cleaner.
- 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: 45 minutes at 70°F (21°C)
Pot life is shortened as temperatures increase.

Additives:



SL814 Universal Flexibilizer
RTS K38 : DX814/SL814 : DT15xx Reducer
10 : 1 : 1



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



SL84 Accelerator: up to 1 oz. per RTS quart.

Sand after 4 hours air dry

Air Pressure & Spray Gun Setup:



HVLP: 8-10 psi at the air cap
Compliant: 29-40 psi at the gun
Gun Setup: 1.3-1.6 mm or equivalent

Note: For best overall results, refer to spray gun manufacturer's recommendations for inlet air pressures.

Application:



Apply: 2-4 wet coats

Dry film build per coat: 2.5 mils

Drying Times:



Between Coats: 10-15 minutes at 70°F (21°C)



Air Dry to Sand:
3-6 mils: 2-4 hours at 70°F (21°C)
6-10 mils: 12 hours at 70°F (21°C)



Force Dry to Sand:
Purge Time: 10 minutes at 70°F (21°C)
3-6 mils: 30 minutes at 140°F (60°C) and cool down
6-10 mils: 45 minutes at 140°F (60°C) and cool down

Note: Bake times are for metal temperature. Additional time should be allowed in the force drying schedule for metal to reach recommended temperature.

Sanding:



Sanding:
Grade Wet: 400-600 grit
Grade Dry Machine: 320-500 grit

Compatible Topcoats:

Deltron NXT Sealers
DPLF Epoxy Primer
DPLV 2.1 VOC Epoxy Primer
OneChoice Sealers
Deltron NXT Basecoat
ENVIROBASE® High Performance Sealers
Envirobase High Performance Basecoat

***Must be sealed before applying black DBC**

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc. should be cleaned thoroughly after each use with any PPG general purpose solvent, lacquer thinner or DT Reducer.

Technical Data:

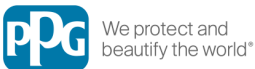
Ready to Use (4:1)
Intended Use: Primer Surfacer
VOC Less Water Less Exempts (RTS): 4.20 lbs./US gal. (503 g/L)
Total Solids by Weight (RTS): 63.5%
Total Solids by Volume (RTS): 42.2%
Sq. Ft. Coverage / US Gallon (RTS): 675 at 1 mil, 100% transfer efficiency

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

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.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

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PPG automotive refinish
19699 Progress Drive
Strongsville, OH 44149
800.647.6050

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
888.310.4762

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www.ppgrefinish.com



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