

Acrylic Urethane Primer Surfacer

P-169P

K36

K36 is a premium quality primer surfacer for today's advanced technology finishes. K36 is a gray, high build, fast drying product that has superior sanding characteristics and excellent gloss holdout. It may also be used as a tintable primer surfacer and a wet-on-wet sealer. For use as a wet-on-wet sealer see bulletin P-169S.

K36 can be used over sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic substrates.



Features & Benefits

- Fills quickly
- Increased productivity
- National Rule compliant
- Tintable

Compatible Surfaces

K36 Primer Surfacer 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[®] Etch Primers*
- *Deltron* Plastic Adhesion Promoter
- ONECHOICE[®] Plastic Adhesion Promoters
- *OneChoice* Etch Primers

*Maintain a minimum dry film of 2.0 mils of K36 after sanding. Insufficient K36 films may result in lifting on color applications.

Required Products

Hardener

K201 Primer Surfacer Catalyst

DT Reducer

DT1565 Fast Thinner (55 to 65°F)

DT1575 Medium Thinner (65 to 77°F)

DT1585 Slow Thinner (77 to 90°F)

DT1595 Very Slow Thinner (95+°F)

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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 180-240 grit abrasive. Sand old finishes by hand or machine with 320-400 grit dry or 600 grit wet.
- Re-clean with appropriate PPG cleaner.
- Steel and aluminum substrates **must** have a two-step metal treatment, etch primer or epoxy primer coating before applying K36
- Prime aluminum within 8 hours.
- Prime carbon steel immediately after cleaning.

Mix Ratio:



K36	:	K201	:	DT15xx Reducer (optional)
5	:	1	:	0-1

The use of the product without reducer will increase film builds and dry to sand.



K36	:	DMD* / DCU2021	:	K201	:	DT15xxReducer
2	:	1	:	1	:	1/2

***DO NOT USE BASECOAT ONLY BASES.** The package VOC of the base chosen must be 4.10 or less to attain a RTS VOC of 4.6 or less. See website VOC As Sold / Detailed Package Charts.



Pot Life: (21°C)	Without Reducer:	30 minutes at 70°F
	With Reducer:	1 hour at 70°F (21°C)
	Flexibilized	1 hour at 70°F (21°C)

Pot life is shortened as temperatures increase.

Additives:



SL84 Accelerator:	up to 1 oz. per RTS quart
SL814 Universal Flexibilizer:	10% per RTS quart

Air Pressure and Spraygun 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 spraygun manufacturer's recommendations for inlet air pressures.

Application:



Apply:	2-4 wet coats		
Dry film build per coat:	(5:1:1) 2.2-2.4 mils	(5:1) 2.4-2.6 mils	(2:1:1:1/2) 1.9-2.1 mils

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Drying Times:



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



Air Dry to Sand: 4 hours at 70°F (21°C) (5:1 mix)
1-2 hours at 70°F (21°C) (5:1:1 or 2:1:1:½ mix)



Force Dry to Sand:
Purge: 10 minutes at 70°F (21°C)
Bake: 30 minutes at 140°F (60°C) and cool down
Force dry only tinted or reduced K36



IR:
Medium Wave: 20 minutes
Short Wave: 10 minutes

Sanding:



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

Note:

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

Compatible Topcoats:



Deltron Sealers
DPLF Epoxy Primer
DPLV 2.1 VOC Epoxy Primer
OneChoice Sealers
*Deltron 2000 (DBC) Basecoat**
ENVIROBASE® High Performance Sealers
Envirobase High Performance Basecoat

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

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc., should be cleaned thoroughly after each use with any appropriate PPG general purpose solvent.

Technical Data:

	K36 : K201	K36 : K201 : DT15xx	K36 : Color : K201 : DT15xx*
Volume Ratio	5 : 1	5 : 1 : 1	2 : 1 : 1 : 0.5
Applicable Use Category	Primer Surfacer	Primer Surfacer	Primer Sealer
VOC Actual (g/L)	484	536	539
VOC Actual (lbs./ gal)	4.04	4.47	4.50
VOC Regulatory (less water, less exempt (g/L)	506	555	551
VOC Regulatory (less water, less exempt (lbs./ US gal.)	4.22	4.63	4.60
Density (g/L)	1413	1331	1201
Density (lbs./ US gal)	11.79	11.11	10.02
Solids vol. %	40.2	34.5	36.2
Solids wt. %	63.5	57.7	53.4
Sq. ft. coverage / US gal. (1 mil. At 100% transfer efficiency)	645	553	580

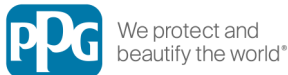
*These are typical values depending on the tint chosen the calculated values can vary. The package VOC of the base color chosen must be 4.10 or less to attain a RTS VOC of 4.6 or less. See website VOC As Sold / Detailed Package Charts.

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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