

# Application of **TK-100™ Gloss**, White or Custom Tint as a Corrosion-Resistant Epoxy Primer Coat to **Commercial Vehicles**

## **SURFACE PREPARATION**

Refer to the **TK-100™ Data Sheet** for general product preparation prior to application.

- 1.) The surface to be primer coated must be completely clean of all contaminants prior to application: including factory release agent, oil, grease, fingerprints, dust, powder, water, rust, scale, etc. Usually, a light solvent wipe-down is sufficient to remove minor oils and dust. Sandblasting may be required to remove rust, scale, or existing paint. Prepare surface as needed for any standard epoxy primer coat.

### *QUALIFIED, PROFESSIONAL APPLICATION RECOMMENDED*

#### **Equipment & materials** required:

- ▶ Wet Film Thickness (WFT) gauge;
- ▶ Conventional or HVLP airgun spray equipment;
- ▶ Proper air delivery system (compressor, reservoir, moisture/oil trap, pressure regulators, etc.);
- ▶ M.E.K. (preferred) or Xylene as thinning solvent;
- ▶ Acetone, Lacquer Thinner, M.E.K., or Toluene as spray equipment cleaning solvent;
- ▶ Isopropyl Alcohol (IPA), Acetone, Lacquer Thinner, M.E.K., or Toluene as surface wipe-down solvent;
- ▶ Proper OSHA protective clothing and activated-charcoal filtered breathing mask;
- ▶ Appropriate contained booth space with filtered air apparatus (if required).

Spray Equipment Selection Guide: Suitable equipment from other manufacturers may be used. Changes in pressure and tip sizes may be needed for proper spray characteristics.

Industrial airgun equipment such as *Binks Model 2001* (Conventional) or *Mach 1* (HVLP), or equal. Separate air & fluid pressure regulators, and moisture & oil trap in main air supply line, recommended. A mechanical pot agitator can be used. Adequate air pressure/volume will ensure proper atomization. Recommended fluid nozzle: .046" to .070" orifice (.055" & .064" most commonly used).

#### **APPLICATION:**

- 1.) Clean equipment and airgun orifices with solvent before use.
- 2.) To thin **TK-100™** for spraying, M.E.K. (or Xylene) is added to stock **TK-100™ Base Compound**, before adding amber-clear **TK-100™ Curing Agent**. Add 6 fluid ounces (5% by weight) per gallon. Stir thoroughly by stick or drill-mounted impeller until uniform, or mix by "box" pouring several times from one 5-gallon pail (or smaller) to another. Additional M.E.K. may added to mixture to thin further, in needed.
- 3.) After thorough mixing, allow **TK-100™** mixture to "dwell" for 30-minutes (aka "induction time"). Stir again just prior pouring into airgun reservoir. Normal pot life is at least 8- to 12-hours at 75°F. Cover remaining **TK-100™** until needed.
- 4.) Spray-apply a single coat of **TK-100™** to approx. 5-mil WFT in even parallel passes, overlapping 50% each pass, and cross spray at right angles, to avoid pinholes and thin areas (aka "holidays").

**TK-100™ Gloss, white or custom tint Primer**  
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(continued)

- 5.) Check wet coating thickness with WFT Gauge until feel for proper WFT is achieved: 6-mil WFT will dry to approx. 5-mil DFT; 5-mil WFT will dry to approx. 4-mil DFT; and 4-mil WFT will dry to approx. 3.5-mil DFT. Overly thick application of **TK-100™** may result in sagging or coating runs.
- 6.) Re-fill airgun reservoir as often as needed to complete job. Any new mixing of **TK-100™** will require same thinning ratio, mixing instruction, and minimum dwell time of 30-minutes prior to application.
- 7.) Immediately clean all spray equipment with Acetone, Lacquer Thinner, M.E.K., or similar epoxy solvent.
- 9.) Allow approx. 8-hours dry time at 77°F before removing tape, stacking, or handling **TK-100™** coated surfaces.
- 10.) A topcoat, such as **KrystalKote™ Custom tint** aliphatic polyurethane, may be directly applied over **TK-100™**:
  - a.) immediately, or within 12-hours of application, without any surface preparation; or
  - b.) after 24-hours, with light sanding (buff pad) to remove gloss (standard prep of primer coating prior to top coat application). For full **KrystalKote™** application instructions, See separate document: "*Application of KrystalKote™ . . . to Commercial Vehicles*".

**TK-100™** and **KrystalKote™** are registered trademark (pending) of:

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