

## **K1000 MIXING, SPRAYING AND BUFFING PROCEDURE:**

1. 5 to 1 of K1000 Basecoat to K1000 Hardener (equals 20% Hardener)
2. 5 to 1 of K1000 Basecoat to K1000 Reducer (equals 20% Reducer)

Adjust spray viscosity with the same K1000 Reducer when ambient working temperatures, spray application and gun air pressure change from recommendations below.

For “spray and go” repairs; Use straight K1000 Reducer as the Finishing Solvent to “burn in” and “wet out” the edges of the overspray edges of the spray job.

Our Hand Glaze works very well to clean the perimeter of the spray area onto the un-sanded acrylic to prevent haze effect or static tension on the surface. This will assist in smooth flow out of the coating onto the edges of the sprayed surfaces were blending the repair spray onto the original gloss.

- Use Hand Glaze as a pre-spray preparation.
- Apply the Hand Glaze like a wax and wipe the surface clean to a smooth glossy luster (film free) and for best spray-out results when blending onto the original gloss surface.
- Use clean t-shirt style material cloths.
- A cloth to apply the product and a clean cloth to hand polish the area to a clean fingerprint-free luster.
- Our Hand Glaze when applied as described can be sprayed directly over with our coatings.
- Always avoid applying the Hand Glaze into the sanded surface rather, an extended surface out and around the filler repair zone.
- With this technique, a tack cloth application is recommended just prior to spraying.
- Spray the K1000 at 45-50 PSI at the gun.

For Spot Repair, be sure a true compressor set up is used that delivers close to 1CFM for Single Action Air Brush and Small touch-up gun use. This means a “compressor motor” with a “reserve tank” set up. (Not a stand-alone motor). Larger spray guns (with pint-quart) size pot will require a 2-3 CFM compressor set-up rating.

For bathtubs, our Fine Grit or Med Grit Texturing additive will create a uniform-Factory look Slip resistant texture to the bottom of the tub when rolled on with our 3” roller and quality roller cover. Use fine line tape to create the perimeter of the edge around the tub at the radius. Sand the surface with 320 grit wet-dry sandpaper.

When applied in a professional manner, this can be a great alternative (time saving) to spray out and potential buffing and polishing work. The key to the best look is good color match and where the line is placed at the radius perimeter.

A smooth texture can be achieved with the right grit selection and grit percentage to the mixture. Start at about 1 percent texturing powder per mixture volume. Test and adjust accordingly to desired roughness and look.

**Allow the sprayed K1000 1–2-hour cure time before buffing and polishing:**

- Optimum cure time at 76-80 degrees 4-5 mils for K1000 as mixed above.
- Heavy flooding of the coating or over reduction can have effect the rate of cure.
- Meaning a 7-10 mil application will cure much slower.
- When applied as heavy coats, allow overnight to polish.

**Optimum buffing speed:** (2000-2500 RPM) with an industrial grade buffing tool, wool pad, and medium grit compound. A Light to Fine grit buffing bar dry compound application is a great alternative in repair settings.