



# XTC PRIMER

## TDS/DIRECTIONS & APPLICATION INFORMATION



XTC Silicone Zinc Primer is a high temperature, corrosion resistant primer formulated from silicone resins and zinc dust.

XTC Primer provides outstanding corrosion protection for metal surfaces operating at temperatures from 500°F (260°C) to 1000°F (538°C), with peaks to 1200°F (649°C).

XTC Primer comes in an aerosol and a two-package system consisting of a base component and zinc that are mixed together before use. XTC and XTC Primer have excellent intercoat adhesion and are able to withstand severe thermal shock throughout the entire temperature range.

To achieve expert results, please take the time to carefully read and understand the following directions before you begin your restoration project. These directions are meant to be general guidelines only and do not cover every application or environmental situation. If you have remaining questions or concerns, please call us toll-free for technical assistance.

**ALWAYS WEAR PROTECTIVE GLOVES AND SAFETY GLASSES.  
ALWAYS WORK IN A WELL-VENTILATED AREA. Please heed all  
warning and caution notices on all KBS products.**

### **SURFACE PREPARATION:**

Surface to be primed must be dry and free from dirt, oils, rust, and other contaminants. Sandblasting is the ideal surface preparation as it leaves the ideal anchor pattern for paint adhesion. After sandblasting, use clean compressed air to blow off any residual blast media. Be sure to wear surgical-type gloves when handling to keep natural body oils off the prepared surface.

If not sandblasting, prepare surface by using wire wheel, wire brushing, or abrasive sanding using 60-80 grit paper. This method will provide a surface equivalent to that provided by sandblasting and allow the desired surface profile or anchor pattern. Wash surface well with KBS Klean at a 10 Parts Hot Water to 1 Part KBS Klean ratio, rinse and let dry thoroughly. Allow surface to **thoroughly dry** before proceeding. Mask off areas not to be coated & protect adjacent areas with drop cloth or newspapers. For best results, apply when XTC and room temperatures are between 60-80° F (16-27° C).

### **APPLICATION GUIDELINES:**

Surface temperature must be at least 5°F (3°C) above dew point.

### **AEROSOL SPRAY APPLICATION:**

For best results, apply when spray can and room temperatures are between 60-80° F (16-27° C). Shake can vigorously for one minute after mixing ball rattles freely & periodically during use to ensure proper mixing and to prevent spray head from clogging. Repeat shaking frequently during use. Hold can 12-15 inches from surface and apply using steady, even strokes. Apply a minimum of two light coats, avoiding drips & runs. Allow 15-30 minutes drying time between coats. Heavy applications can lead to reduced coating life/adhesion. Clean spray head immediately after use by turning can upside down and spraying until no more paint appears. If clogging occurs, remove spray head and clean with a fine wire. Replace carefully, pointing can and spray head away from you. Allow painted surface to dry a minimum of 8 hrs before subjecting to high heat.

**ALWAYS APPLY THIN, COVERING COATS!**

### **MIXING (QUARTS/GALLONS):**

XTC Primer is a two-package system consisting of a base component and zinc that are mixed together before use. Sift zinc dust slowly into base with continuous mechanical agitation. Mix thoroughly until free of lumps. Pour mixture through 30 mesh screen. If a partial unit is needed, mix by weight 10 parts of the Base component with 3 parts Zinc Dust component. Do not open containers until ready to use. Re-disperse any settled-out pigments by stirring with a paint paddle or power mixer to a uniform consistency. Keep lid on container when not in use.

### **APPLICATION EQUIPMENT (QUARTS/GALLONS):**

Conventional spray is the recommended method of application. However, XTC Primer may also be applied by airless spray, brush or roller. Do not apply XTC Primer in heavier films than specified since blistering may occur.

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### **BRUSH (QUARTS/GALLONS):**

Use only wooden-handled brush with short China bristles. Do not use synthetic-bristled brushes. Do not flood surface with coating. Brush out thoroughly, maintaining a continuous wet edge and uniform appearing paint film.

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### **ROLLER (QUARTS/GALLONS):**

Use only wooden-handled roller with phenolic shank and core, and 1/4-3/8" nap. Do not flood surface with coating. Roll out excess coating on a suitable, screened surface. Then roll out thoroughly, maintaining a continuous wet edge and uniform appearing paint film.

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### **THINNING (QUARTS/GALLONS):**

XTC Primer can be thinned up to 5% (20 parts paint/1 part thinner). Only thin using KBS #1 Thinner. Note: Use of other thinners not approved by KBS may hinder product performance and void product guarantee.

### **TEMPERATURE CURING (REQUIRED):**

If you are just applying XTC Primer and not overcoating the XTC Primer with XTC, you will want to do a temperature cure before putting the coated piece back in use.

After proper dry time, coating will be dry to the touch and can be handled using care, but resins will not reach full hardness until heated to approx. 350° F (176° C). For headers or manifolds, this can be done in an oven, BBQ, or by mounting back on engine and run to normal operating temperature.

For automotive applications, you can also temperature cure by installing and running the engine. After the parts have been installed, start the engine and let it idle until the XTC begins to smoke then immediately shut engine off and let the manifold or header completely cool naturally to room temperature. Repeat and do this process three times total. After the third time, perform a fourth temperature cycling and on the fourth cycle, let the engine run until the XTC smokes and this time let the engine continue to run until the smoke from the XTC dissipates. Once the smoke has completely dissipated, turn the engine off let the surface come back to room temperature naturally. It is important to follow this process to gradually cure the XTC.

NOTE: Coating can emit potentially harmful vapors during the first few heat/cool cycles. Allow for full and proper ventilation during initial heat curing. Avoid excessive heat during this initial "break-in" period, as the resins need to be tempered into the substrate to provide proper adhesion.

**ALWAYS APPLY THIN, COVERING COATS!**

### **DRY TIME 70° (21°) 50% RH (QUARTS/GALLONS):**

XTC Primer will air dry tack and thumb print free within 1/2-1 hour. Allow 8 hours dry time between coats. Allow 24 hours dry time prior to shipping and handling if coating is not heat cured. Surfaces coated with XTC Primer in the air dried state can be handled and shipped prior to a heat cure as long as shipping and handling procedures for thin film systems are followed. Avoid mechanical abrasion during shipping and handling. Higher temperatures will reduce tack free, recoat and shipping times. Allow one hour solvent flash off period before heat curing or placing into service. Optimum film properties require a heat cure of 350°F (177°C) for 30 minutes. Equipment protected with the XTC Primer in the air dried state will heat cure when placed into service.

### **CLEANUP:**

Thoroughly flush spray equipment and hoses immediately after use with KBS #1 Thinner or lacquer thinner. Dismantle spray equipment and immediately clean parts, brushes and rollers with KBS #1 Thinner or lacquer thinner.

## STORAGE:

Store in a cool, dry place with temperatures between 50°F and 100°F (10°C and 38°C). Keep container closed when not in use.

## TECHNICAL DATA:

Characteristics	XTC Primer
Generic Type	Silicone Zinc Dust
Color	Dark Grey
Temperature resistance Continuous Intermittent	1000°F (538°C) 1200°F (648°C)
Percent (%) Solids by Volume	33
Dry film thickness per coat	1.5 - 2.0 mils (37 - 50 microns)
Wet film thickness per coat	4.5 - 6.0 mils (112 - 150 microns)
Theoretical coverage	530 mil. sq. ft. (12.65 sq. m./liter @ 25 microns)
Drying time @ 50% RH To Touch To Recoat To Ship	50°F (10°C)    70°F (21°C) 1 hour            30 minutes 12 hours         8 hours 48 hours         24 hours
Full cure @ 350°F (176°C)*	30 minutes
Weight per gallon	12.0 lb. (5.5 kg.)
Flash Point	45°F (7°C)
Pot life	N/A
Shelf life	2 year
Volatile organic compounds	5.76 lb./gal. (690 g./l.)

\*See Dry Time Section

Sprayable VOC's (Using KBS #1 Thinner): <690g/l

Please remember these instructions are general guidelines only and do not cover every application and environment. If you remain unsure as how to proceed, refer to product instruction sheet, our website at KBS-Coatings.com, or please call toll-free for technical advice at 1-219-263-0073.

WARNING: This product contains a chemical known to the State of California to cause cancer and/or birth defects or other reproductive harm. www.P65Warnings.ca.gov

**PLEASE SEE SDS FOR CAUTIONS AND WARNINGS.**

**MADE IN THE USA.**

Information contained herein is to our knowledge true and accurate, but all recommendations or suggestions are made without guarantee. Since application lies outside our control, we cannot accept any liability for the results. User shall determine the suitability of the product for its intended use, and user assumes all risk and liability whatsoever in connection therewith.

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