Product Data Sheet

Keeler & Long/PPG
856 Echo Lake Road
Watertown, CT 06795
1-800-238-8596

PPG High Performance Coatings

Kolormastic™ II Epoxy Coating

Product Information

Product Code:	KLC1013 Beige, KLC1020 Black, KLC1024 Gray, KLC1050 White, and KLC1049B Curing Agent Part B KLC1055 White Base, KLC1060 Neutral Base and KLC1069 Curing Agent Part B for Bases
Product:	Polyamide-Epoxy
Suggested Use:	Use where one coat high build barrier type protection is required for properly prepared metal substrates. Their excellent wetting properties allow application and good performance over tightly adhering rust.
Not Recommended:	Do not topcoat with alkyd-oil coatings.

Product Description

Color:	Beige, Black, Gray and White are available as ready mix colors. A wide variety of colors are available through the use of tinting bases.
Gloss 60°:	Typically 25 to 55
VOC:	1.06 lbs./gal. (127 g/L) *
Method:	Calculated (mixed)
Weight/Gallon:	12.4 ± 0.5 lbs./gal. (mixed) *
In Service Heat Limitations:	250°F (121°C) maximum, dry heat
Flash Point:	Part A 106°F (41°C) Part B 164°F (73°C)
Package:	Available in one and five gallon containers.
Percent Solids by Volume:	84.9 ± 3.0% (mixed) *
Percent Solids by Weight:	91.4 ± 3.0% (mixed) *

Drying Schedule

Air Dry @ 77ºF (25ºC) ASTM D5869

Dry to Touch:	8 hours
Dry to Handle:	16 hours
Dry to Recoat:	24 hours
Accelerated Handle:	9 hours

Application Data

Substrate:	Metal or masonry
Substrate Preparation:	The service life of the coating is directly related to the surface preparation. The surface to be coated must be dimensionally stable, dry, clean and free of contamination. Remove all loose paint, mill scale and rust. Steel Non-Immersion: SSPC-SP2/3 Hand/Power Tool Cleaning minimum. Immersion: SSPC-SP10 (NACE No. 2) Near White Metal Blast Cleaning minimum. Aluminum: Lightly blast to remove contaminants and provide an anchor pattern. If blasting is not performed, the aluminum surface must be pretreated with KL7840A, B, T Wash Primer. An overnight dry is required before applying Kolormastic™ II over KL7840 Wash Primer. Hot Dipped Galvanized Steel: Stabilizers on the surface of the galvanized steel must be removed by either brush blasting or chemical treatment prior to coating to promote adhesion. Concrete: Acid etch or brush blast. Hot rolled steel should be prepared by abrasive blast cleaning whenever possible.
Application Method:	Air Spray: DeVilbiss MBC-510 gun, 704 or 777 air cap with “E” tip and needle or equivalent equipment. Atomization Pressure: 55-70 psi. Airless Spray: Equipment capable of maintaining a minimum of 1500 psi at the tip without surge. 0.017” (0.432 mm) to 0.021” (0.533 mm) orifice. Brush: Use a high quality natural bristle brush. Roller: Use a 3/8” nap polyester-nylon roller cover with a solvent resistant core. Refer to Application Guide APG-8 for additional information.
Parts Base by Volume:	1 Part “A”
Parts Catalyst by Volume:	1 Part "B"

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Application Data (continued)

Thinner Code & Percent:	Thin up to 25% with KLC1225, KLC1275 or KL1200 as needed. For brush or roller application, thin with KLC1275. Do not over thin. Over thinning will result in reduced film build properties.
Digestion Time:	Ready mix products do not require digestion. Bases require 30 minutes at paint temperatures of 77°F (25°C).
Pot Life:	4 hours at 77°F (25°C)
Coverage Sq. Ft./Gal. @ 1 mil:	1362 sq. ft./gal.*
Mixing Instructions:	Mix both components thoroughly before blending. (If KL723 Accelerator is used, add Accelerator to the Part A, mix well prior to adding Part B.) Add Part "B" to Part "A" and blend well using mechanical agitation.
Wet Film Per Coat:	5.9 to 8.2 mils *
Dry Film Per Coat:	5.0 to 7.0 mils
Clean Up:	KLC1225, KLC1275 or KL1200 Thinner.

Additional Information

*Values are calculated for KLC1050 White Part A mixed with KLC1049B Part B. Values will vary with color.

Apply only when air, product and surface temperatures are above 50°F (10°C) and surface temperature is at least 5°F (3°C) above the dew point. Curing is retarded below 60°F (15°C).

Store materials at temperatures between 50ºF (10ºC) and 90ºF (32ºC).

Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available by calling 1-800-238-8596.

These products lose gloss and chalk on exterior exposure, however film integrity is not affected.

Not intended for residential use.

Spray equipment must be handled with due care and in accordance with manufacturer's recommendation.

High-pressure injection of coatings into the skin by airless equipment may cause serious injury, requiring immediate medical attention at a hospital.

WARNING! If you scrape, sand, or remove old paint, you may release lead dust or fumes. LEAD IS TOXIC. EXPOSURE TO LEAD DUST OR FUMES CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a properly fitted NIOSH-approved respirator and prevent skin contact to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the USEPA National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead. In Canada contact a regional Health Canada office. Follow these instructions to control exposure to other hazardous substances that may be released during surface preparation.

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