

Product Data Sheet



PPG High Performance Coatings

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

Kolormastic™ II
KL1800/KL1800B
Aluminum

Product Information

Product Code: KL1800 Aluminum Part A
KL1800B Curing Agent Part B

Product: Epoxy-Polyamine

Suggested Use: A primer/finish recommended for the paint or repaint of most steel surfaces such as structural steel, tanks, bridges and piping.

Not Recommended: Immersion service in strong acids or alkalies.

Product Description

Color: Aluminum

Gloss 60°: 30-50 typically

Weight/Gallon: 13.1 ± 0.5 lbs./gal. (mixed)

In Service Heat Limitations: 200°F (93°C) maximum, dry heat

Flash Point: Part A 100°F (37.7°C)
Part B 200°F (93.3°C)

Package: KL1800 is filled in five gallon container at 4.0 gallons (15.1 liters) or one gallon containers at 0.80 gallon (3.03 liters).
KL1800B is filled in one gallon containers at 1.00 gallon (3.79 liters) or quart containers at 0.20 gallon (0.757 liters).

Percent Solids by Volume: 86.8 ± 3.0% (mixed, calculated)

Percent Solids by Weight: 92.6 ± 3.0% (mixed, applied and air dried)

VOC, Air Dried: 116 g/L (0.97 lbs./gal.) mixed

VOC, EPA 24: 215 g/L (1.79 lbs./gal.) mixed

Drying Schedule

Air Dry @ 77°F (25°C) ASTM D5895

Dry to Touch: 8 hours

Dry to Handle: 16 hours

Drying Schedule (continued)

Dry to Recoat: When dry to handle.

Drying times listed may vary depending on temperature, humidity and air movement.

Application Data

Substrate: Steel

Substrate Preparation: The service life of the coating is directly related to the surface preparation. The surface to be coated must be properly prepared, dry, clean and free of contamination. Remove all loose paint, mill scale and rust.

Topcoats: Steel Non-Immersion: SSPC-SP2/3 Hand/Power Tool Cleaning minimum.
Immersion: SSPC-SP10 Near White Metal Blast Cleaning minimum.

Topcoats: Kolor-Poxy™ Hi-Build Enamels, Kolor-Poxy™ Enamels, Acrythane™ Enamels, Kolorane™ Enamels, Poly-Sil™ Enamels and Anodic Self-Priming Paints

Application Method: Air Spray: DeVilbiss MBC gun, 704 or 765 air cap with "E" or "EX" tip and needle or equivalent equipment. Atomization Pressure: 30-60 psi.

Airless Spray: Equipment capable of maintaining a minimum of 2500 psi at the tip without surge. 0.021" (0.533 mm) to 0.031" (0.787 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: 4 parts KL1800

Parts Catalyst by Volume: 1 part KL1800B

The statement and methods presented in this bulletin are based upon the best available data and practices known to PPG/Keeler & Long at the present time. They are not representations or warranties of performance, results or comprehensiveness of such data. Since PPG/Keeler & Long is constantly improving its coatings and paint formulas, future technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG/Keeler & Long Sales Representative for the most up-to-date information.

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Application Data (continued)

Thinner Code & Percent: Thin up to 25% by volume with KL3700 as needed for application.

Digestion Time: None required

Pot Life: 4 hours at 77°F (25°C)

Coverage Sq. Ft./Gal. @ 1 mil: 1392 sq. ft./gal.

Mixing Instructions: Mechanically agitate KL1800 Part A thoroughly. Add KL1800B Part B to KL1800 Part A. Mix thoroughly.

Wet Film Per Coat: 5.8 to 13.8 mils

Dry Film Per Coat: 5.0 to 12.0 mils

Clean Up Solvent: KL3700

Additional Information

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

Store materials at temperatures between 50 °F (10°C) and 85 °F (29.4 °C).

Permissible substrate temperature during application is 50°F (10°C) to 120°F (49°C).

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

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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