

Product Data Sheet



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



Kolor-Poxy™
Fast Dry Primer
KLC3250 Series

Product Information

Product Code: KLC3250 Gray Part A
KLC3255 Buff Part A
KLC3250B Curing Agent Part B

Product: Polyamide-Epoxy

Suggested Use: Use where an inhibitive, fast drying epoxy primer is needed for properly prepared metal surfaces. This product can also be used as a high build intermediate over zincs and other primers.

Not Recommended: Immersion service.

Product Description

Color: Gray and Buff

Gloss 60°: Flat

VOC: 2.80 lbs./gal. (336 g/L)

Method: Calculated (mixed)

Weight/Gallon: 12.6 ± 0.5 lbs./gal. (mixed)

In Service Heat: 250°F (121°C) maximum, dry heat

Limitations:

Flash Point: Part A 55°F (12.7°C)
Part B 62°F (16.7°C)

Package: Available in full filled one and five gallon containers.

Percent Solids by Volume: 61.0 ± 2.0% (mixed)

Percent Solids by Weight: 77.7 ± 2.0% (mixed)

Drying Schedule

Air Dry @ 77°F (25°C) ASTM D5869

Dry to Touch: 30 minutes

Dry to Handle: 2 hours

Dry to Recoat: 2 hours

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

Application Data

Substrate: Metal

Substrate Preparation: The service life of the coating is directly related to the surface preparation. The surface to be coated must be dry, clean and free of contamination including dust, dirt, oil, grease, rust mill scale, stabilizers and loose paint.

Recommended surface preparation for metal substrates is SSPC-SP6 (NACE No. 3) Commercial Blast Cleaning. The minimum surface preparation is SSPC-SP2/SP3 Hand Tool or Power Tool Cleaning.

Application Method: Air Spray: DeVilbiss MBC-510 gun, 777 air cap with "E" tip and needle or equivalent equipment. A 64 air cap may be used to reduce dry spray on larger parts. Atomization Pressure: 30-60 psi.

Airless Spray: Equipment capable of maintaining a minimum of 2000 psi at the tip without surge. 0.013" (0.330 mm) to 0.017" (0.432 mm) orifice.

Brush and roller application not recommended.

Refer to Application Guide APG-3 for additional information.

Parts Base by Volume: 1 part "A"

Parts Catalyst by Volume: 1 part "B"

Thinner Code & Percent: Not required.

Digestion Time: 30 minutes at paint temperatures of 70°F (21°C) or more before using.

Pot Life: 8 hours at 77°F (25°C)

Coverage Sq. Ft./Gal.: 978 sq. ft./gal.

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.



PPG High Performance Coatings

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Application Data (continued)

Mixing Information: Mix both components thoroughly before blending. Add Part "B" to Part "A" and blend well using mechanical agitation.

Wet Film Per Coat: 6.6 to 9.8 mils

Dry Film Per Coat: 4.0 to 6.0 mils

Clean Up: KLC1225 or KL1200 Thinner.

Additional Information

Apply only when air, product and surface temperatures are above 40°F (4.4°C) and the surface temperature is at least 5°F (3°C) above the dew point.

Store materials at temperatures between 70°F (21°C) and 85°F (29°C).

Permissible substrate temperature during application is 40°F (4.4°C) to 100°F (38°C).

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

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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