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
Inhibitive Red Oxide Primer
KLC2174/KLC2180

Product Information

Product Code:	KLC2174 and KLC2180
Product:	Polyamide-Epoxy modified to cure down to 32°F (0°C).
Suggested Use:	Use where one coat high build barrier type protection is required for properly prepared metal substrates. May be applied over tightly adherent rust or over blasted surfaces.
Not Recommended:	Immersion Service. Do not topcoat with alkyd-oil coatings.

Product Description

Color:	Red Oxide
Gloss 60°:	Semi-gloss
VOC:	2.27 lbs./gal. (272 g/L)
Method:	Calculated (mixed)
Weight/Gallon:	11.2 ± 0.5 lbs./gal. (mixed)
In Service Heat Limitations:	250ºF (121ºC) maximum, dry heat
Flash Point:	Part A 62°F (16.7°C) Part B 80°F (26.7°C)
Package:	Available in full filled one and five gallon containers
Percent Solids by Volume:	69.1 ± 3.0% (mixed)
Percent Solids by Weight:	79.7 ± 3.0% (mixed)

Drying Schedule

ASTM D5869	32°F (0°C)	77°F (25°C)	100°F (38°C)
Dry to Touch:	16 hours	3 - 4 hours	
Dry to Handle:	3 days	7 - 8 hours	2 - 3 hours
Dry to Recoat:	When dry to handle**	3 hours minimum**	3 hours minimum**

**When recoating or topcoating, the dry time of the total system will be extended compared to the dry time of a single coat. Additional care must be taken not to exceed the recommended film thickness of primer or topcoat. Dry times will vary depending on temperature, humidity, air movement and film thickness.

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 properly prepared, dry, clean and free of contamination. Steel Non-Immersion: SSPC-SSP2/3 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 Wash Primer. Hot Dipped Galvanized Steel: Stabilizers on the surface of galvanized steel must be removed by brush blasting or chemical treatment prior to coating. Concrete: Acid etch or brush blast. Hot rolled steel should be prepared by abrasive blast cleaning whenever possible.
Application Method:	Air Spray: DeVilbiss MBC gun, 704 or 777 air cap with “E” or “EX” 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:	Thinning is not normally required. Over thinning will result in reduced film build properties. Thin up to 10% with KL1200 in cool weather or KLC1275 in warm weather as needed.
Digestion Time:	15 minutes at paint temperatures of 77°F (25°C).
Pot Life:	3 hours at 77°F (25°C)
Coverage Sq. Ft/Gal.:	1108 sq. ft./gal.*
Mixing Instructions:	Mix both components thoroughly before blending. Add Part "B" to Part "A" and blend well using mechanical agitation.
Wet Film Per Coat:	7.2 to 10.1 mils *
Dry Film Per Coat:	5.0 to 7.0 mils
Clean Up:	KL1200, KLC1225 or KLC1275 Thinner.

Additional Information

Apply only when air, product and surface temperatures are above 32°F (0°C) and surface temperature is at least 5°F (3°C) above the dew point and no frost or ice is present of the substrate. These products may be applied to damp surfaces. When excessive dampness is observed, the surface appears to shine from moisture or there is standing water. Do not apply under these conditions.

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

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

Not intended for residential use.

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.