Product Data Sheet

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

PPG High Performance Coatings

Amine Cured Coal Tar Epoxy Coating KLCT600/KLCT600B

Product Information

Product Code:	KLCT600 Black Part A KLCT600B Curing Agent Part B
Product:	Amine cured coal tar epoxy coating
Suggested Use:	Heavy industrial coating system for immersion and environmental resistance to: fresh and salt water, many organic and inorganic acids, inorganic bases and salts, crude oils, petroleum and petro-chemical products, oil brines, sewage water, hydrogen sulfide liquors and fumes.

Product Description

Color:	Black
Gloss 60°:	Medium to low gloss depending upon cure conditions.
VOC:	2.2 lbs./gal. (264 g/L)
Method:	Calculated (mixed)
Weight/Gallon:	10.9 ± 0.3 lbs./gal. (mixed)
In Service Heat Limitations:	Dry Heat: 400°F (204°C) maximum. Immersion: 150°F (66°C) maximum.
Flash Point:	KLCT600 84 °F (29 °C) KLCT600B 92 °F (33 °C)
Package:	KLCT600 is filled at 4.75 gallons (17.9 liters) in a five-gallon container. KLCT600B is filled at 0.25 gallon (946 ml) in a quart container.
Percent Solids by Volume:	69.4 ± 2.0% (mixed)
Percent Solids by Weight:	79.8 ± 2.0% (mixed)

Drying Schedule

Air Dry @ 77 °F (25°C) ASTM D5895

Dry to Touch:	2 to 4 hours
Dry to Handle:	6 to 8 hours
Dry to Recoat:	Overnight Must be recoated within 48 hours or adhesion problems may result. If not recoated within 48 hours, sweep blasting in necessary to gain adhesion.
Immersion:	7 days
	Drying times listed may vary depending on temperature, humidity and air movement.

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, properly prepared, dry, clean and free of contamination. SSPC-SP6 (NACE #3) Commercial Blast is minimum for environmental exposures. SSPC-SP10 (NACE #2) Near White Metal Blast is minimum for immersion service.
Application Method:	Air or airless spray. May be brushed, after reduction, on small areas of metal. Reduce and brush as first coat on concrete. To secure proper film build and prevent pinholing during hot weather, apply thin successive coats to exterior surfaces. Air Spray: DeVilbiss MBC gun with 704 or 777 air cap with “D” or “E” tip and needle or equivalent. Atomizing pressure: 55-70 psi. Airless Spray: Equipment capable of maintaining a minimum of 3000 psi at the tip without surge. 0.017” (0.432 mm) to 0.025” (0.635 mm) orifice. Brush: Use an inexpensive fiber bristle brush and discard after use.
Parts Base by Volume:	19 parts KLCT600 Part A
Parts Catalyst by Volume:	1 part KLCT600B Part B
Thinner Code & Percent:	Thin only where permitted by local VOC regulations. For air or airless spray, thin up to 10% with KLC1225. For brushing, thin up to 50% with KLC1225, for prime coat on concrete.
Digestion Time:	30 minutes
Pot Life:	4 hours at 77 °F (25°C). The pot life decreases at elevated temperatures and increases at lower temperatures.
Wet Film Per Coat:	9.6 to 11.2 mils (thinned 10%)
Dry Film Per Coat:	6.0 to 7.0 mils
Coverage Sq. Ft./Gal. @ 1 mil:	1114 sq. ft./gal.
Clean Up Solvent:	KLC1225

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Application Data (continued)

1. Thoroughly agitate KLCT600 Part A with a mechanical mixer. Add KLCT600B Part B to Part A and mix thoroughly with a mechanical mixer. Allow to digest 30 minutes before use.
2. Do not attempt to apply enough material with a single spray pass to deliver the required 6-7 mils dry per coat. This is especially true for exterior applications on vertical surfaces exposed to direct sunlight during the hot summer months or in tropical climates. The aromatic solvents in this coal tar coating begin to vaporize at 80°F (27°C), and at higher temperatures they will form gas, increasing the probability of pin-holes, blisters and craters in the dry film. Under such conditions, apply a normal wet film of 4 to 5 mils and allow several minutes for the solvent to flash off before making a return pass to complete the wet film build necessary for 6 to 7 dry mils per coat. For the coal tar epoxy coatings to be effective they must be applied as a paint system and the minimum dry film for the coal tar epoxy portion of the system is 12 mils.
3. When necessary to apply coal tar epoxies in production areas where process dust contaminate the surface, always clean the surface before application.
4. The shelf life of KLCT600 Part A is limited to 8 months for interior storage at normal temperatures. When storing the material at job site, it should be protected from excessive heat.
5. When applying KLCT600/KLCT600B to an old masonry or concrete substrate that has been exposed to acid or alkali, make sure the sandblast operation removes the contaminates on the surface. After thorough washing, the neutrality of the surface should be verified before proceeding. Additional blasting will be required if the surface is not neutral in pH. When a neutral surface is obtained, allow it to dry and vacuum clean before applying the bond coat of KLCT600/KLCT600B. New concrete and masonry surfaces that are acid etched to remove laitance, etc., should be flushed with copious amounts of water. The neutral pH of the surface should be verified to insure that adequate flushing has been performed. After the surface has completely dried, it must be vacuumed clean before applying KLCT600/KLCT600B. In some instances, a portion of the concrete must be removed before painting is done. The surface must be clean, dry and solid before coal tar epoxy coating is applied. Voids in the surface should be filled with and epoxy-cement grout or epoxy caulking compound.

   CAUTION: Some new concrete may have a surface coating applied or certain additives that speed up the cure and harden the surface. This material MUST BE REMOVED from the surface before painting. Acid etching or sandblasting is recommended before coating.
5. When it is necessary to apply KLCT600/KLCT600B to small areas by brushing, use an inexpensive fiber brush and discard it after use.
6. When using airless equipment to apply KLCT600/KLCT600B, the pump must be of a type that will deliver a constant 3000 psi without surge for proper atomization.
7. Do not apply KLCT600/KLCT600B over surfaces with dew or moisture condensation on them or when the surface temperature is less than 5°F (3°C) above the dew point.
8. Brush application of the bond coat on concrete is recommended. The KLCT600/KLCT600B used for this operation is prepared by thinning the mixed material up to 50% with KLC1225 Epoxy Thinner. Apply as a full continuous coating, making sure the surface is completely covered.
9. When applying KLCT600/KLCT600B to exterior surfaces exposed to direct sunlight during hot weather, the recoat time for proper interfilm adhesion is greatly reduced. The black color holds the heat and hastens the final cure. Recoat under such conditions within 24 hours for this amine cured product.
10. Coal Tar Epoxy Coating systems for immersion service should cure completely before they are put in service. Under normal conditions the time required is seven days. Hot air or infrared heat may be used to hasten the cure. Heating at 200°F (93°C) to 250°F (121°C) for 4 to 8 hours is required to completely cure the coal tar epoxy coating within a 24-hour period. This heat may only be applied to remove the last traces of solvent. It may be applied after the coating is dry to handle to shorten the cure time require prior to immersion service.
11. If KLCT600/KLCT600B is allowed to cure for longer than 48 hours, brush blasting must be performed prior to application of the second coat.
12. Coatings containing coal tar will exhibit bleeding when any attempt is made to topcoat them with products containing aromatic or oxygenated solvents.

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Additional Information

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.

Store materials at temperatures between 50°F (10°C) and 90ºF (32.2ºC).

Permissible substrate temperature during application is 50ºF (10ºC) at 100ºF (38ºC).

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.