Product Data Sheet

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

PPG High Performance Coatings

Polyamide-Epoxy Coal Tar Coating KLCT400/KLCT400B

Product Information

Product Code:	KLCT400/KLCT400B
Product:	Polyamide-epoxy coal tar 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°:	High gloss initially. Chalks rapidly without adversely affecting coating performance.
VOC (g/l):	235
Method:	Calculated (mixed)
Weight/Gallon:	10.1 +/- 0.3 lbs./gal. (mixed)
In Service Heat Limitations:	Dry Heat: 325°F (162°C) maximum Immersion Service: 180°F (82°C) maximum
Flash Point:	KLCT400 90°F (32°C) KLCT400B 65°F (18.3°C)
Package:	KLCT400 ones and fives KLCT400B quarts and ones
Percent Solids by Volume:	72.2 +/- 2.0% (mixed)
Percent Solids by Weight:	80.5 +/- 2.0% (mixed)

Drying Schedule

Air Dry @ 77? F ASTM D5895

Dry to Touch:	2 hours
Dry to Handle:	4 to 6 hours
Dry to Recoat:	Overnight, in hot weather. For exterior exposures in bright sunlight, recoat within 3 days.
Additional Information:	**Do not use for potable water.** Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available by calling 1-800-238-8596.

Application Data

Substrate:	Metal or masonry
Substrate Preparation:	Immersion service: SSPC-SP10 (NACE #2) Near White Metal Blast required. Non-immersion service: SSPC-SP6 (NACE #3) Commercial Blast minimum.
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: High quality natural bristle brush.
Parts Base by Volume:	4 parts KLCT400 Part A
Parts Catalyst by Volume:	1 part KLCT400B Part B
Thinner Code & Percent:	Thin only when permitted by local VOC regulations. For air spray, thin 10% with KLC1225 or KL3700. For brushing, thin up to 45% with KLC1225 or KL3700, for prime coat on concrete.
Digestion Time:	30 minutes
Pot Life:	8 to 10 hours at 77°F (25°C)
Wet Film Per Coat (mils):	8.3-9.7
Dry Film Per Coat (mils):	6.0-7.0
Coverage Sq. Ft./Gal.:	1158
Clean Up:	KLC1225 or KL3700

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Application Notes:

1. Thoroughly agitate KLCT400 Part A with a mechanical mixer. Add KLCT400B 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 four or five 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 coat 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 KLCT400 Component 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 KLCT400/KLCT400B 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. Neutralize the surface, wash thoroughly and vacuum clean before applying the bond coat of KLCT400/KLCT400B.

   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.

   New concrete and masonry surfaces that are acid etched to remove form oils, etc., should be flushed clean with water and allowed to dry and vacuum cleaned before applying KLCT400/KLCT400B.

   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.
6. When it is necessary to apply KLCT400/KLCT400B to small areas by brushing, use an inexpensive fiber brush and discard it after use.
7. When using airless equipment to apply KLCT400/KLCT400B, the pump must be of a type that will deliver a constant 3000 psi without surge for proper atomization.
8. Do not apply KLCT400/KLCT400B over surfaces with dew or moisture condensation on them or when the relative humidity and ambient temperatures are near the dew point, which might cause moisture to form.
9. Brush application of the bond coat on concrete is recommended. The KLCT400/KLCT400B used for this operation is prepared by thinning the mixed material 45% with KLC1225 or KL3700 Epoxy Thinner. Apply as a full continuous coating, making sure the surface is completely covered.
10. When applying KLCT400/KLCT400B 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 3 days; otherwise, scuff sanding is required prior to coating.
11. 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. Adequate flash time must be allowed before heat is applied to the coal tar epoxy film or blistering will result.

Shelf Life: Eight months, inside storage, at temperatures of 77°F (25°C).

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