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KLASS KOTE – EPOXY PRIMER DATA SHEET

PRODUCT NAME **KLASS KOTE – PRIMERS AVAILABLE IN: GRAY #50, WHITE #55, BLACK #52 & YELLOW #58**

DESCRIPTION **KLASS KOTE EPOXY PRIMERS** are high solids, catalyzed primers with excellent filling capabilities. They have been extensively field tested since 1964. Colors include **GRAY PRIMER #50, WHITE PRIMER #55, YELLOW PRIMER #58, & BLACK PRIMER #52**. All **KLASS KOTE EPOXY PRIMERS** contain Zinc Phosphate as the anti-corrosive agent. On the American Society for Testing and Materials (ASTM) B-117 test for rust creepage on steel panels, all **KLASS KOTE EPOXY PRIMERS** rated 9 or 10 on a scale of 0-10. (0-worst, 10-best), **making them very effective in preventing rust on primed surfaces.**

KLASS KOTE EPOXY PRIMERS are designed to be the first primer applied to bare substrates. They are high-build, rust-inhibiting, penetrating, filling primers - all with excellent sanding attributes. They can be sprayed, brushed or rolled-applied. **GRAY PRIMER #50, WHITE #55, & YELLOW #58,** can all be catalyzed with either **KLASS KOTE PRIMER CATALYST #415** - for regular drying speeds - or **PRIMER CATALYST FAST #420** for applications where quick drying times are important. **BLACK PRIMER #52** can **only** be catalyzed with **PRIMER CATALYST BLACK FAST #422**, and dries "fast" as outlined in the cure schedule section of this document.

BASIC USES Highly adhesive, rust inhibiting, protective, sealer, and sandable primer. Applicable on most surfaces, including wood, metal, cement, aluminum, fiberglass, glass, balsa, fabric, concrete, porcelain, cast-iron, etc. (Do not use sandpaper with silicon in it)

PHYSICAL DATA

PART-A EPOXY PRIMERS:	<u>SOLIDS BY WEIGHT:</u>	60.10% - 60.20%
	<u>SOLIDS BY VOLUME:</u>	40.33% - 41.89%
PART-B PRIMER CATALYSTS:	<u>SOLIDS BY WEIGHT:</u>	59.92% - 61.08%
	<u>SOLIDS BY VOLUME:</u>	39.34% - 41.28%

SURFACE PREPARATION The surface **must be clean** and free from dirt, dust, grease, rust, wax, and scale, or anything else that will otherwise impede adhesion. Whenever possible, lightly solvent wash the surface to be coated with **KLASS KOTE EPOXY REDUCER #500**. If **EPOXY REDUCER #500** is not available, use a high-grade lacquer thinner. For rusted, heavily scaled or previously painted surfaces, sanding to bare surface or media blasting is recommended. If this is not practical, use other conventional methods such as sanding to remove scale and old paints and primers - as much as possible.

APPLICATION **KLASS KOTE EPOXY PRIMERS** work ideally with conventional air-atomizing spray equipment, as well as HVLP and airless equipment. They can also be brush or roll-applied. Use natural-bristle brushes and mohair-blend rollers. Once the components are mixed and reduced, **KLASS KOTE** covers like most conventional primers. For best results while using conventional spray equipment **SIDE-A EPOXY PRIMERS COMBINED WITH SIDE-B CATALYST COMPONENT #415** should be inducted (allowed to stand after mixing) for a minimum of 30 minutes (with occasional stirring) **prior to reduction or application**. When using either **PRIMER CATALYST FAST #420, OR PRIMER CATALYST BLACK FAST #422 - NO INDUCTION PERIOD IS NECESSARY. JUST MIX THOROUGHLY AND APPLY.** Film thickness should be built up by applying successive thin coats of primer and allowing about 20 minutes (at 70°F) of "flash off" time between coats.

For electrostatic application, the use of a polar solvent such as PPG DTL 16 or Klean-Strip L-27, may be required.

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MIXING INSTRUCTIONS

Thoroughly mix equal parts by volume of components A & B. If using **PRIMER CATALYST #415** allow **mixture to inducted/react for a minimum of 30 minutes**, with occasional stirring prior to thinning and application. Mix equal parts of epoxy part-A and catalyst part-B components together first -- before reducing the mixture. The amount of reducer needed depends upon the ambient room temperature and type of spray equipment or other application being used. Start with about 15-20% reducer and increase until the application is "flowing" well and the coating self-levels. If **KLASS KOTE EPOXY REDUCER #500** is unavailable, use a high-grade lacquer thinner formulated to reduce epoxy resins. Reduction up to 1-to-1-to-1 (1-part A, 1-part-B, & 1-part Reducer) may be necessary to achieve the proper viscosity (flow), especially when working with smaller guns and air brushes.

APPLICATION TECHNIQUES

A film of the combined components A&B would yield a dry film by volume of $(40.33 + 41.28) / 2 = 40.80$. In other words, a wet film of 3 mils (.003) would yield a dry film of $3 \times .048 = 1.22$ mils. Care must be taken in finish coating over epoxy primers. If film has not cured sufficiently, the catalyst component may migrate into the finish coat producing a cheese like result. **For rush jobs that need to be cured quicker when using catalyst #415, induct parts A&B for 2-3 hours before applying**, or use **PRIMER CATALYSTS #420 & #422, WHERE NO INDUCTION IS NECESSARY**. This will cut the cure rate to approximately 1/2 the documented, normal-speed cure times. Topcoats should be applied **no sooner than 2 hours after last prime coat, and no later than 24 hours**, depending on primer film thickness and shop conditions. After 24 hours (**with #415**) the primer coat must be scuffed prior to top coating. When using **PRIMER CATALYSTS #420 & #422**, top coating can occur in the range of 1 -18 hours – depending on film thickness and shop conditions.

CURE SCHEDULE

For best results, paint and surface should be around 70°F. The applied film and can be force dried after solvent has flashed off. Suggest heats up to 120°F for 15 minutes to speed cure time. Oven, heat guns, and space heaters work best.

At 70°F (air & substrate temperatures) with **PRIMER CATALYST #415**:

TACK FREE TIME: 20 - 30 MINUTES UP TO 1 HOUR

PRINT FREE TIME: 2 - 4 HOURS

PACKAGING TIME: 18 - 24 HOURS

RECOAT/TOP COAT WINDOW: 2 – 24 HOURS - DEPENDING ON FILM THICKNESS

SWARD HARDNESS: 4 DAYS - 1 WEEK – DEPENDING ON TEMP & HUMIDITY

(COMPLETE CHEMICAL CURE) **PRIMER CATALYST #420 & #422 - WILL REDUCE CURE TIMES BY 35-50%:**

COVERAGE

Using conventional air atomizing spray equipment on a non-porous substrate, 1 quart of reduced **KLASS KOTE** primer will cover approximately 50-75 square feet. On more porous substrates, 1 quart will cover approximately 40-50 square feet.

PACKAGING

Available in pint kits (2 x ½ pints), quart kits, (2 x pints), ½ gallon kits, (2 x quarts), 1 gallon kits (2 x ½ gallons, and 2-gallon kits (2 x 1-gallons). All applications require equal parts of epoxy (part-A) and catalyst (part-B). Black #52 and Yellow #58 are available in 1 gallon kit size and larger. For industrial customers, or jobs that require larger quantities, please call customer service, as quantities of 2 x 55-gallon drums or more are available.

AVAILABILITY

Please call us or visit our website **klasskote.com** for details. Some retail outlets are also available.

WARRANTY

The manufacturer warrants that this product conforms to label descriptions, is free from manufacturing defects, and is fit for the ordinary purposes for which such goods are used. Inasmuch as the use of this product by others and other factors affecting product performance are beyond manufactures control, manufacturer does not guarantee the results obtained. Should this product fail to give satisfactory results, manufacturer will replace the product, or at its option, refund the purchase price. This is the sole and exclusive remedy for any failure of this product to perform as warranted and shall also constitute liquidated damages in case of loss. Under no circumstances shall the buyer be entitled to any other remedy or damages. Remedies for incidental and consequential damages are specifically excluded. The seller does not authorize any person or organization to assume for it any other liability in connection with the sale or use of this product unless specifically authorized by manufacturer in writing.