

KELLY-MOORE PAINTS INDUSTRIAL COATINGS HIGH PERFORMANCE SYSTEMS

KM-100

Moisture Cured Urethane Aluminum Primer/Finish

THIS PRODUCT MAY NOT BE AVAILABLE IN SOME AREAS DUE TO VOC REGULATIONS

Contact your Kelly-Moore representative for more information

Product Description

A one component, Moisture Cured Polyurethane Aluminum Coating. Has excellent adhesion to sound, tightly adherent rusty steel, and other marginally prepared surfaces. This low viscosity, high "wetting" coating undergoes a rapid molecular weight change as it polymerizes into a high molecular weight finish which provides excellent corrosion resistance and abrasion resistance. Its resistance to creeping, undercutting, and blistering is superior to epoxy primers. KM-100 is also a barrier primer or tie coat to prevent lifting of strong solvent top coats over conventional coatings, and most chemical coatings.

Performance Features

- **Excellent Corrosion Resistance**
- **Fast Recoating**
- **May be applied at low temperature (>18° F.)**
- **Outstanding Abrasion Resistance**
- **Single Component**

Product Specifications

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| Resin Type | Moisture Cure Polyurethane |
| Color Range | Aluminum |
| Finish | Low Sheen |
| Drying Time (75° F & 50% R.H) | Tack Free: 1-2 hours Recoat: after 2 hours and before 24 hours |
| Practical Coverage | 290-430 Sq. Ft. / Gallon |
| Recommended Dry Film Thickness | 2 - 3 mils per coat |
| Solids By Volume | 54 ±2% |
| Sizes | One Gallon cans |
| Shelf Life | Min. 6 months in unopened containers stored below 90°F. |
| V.O.C. | 356 Grams per liter |
| Thinner | KM-SA-50 |
| Clean Up | Xylene, KM-SA-50 or KM-S-74 |

Surface Preparation

WARNING! If you scrape, sand or remove old paint from any surface, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-approved respirator to control lead exposure. Carefully clean up with a wet mop or HEPA vacuum. Before you start, find out how to protect yourself and your family by contacting the U.S. EPA/Lead Information Hotline at 1-800-424-LEAD (5323) or log on to www.epa.gov/lead.

1. Steel: For best results, sand blast to a SSPC-SP6 "commercial" blast finish. Where blasting is not appropriate, remove all loose rust and mill scale by power wire brushing or hand tool cleaning. A tightly adherent rusty surface is acceptable.

2. Galvanized Steel:

a. New - Brush blast per SSPC-SP7

b. Old, Weathered, or Rusty - Remove all oil, grease, dirt, and other foreign matter. Surface should be clean, dry, and free of contaminants. Remove all loose rust, etc., as outlined above under steel.

3. Previously Painted Surfaces - Remove all loose, peeling, or blistered paint, and any other surface contaminants. Make sure surface is sound and dry. Apply a test patch to insure compatibility.

Mixing Instructions:

KM-100 is made ready for use by stirring so that the aluminum pigment is thoroughly dispersed in the resin and a uniform "silver" color is achieved. When used over a period of time, stir occasionally to maintain uniform mix. Thinning is not usually necessary. If needed, use up to 10% KM-SA-50 Urethane Reducer. Always keep partially used containers tightly sealed to prevent air moisture from reacting with the material and forming a tough skin. Skin can be removed and remaining material used.

Application Procedure

KM-100 may be applied by brush, roll, or spray. Roller cover should have a phenolic core and brushes should be natural bristles. For spray it is important that a moisture/oil trap be used on incoming air, and that fluid lines be flushed first with an anhydrous solvent (water free). Also, flush every 1-2 hours during use to keep lines clean from material build up. Required equipment is as follows:

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KM-100 (cont.)

1. Airless Spray - Use a minimum 20:1 ratio pump with 80-100 psi inbound air. Recommend a .013" - .017" tip. Adjust pressure for proper atomization based on selected tip.

2. Conventional Spray - Use a dual regulated pot with 15-25 psi fluid pressure and 40-50 psi atomization pressure. A Binks #18 with a 704E tip/air cap is recommended.

When spraying, use a 50% overlapping crosshatch pattern to minimize the occurrence of pinholes. Do not apply to surfaces below 18°F or above 140°F. Do not apply over dew or frost. The surface should be dry and at least 5°F above the dew point.

At 75°F and 50% R.H., KM-100 is tack free in 1-2 hours and may be overcoated in 2-4 hours. Always check for finger nail hardness. For maximum adhesion, recoat the same day, but no longer than 16-24 hours at 75°F and 50% R.H. High temperatures and humidity will shorten recoat time. When applying conventional paints (eg Alkyds, Silicone, Enamels and Acrylics) KM-100 must be top coated in the same day. **If KM-100 is rained on or condensation forms on the surface, a sweep blast is recommended before applying a topcoat.**

Note: Always wear protective gloves and clothing while mixing and applying KM-100. Do not get on skin. KM-100 is difficult to remove.

Precautions

KM-100 is flammable. Keep away from all sources of ignition during mixing application and cure. Contains aromatic polyisocyanates. Proper ventilation is necessary when painting indoors or confined areas. Vapors and spray mist may cause eye/skin irritation as well as allergic reactions. Always wear protective clothing, goggles, impervious gloves and use NIOSH approved respirators. For industrial use only. Keep out of reach of children. This product is sold without warranty as to performance expressed or implied. Users are urged to make their own tests to determine the suitability for their particular conditions.

Proper Disposal

For proper disposal of excess material, please contact your local city or county waste management agency.

Limited Warranty: The statements made on this bulletin, product labels or by any of our agents concerning this material are given for information only. They are believed to be true and accurate and are intended to provide a guide to approved construction practices and materials. As workmanship, weather, construction equipment, quality of other materials and other variables affecting results are all beyond our control, Kelly-Moore Paint Company, Inc., does not make nor does it authorize any agent or representative to make any warranty of MERCHANTABILITY OR FITNESS for any purpose or any other warranty, guarantee or representation, expressed or implied, concerning this material except that it conforms to Kelly-Moore's quality control standards. Any liability whatsoever of Kelly-Moore Paint Company, Inc. to the buyer or user of this product is limited to the purchaser's cost of the product itself.

SEE MATERIAL SAFETY DATA SHEETS FOR FULL SAFETY PRECAUTIONS.

KM-100 IS FOR PROFESSIONAL USE ONLY.

KM-100 IS FOR INDUSTRIAL USE ONLY.

KEEP AWAY FROM CHILDREN