

KELLY-MOORE PAINTS INDUSTRIAL COATINGS HIGH PERFORMANCE SYSTEMS

KM-110

Rust-Inhibitive Epoxy Primer

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

Contact your Kelly-Moore representative for more information

Product Description

A two component, high build modified polyamide cured, rust-inhibitive epoxy metal primer. KM-110 helps prevent edge failure and film under-cutting on steel surfaces exposed to corrosive atmosphere and chemically aggressive environments. KM-110 is used as a primer for epoxy and polyurethane topcoats.

Performance Features

- Excellent Adhesion
- Excellent Resistance to Under-cutting
- Excellent Rust Preventative
- Good Flexibility, Abrasion & Impact Resistance
- Excellent Film Build

Product Specifications

Resin Type	Polyamide Epoxy
Color Range	Red, Brown & Gray.
Drying Time	See chart - page 2
Practical Coverage	146-293 Sq. Ft. / Gallon
Recommended Dry Film Thickness	3.0-6.0 mils per coat
Solids By Volume	55%
Mixing Ratio	4:1 by volume 4 parts Base <u>A</u> to 1 part Hardener <u>B</u>
Pot Life	8-10 hours @ 75°F.
Induction Time:	30 Minutes
Sizes	Five Gallon & One Gallon kits
V.O.C.	395 Grams per liter (white)
Thinner	KM-SA-65
Clean Up	KM-SA-65 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.

General:

Remove all dirt, grease, oil, soil, chemical contaminants, and other foreign matter before abrasive blast cleaning. Prepare and paint only clean surfaces in accordance with Steel Structures Painting Council (SSPC) or National Association of Corrosion Engineers (N.A.C.E.) specifications.

Steel (Non Immersion):

A. Corrosive Service:

Abrasive blast to a "Near White" blast finish as outlined in SSPC-10-63T or N.A.C.E. No. 2 specification.

B. Mild Service:

Abrasive blast to a 'Commercial' blast finish as outlined in SSPC-SP6-63 or N.A.C.E. No. 3 specification.

Steel (immersion):

Abrasive blast to a 'White Metal' blast finish as outlined in SSPC-SP5-63 or N.A.C.E. No. 1 specification.

Galvanized Steel:

Surface must be clean and free of grease, dirt, and other foreign matter. Surface should be high pressure water cleaned or solvent degreased per SSPC-SP1-63 specification. Abrasive sweep blast to achieve a profile.

Mixing Instructions:

Stir each component to a uniform consistency, using a slow speed, explosion proof, variable speed drill with a Jiffy Mixer. Make sure any pigment settled to the bottom is incorporated. Do not vary proportions. KM-110 is prepared by mixing 4 parts base (Part A) to 1 part Hardener (Part B) with a power mixer. Be sure material is thoroughly mixed together. Allow an induction time of 30 minutes before use.

Pot Life: The Pot life of KM-110 is about 8-10 hours at 75°F, and 4-6 hours at 90°F.

Application Procedure

Airless	Graco
Gun:	205-591
Pump:	Bulldog 30:1
Tip Range:	.017 - .021
Hose:	3/8" ID
Pressure:	2500

Conventional	DeVilbiss
Gun	MBC or JCA
Fluid Tip	E
Air Cap	64 or 704
Atomizing Pressure	40 psi
Pot Pressure	50 psi
Hose	1/2" ID

KM-110 (cont.)

Dry Times

Temp.	Tack Free	Recoat
90° F	2 hours	3-24 hours
75° F	3 hours	4-24 hours
50° F	8 hours	18 - 48 hours

Times will be longer for films thicker than 4 mils. When spraying use a 50% overlapping crosshatch pattern to minimize the occurrence of pinholes. Do not apply to surfaces below 50° F. or above 120° F. Do not apply over dew or frost. Do not apply if the temperature is within 5° of the dew point.

Precautions

KM-110 is flammable. Keep away from all sources of ignition during mixing, application and cure. The Hardener and mixtures of Hardener and Base can cause eye and skin burns as well as allergic reactions. The use of goggles, fresh air masks or NIOSH approved respirators, protective skin cream and protective clothing is recommended standard practice when spraying coatings

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 SHEET FOR FULL SAFETY PRECAUTIONS

KM-110 IS FOR PROFESSIONAL USE ONLY

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KEEP AWAY FROM CHILDREN