

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, chemical resistant, polyamide epoxy mastic. KM-275 provides excellent adhesion and protection of sound, rusty steel surfaces. This high solids primer-finish is formulated to meet low VOC requirements and offers extended recoat times for epoxy or urethane topcoats.

**Performance Features**

- **Excellent Adhesion to Tight Rust**
- **Meets USDA Requirements**
- **Excellent Against Undercutting**
- **Good Chemical, Abrasion & Impact Resistance**
- **Excellent Film Build**
- **Self-Priming on Steel**

**Product Specifications**

Resin Type	Epoxy Polyamide
Color Range	103 White, 013 Med. Gray, 120 Red Oxide, Custom Colors.
Finish	Semi-Gloss
Drying Time (@75° F.)	To Touch: 3-4 hours To Recoat: 8 hours
Practical Coverage	160-320 Sq. Ft. / Gallon
Recommended Dry Film Thickness	4 - 8 mils per coat
Solids By Volume	80%
Mixing Ratio	1:1 by volume 1 part Base <u>A</u> to 1 part Hardener <u>B</u>
Pot Life	2 hours @ 75°F.
Sizes	Two Gallon & Ten Gallon kits
V.O.C.	187 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](http://www.epa.gov/lead).

**General:**

Remove all dirt, grease, oil, soil, chemical contaminants, and other matter before any mechanical preparation. High pressure water cleaning is recommended. 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:**

a. Sand Blast - Best:

Sand blast to a "Commercial" (SSPC-SP6-63) or "Near White" metal finish. Prime same day, if possible.

b. Power Tool Clean:

Follow instructions as outlined SSPC-SP3-63 specifications.

c. Hand Cleaning:

Follow instructions as outlined in SSPC-SP2-63 specifications.

**Galvanized Steel:**

a. New:

Brush blast per SSPC-SP7

b. Old, Weathered, or Rusty

Remove 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". Power tool clean or sweep blast to get an anchor profile.

**Previously Painted Surfaces:**

Remove all loose, peeling, or blistered paint, and any other surface contaminants. Make sure surface is sound and dry.

**Concrete:**

All new concrete must be cured at least 28 days. Do not use form release agents, surface hardeners, or curing compounds. All concrete should be prepared in accordance to the American Concrete Institute (ACI), Steel Structures Painting Council (SSPC), and National Association of Corrosion Engineers (NACE) concrete specifications. Remove all dirt, dust, oil, grease, laitance, efflorescence, loose or unsound concrete, and any chemical contaminants by such methods as high pressure water blast, wet or dry abrasive blast, vacuum shot blast, acid etching and other accepted surface preparation methods. A combination of these methods are normally used. For on-grade concrete slabs check that a moisture vapor barrier film has been used. Testing may be necessary. Check for the presence of hardeners or residual forming membrane curing agents. Repair all cracks, spalled concrete, voids and expansion joints. The properly sound, cleaned concrete must be primed first with either KM-155, KM-1703 Epoxy Concrete Primer. Two finish coats of KM-275 Epoxy at approximately 5-8 mils dry per coat is recommended for light traffic areas.

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# KM-275 (cont.)

## Mixing Instructions:

Stir each component to a uniform consistency, using an explosion proof, slow speed, variable speed power drill with a Jiffy Mixer. Do not mix by hand. Make sure any pigment settled to the bottom is incorporated. Do not vary proportions. KM-275 is prepared by mixing 1 part base (Part A) to 1 part Hardener (Part B) with an explosion proof, slow speed, variable speed power drill with a Jiffy mixer. KM-275 may be thinned up to 10% by volume for airless spray, and up to 20% by volume for conventional spray. When rolling, thin 10-20% by volume. Use KM-SA-65 for thinning. Allow 15 minutes induction time before application.

**Pot Life:** The pot life of KM-275 is about 2 hours at 75°F, and 1 hour at 90°F.

## Application Procedure

Airless	Graco	Binks
Gun:	205-591	Model 500
Pump:	Bulldog 30:1	Mercury 5C-30:1
Tip Range:	.019 - .023	.019 - .023
Hose:	3/8" ID	3/8" ID
Pressure:	2400 - 2700	2400 - 2700

Conventional	DeVilbiss	Binks
Gun	MBC or JGA	#18 or #62
Fluid Tip	D	67PB
Air Cap	64	67
Atomizing Pressure	60 psi	60 psi
Pot Pressure	15 -20 psi	15 - 20 psi
Hose	1/2" ID	1/2" ID

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. The surface should be dry and at least 5°F above the dew point.

## Dry Times

Temp.	Tack Free	Min. Recoat	Max. Recoat
90° F	1 - 2 hours	6 hours	21 days
75° F	3 - 4 hours	8 hours	28 days
50° F	8 - 12 hours	24 hours	35 days

Times may be longer for thickness above 5 dry mils. For safety and proper product curing, good ventilation is necessary when painting indoors or in confined areas. Be sure the batch numbers are all the same to provide uniform color. Epoxy coatings may yellow or darken during application and after final cure. This will affect the color but will have no effect on the performance of the product. Heaters that emit carbon dioxide and carbon monoxide can cause the coating to yellow. For maximum interior gloss and color retention apply 1 coat of KM-270 Polyester Epoxy. For maximum exterior gloss and color retention apply a top coat of KM-370 or KM-375 gloss polyurethane enamel.

## Precautions

KM-275 is flammable. Keep away from all sources of ignition during mixing, application and cure. The Hardener and Base can cause eye and skin burns as well as allergic reactions. Use goggles, fresh air masks or NIOSH approved respirators, protective skin cream and protective clothing.

## 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-275 IS FOR PROFESSIONAL USE ONLY**

**KM-275 IS FOR INDUSTRIAL USE ONLY**

**KEEP AWAY FROM CHILDREN**