KELLY-MOORE PAINTS
INDUSTRIAL COATINGS
HIGH PERFORMANCE SYSTEMS

KM-615
100% Solids Epoxy Crack Filler

Product Description

KM-615 Epoxy Crack Filler is a 100% solids, two component epoxy crack filler for concrete, steel and wood surfaces. A trowellable adhesive formulated for patching or resurfacing horizontal, vertical or overhead surfaces. KM-615 may be mixed with silica sand to make a mortar consistent material for patching or troweling. KM-615 can cure in the presence of moisture.

Performance Features

- **Excellent Chemical, Abrasion & Impact Resistance**
- **Non-Toxic When Cured**
- **May be Mixed with Aggregate**
- **Zero VOC**
- **100% Solids**

Product Specifications

Resin Type	Epoxy
Color Range	Clear
Recoat Time (@ 75° F.)	8 hours minimum 24 hours maximum
Solids By Volume	100%
Mixing Ratio	2:1 by volume 2 parts Base A : 1 part Hardener B
Pot Life	20-30 minutes @ 75°F.
Sizes	1.5 gallon kits
V.O.C.	0 Grams per liter
Thinner	DO NOT THIN
Clean Up	S-74 or SA-17

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.

Any one of the following surface preparations may be sufficient or a combination of the following may be required depending on the condition of the concrete surface.

High Pressure Wet Abrasive Blast Cleaning

All loose and unsound concrete must be mechanically removed down to sound concrete by means of power tool equipment, such as, chipping/scaling hammers, rotary scalers, etc.

High pressure water blast with sand injection all surfaces to remove all laitance, contaminants, and other foreign deposits to provide a sound, clean surface. Use clean dry air to blow down these areas to remove excessive moisture.

Acid Etch

Apply Concrete Acid Etching Solution per the manufacturer's recommendations. Work the solution into the concrete with a stiff broom or fiber brush.

Allow solution to remain on the concrete surface per directions, or until the effervescing and bubbling ceases. Then flush floor thoroughly with clean, fresh water to remove all laitance, dirt, and other foreign materials.

NOTE: Do not allow the acid solution to dry on the floor before flushing off because dirt, etc., can be redeposited in the pores of the concrete.

Dry Abrasive Blast

Abrasive blast concrete surface to remove all laitance, loose concrete, coating, sealers, etc. It is necessary to achieve a rough anchor pattern and get to sound concrete. All blast material and foreign matter must be removed before application.

In all cases of surface preparation, the pH should be checked. A pH reading of 7.0 - 8.5 is acceptable. Also, a "Water Dissipation Test" should be made on random areas of the floor. A "Vapor Barrier Test" should also be run on the concrete.

New concrete must be cured at least a minimum of 28 days before applying a coating. All laitance, efflorescence, chemical contaminants, grease, oil, and other foreign material must be removed. The prepared surface must be clean, dry and structurally sound.

Mixing Instructions

Do not mix until surface has been primed with KM-155 or KM-1703. Best results are obtained if base and hardener are stored at 75° F. or above for 12 hours prior to mixing.

KM-615 is prepared by mixing 2 parts Base (Part A) to 1 part Hardener (Part B) with a power mixer for approximately 2 minutes. Pot Life is 20 - 30 minutes at 75° F.

KM-615 can be used as is or mixed 1:1 with salt-free, kiln dry aggregate as a mortar.

Application Procedure

KM-615 must be applied over KM-155 or KM-1703 while the primers are tacky. Apply KM-615 with a hand trowel, putty knife or spatula. Apply pressure to compact the material to a dense, tight finish. After the mortar has cured a sealer or finish coat is recommended.
Do not apply below 50° F. or above 100° F.

Precautions

KM-615 is not a fire hazard. The flash point is 300° F. However, under conditions of fire it will burn and release potentially toxic fumes. The Hardener (Part B) either alone or when mixed with Base (Part A) can cause eye and skin burns. The use of goggles, protective skin cream, and protective clothing is recommended as a standard practice.

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-615 IS FOR PROFESSIONAL USE ONLY

KEEP AWAY FROM CHILDREN