## KELLY-MOORE PAINTS NDUSTRIAL COATINGS HIGH PERFORMANCE SYSTEMS

# **KM-15** Chemical Mastic High Build Epoxy

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 solids, chemical resistant amine adduct cured epoxy mastic. Chemical Mastic KM-15 is specially modified with a proprietary blend of selective resins, wetting agents, penetrants and rust inhibitors to provide excellent adhesion and protection of sound, rusty steel surfaces, and to upgrade old, deteriorated coatings. Ideal as a one coat system over marginal or poorly prepared surfaces where blasting is impractical or prohibited. Recommended as a high build primer under a wide variety of topcoats.

#### **Performance Features**

- Excellent Adhesion to Tight Rust
- USDA Approved
- Rust Inhibitive
- Good Chemical, Abrasion & Impact Resistance
- Excellent Film Build
- Self-Priming on Steel

#### **Product Specifications**

Epoxy Amine		
Standard Industrial Colors.		
Gloss 80-90		
See chart - page 2		
188-263 Sq. Ft. / Gallon		
5-7 mils per coat		
82%		
4:1 by volume		
4 parts Base <u>A</u> to 1 part Hardener <u>B</u>		
3 hours @ 75°F. when thinned		
Five Gallon & One Gallon kits		
161 Grams per liter (white)		
KM-S-74		
KM-S-74 or MEK		

#### **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 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:

#### <u>a. New:</u>

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".

#### **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 or self-primed with KM-15 reduced 15% with KM-S-74. Two finish coats of KM-15 Epoxy at approximately 5-7 mils dry per coat is recommended for light traffic areas.

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#### **Mixing Instructions:**

Stir each component to a uniform consistency, using a slow speed, explosion proof, variable speed drill with a Jiffy Mixer. Do not mix by hand. Make sure any pigment settled to the bottom is incorporated. <u>Do not</u> vary proportions. KM-15 is prepared by mixing 4 parts base (Part A) to 1 part Hardener (Part B) with a power mixer. KM-15 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-S-74 for thinning.

Pot Life: The Pot life of KM-15 is about 3 hours at 75°F, and 1 1/2 hours at 90°F.

#### **Application Procedure**

Airless	Graco	Binks			
Gun:	205-591	Model 500			
Pump:	Bulldog 30:1	Mercury 5C-30:1			
Tip Range:	.019023	.019023			
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  $50^{\circ}$ F or above  $120^{\circ}$ F. Do not apply over dew or frost. The surface should be dry and at least  $5^{\circ}$ F above the dew point.

#### **Dry Times**

Temp.	Tack Free	Min. Recoat	Max. Recoat
90° F	1 - 2 hours	5 - 6 hours	3 days
75° F	3 - 4 hours	7 - 8 hours	7 days
50° F	8 - 12 hours	36 - 48 hours	10 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.

#### **Chemical Resistance**

Aluminum Nitrate - 50% Apple Juice Brine Boric Acid - 25% Castor Oil Corn Oil **Diesel Fuel Distilled Water** Fish Oil Gasoline (unleaded) Glyoxal Hexylene Glycol Hexane lodine Kerosene Linseed Oil Mineral Oil Molasses Mustard Oleic Acid Orange Juice Phosphoric Acid - 20% Rock Salt Sodium Bromide - 40% Sulfuric Acid - 20% Tomato Juice Whiskey **Xylene** Sodium Carbonate - 30% Aluminum Sulfate - 50% Beer Barium Chloride - 50% Calcium Chloride - 50% Copper Sulfate - 50% Cutting Oil Diethylene Glycol Ethylene Glycol Fuel Oil Glycerin Grape Fruit Juice Hydraulic Fluid Honey Jet Fuel - (JP4, JP5, JP7) Ketchup Latic Acid - 25% Milk **Mineral Spirits** Motor Oil Naptha (Aliphatic) Olive Oil Peanut Oil Power Steering Fluid Sodium Bisulfate - 50% Sodium Hydroxide - 50% Transmission Fluid Vegetable Oil Wine

#### Precautions

KM-15 is flammable. Keep away from all sources of ignition during mixing, application and cure. KM-15 Hardener is corrosive. 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. 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 SHEET FOR FULL SAFETY PRECAUTIONS KM-15 IS FOR PROFESSIONAL USE ONLY KM-15 IS FOR INDUSTRIAL USE ONLY KEEP AWAY FROM CHILDREN

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