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KLASS KOTE - PRODUCT DATA SHEET

PRODUCT NAME **KLASS KOTE - GRAY PRIMER #50 & WHITE PRIMER #55**

DESCRIPTION **KLASS KOTE GRAY PRIMER #50 & WHITE PRIMER #55** are high solids, catalyzed primers with excellent filling capabilities. They have been extensively field tested since 1964. **GRAY PRIMER #50** contains Zinc Chromate pigment as the anti-corrosive agent, while **WHITE PRIMER #55** contains Zinc Phosphate. On the ASTM B-117 test for rust creepage away from x-scribe on steel panel, **GRAY PRIMER #50** rated 10 on a scale of 0-10. (0-worst, 10-best), while **WHITE PRIMER #55** rated a 9.

These products are designed to be the first primer applied to bare substrates. **WHITE PRIMER #55** must be catalyzed with **KLASS KOTE PRIMER CATALYST WHITE FAST #420**, while **GRAY PRIMER #50** can be catalyzed with either **PRIMER CATALYST WHITE FAST #420**, or **PRIMER CATALYST #415** - based on cure schedule requirements and shop conditions.

BASIC USES Highly adhesive, rust inhibiting, protective, sandable primer. Applicable on most surfaces, including wood, metal, cement, aluminum, fiberglass, glass, balsa, etc.

PHYSICAL DATA

		<u>GRAY #50</u>	<u>WHITE #55</u>
<u>PART-A EPOXY:</u>	<u>SOLIDS BY WEIGHT:</u>	60.10%	60.20%
	<u>SOLIDS BY VOLUME:</u>	41.89%	40.33%
<u>PART-B CATALYST:</u>	<u>SOLIDS BY WEIGHT:</u>	59.92%	61.08%
	<u>SOLIDS BY VOLUME:</u>	39.34%	41.28%
	<u>COLOR:</u>	<u>MEDIUM GRAY</u>	<u>OFF WHITE</u>
	<u>DUST FREE:</u>	<u>1-HR</u>	<u>45 MIN - 1 HR</u>

SURFACE PREPARATION

The surface **must be clean** and free from dirt, dust, grease, rust, and scale, or anything that will otherwise impede adhesion. Whenever possible, solvent wash with **KLASS KOTE EPOXY REDUCER #500**. If the recommended reducer is not available, use a high-grade lacquer thinner. For rusted, heavily scaled or previously painted surfaces, sanding to bare surface or media blasting is recommended. If this is not practical, use other conventional methods to remove scale and old paint/primer. **KLASS KOTE** Epoxy Primers are **NOT RECOMMENDED** for use over old paint or uncatalyzed primers!

APPLICATION

KLASS KOTE products work ideally with conventional air-atomizing spray equipment, as well as HVLP and airless equipment. (Can also be applied with a brush or roller.) Once the components are mixed and reduced, **KLASS KOTE** covers like most conventional primer coats. For best results while using conventional spray equipment with **GRAY PRIMER #50 & PRIMER CATALYST #415**, components parts A & B should be inducted or reacted for 30 to 40 minutes (with occasional stirring) prior to application. No induction is necessary when using **PRIMER CATALYST WHITE FAST #420**. Film thickness should be built up by applying successive thin coats of primer and allowing about 20 minutes "flash off" time between coats.

For electrostatic application, if conductivity does not fall within the prescribed range for a given application the conductivity can be raised by adding a polar solvent, such as PPG DTL 16 or Klean-Strip L-27. The polar solvent may have to be added a number of different times in a number of different quantities before desired conductivity is reached, so be sure to record the amount added to each test batch before application.

MIXING INSTRUCTIONS

Thoroughly mix equal parts by volume of components A & B. If using **GRAY PRIMER #50** with **PRIMER CATALYST #415** allow mixture to inducted/react for 30 to 40 minutes, (with occasional stirring) prior to thinning and application. Always mix equal parts of epoxy and catalyst components together first -- before reducing the mixture. The amount of reducer needed depends upon ambient temperature and type of spray equipment used. Start with 6 parts paint to 1 part reducer. If **KLASS KOTE EPOXY REDUCER #500** is unavailable, use a high grade lacquer thinner formulated to reduce epoxies. Reduction up to 1-to-1-to-1 (1-part A, 1-part-B, & 1-part Reducer) may be necessary to achieve the proper viscosity, especially when working with smaller guns and air brushes. Do **NOT** over-reduce!

TECHNIQUE

A film of the combined components A&B would yield a dry film by volume of $(40.33 + 41.28) / 2 = 40.80$. In other words, a wet film of 3 mils (.003) would yield a dry film of $3 \times .048 = 1.22$ mils. Care must be taken in finish coating over epoxy primers. If film has not cured sufficiently, the catalyst component may migrate into the finish coat producing a cheese like result. For rush jobs, induct parts A&B for 2-3 hours before applying, and/or use **PRIMER CATALYST WHITE FAST #420**, with no induction necessary. This will cut the cure rate to approximately 1/2 the time. Top coats must be applied no sooner than 2 hours after last prime coat, and no later than 24 hours, depending on primer film thickness and shop conditions. After 24 hours primer coat must be scuffed prior to top coating - (when using **PRIMER CATALYST WHITE FAST #420**, top coating can occur in the range of 1 -18 hours – depending on film thickness and shop conditions.

CURE SCHEDULE

For best results paint and surface should be at least 70°F, and can be force dried after solvent has flashed off. Suggest 120°F for 15 minutes to speed cure time. Oven or heat gun works best. At 70°F (air & substrate temperatures):

- TACK FREE TIME: 20 - 30 MINUTES UP TO 1 HOUR
- PRINT FREE TIME: 2 - 4 HOURS
- PACKAGING TIME: 18 - 24 HOURS
- RECOAT/TOP COAT WINDOW: 2 – 24 HOURS - DEPENDING ON FILM THICKNESS
- SWARD HARDNESS: 4 DAYS - 1 WEEK

COVERAGE

Using conventional air atomizing spray equipment on a non-porous substrate, 1 quart of reduced **KLASS KOTE** will cover approximately 50-75 square feet. On more porous substrates, 1 quart will cover approximately 40-50 square feet.

PACKAGING

Available in pint kits (2x ½ pints), quart kits, (2x pints) & ½ gallon kits, (2x quarts). All applications require equal parts of epoxy (part-A) and catalyst (part-B). For industrial customers, or jobs that require larger quantities, please call customer service.

AVAILABILITY

DIVERSIFIED SOLUTIONS, LLC • 5932 CHICAGO AVE. SOUTH • MINNEAPOLIS, MN 55417
Some retail outlets are also available. Please call us for details.

WARRANTY

The manufacturer warrants that this product conforms to label descriptions, is free from manufacturing defects, and is fit for the ordinary purposes for which such goods are used. Inasmuch as the use of this product by others and other factors affecting product performance are beyond manufactures control, manufacturer does not guarantee the results obtained. Should this product fail to give satisfactory results, manufacturer will replace the product, or at its option, refund the purchase price. This is the sole and exclusive remedy for any failure of this product to perform as warranted and shall also constitute liquidated damages in case of loss. Under no circumstances shall the buyer be entitled to any other remedy or damages. Remedies for incidental and consequential damages are specifically excluded. The seller does not authorize any person or organization to assume for it any other liability in connection with the sale or use of this product unless specifically authorized by manufacturer in writing.