WATER-BASED EPOXY
K0244 Series, Part A,
K02448431, Gloss Hardener, Part B
K02448432, Semi-Gloss Hardener, Part B

Product Data Sheet

DESCRIPTION
Water-Based Epoxy is a two-component, acrylic catalyzed, epoxy resin coating formulated for high performance use in industrial and commercial environments.

ADVANTAGES
- Meets performance requirements of ASTM D3730
- Corrosion and chemical resistant
- Impact and abrasion resistant
- Flash rust resistant
- Acceptable for use in federally inspected meat and poultry plants
- Low odor/non-flammable
- Low VOC
- Tested for nuclear irradiation and decontamination, Level II

RECOMMENDED USES
For use over prepared substrates such as steel, aluminum, and concrete in industrial environments.
- Tile-like wall coating
- Interior institutional/commercial high maintenance areas
- Upgrade surfaces painted with conventional coatings to a high performance protection system without lifting and bleeding
- Low odor/no shutdown sanitary coating system
- Hospitals
- Schools
- Pharmaceutical houses
- Exterior storage tanks
- Institutional kitchens
- Manufacturing equipment

SPECIFICATIONS

RECOMMENDED SYSTEMS
Steel, Water-Based Epoxy Primer:
1 ct. Water-Based Epoxy Primer (K02448430) @ 3.0 - 5.0 mils dft
1-2 cts. Water-Based Epoxy (K0244 Series) @ 2.5 - 3.0 mils dft/ct
Steel, Acrylic Primer:
1 ct. DTM Acrylic Primer/Finish (K00021374) @ 2.5 - 4.0 mils dft
1-2 cts. Water-Based Epoxy (K0244 Series) @ 2.5 - 3.0 mils dft/ct
Steel, Alkyd Primer:
1 ct. Universal Primer (K00023000 / K00023001 / K00023002) @ 2.5 - 5.0 mils dft
1-2 cts. Water-Based Epoxy (K0244 Series) @ 2.5 - 3.0 mils dft/ct
Aluminum/Galvanized Metal:
1-2 cts. Water-Based Epoxy (K0244 Series) @ 2.5 - 3.0 mils dft/ct
Concrete:
1 ct. Heavy Duty Block Filler (K00261646) @ 10.0 - 15.0 mils dft
1-2 cts. Water-Based Epoxy (K0244 Series) @ 2.5 - 3.0 mils dft/ct
Masonry:
2 cts. Water-Based Epoxy (K0244 Series) @ 2.5 - 3.0 mils dft/ct

Note: Weathered, soft or porous masonry must be properly prepared.

ORDERING INFORMATION
Packaging: Part A: 4 gallon kit or 1 gallon container
Part B: 1 gallon or 1 quart

WEIGHT PER GALLON: 10.0 ± 0.2 lb (mixed, may vary by color)

SURFACE PREPARATION
Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron and Steel (Atmospheric Service): Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Power Tool Cleaning per SSPC-SP3. For better performance, use Commercial Blast Cleaning per SSPC-SP6. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Remove all weld spatter and round all sharp edges by grinding to a minimum 1/4” radius. Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

Aluminum: Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1.

Galvanized Steel: Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1 (recommended solvent is VM&P Naphtha (K01661714). When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area with a rust inhibitive primer the same day as cleaned.

Concrete and Masonry: Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F. Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids. Weathered masonry and soft or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination and to get to a hard, firm surface. Laitance must be removed by etching with a 10% muriatic acid solution and thoroughly neutralized with water. Brick must be allowed to weather for one year prior to surface preparation and painting.

APPLICATION

APPLICATION CONDITIONS
Temperature: 55°F minimum, 100°F maximum (air, surface, and material). At least 5°F above dew point
Relative Humidity: 85% maximum

APPLICATION EQUIPMENT
The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.

Airless Spray: Pressure: 2000 psi; Hose: 1/4” ID; Tip: .015”; Filter: 100 mesh; Reduction: As needed, up to 12% by volume.

Brush: Nylon / polyester; Reduction: Not recommended.

Roller: Cover: 3/8” woven with phenolic core;
Reduction: Not recommended

Note: If specific application equipment is listed above, equivalent equipment may be substituted.
APPLICATION PROCEDURES
Surface preparation must be completed as indicated. Mix contents of each component thoroughly with power agitation. Make certain no pigment remains on the bottom of the can. Then combine four parts by volume of Part A with one part by volume of Part B.

Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated. Re-stir before using. If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

PERFORMANCE TIPS
• Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.
• When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.
• Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.
• Excessive reduction of material can affect film build, appearance, and adhesion.
• Do not apply the material beyond recommended pot life.
• Do not mix previously catalyzed material with new.
• In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with soap and water.

CLEAN-UP
Clean spills and spatters immediately with soap and warm water. Clean hands and tools immediately after use with soap and warm water. After cleaning, flush spray equipment with Mineral Spirits, to prevent rusting of the equipment. Follow manufacturer’s safety recommendations when using any solvent.

CHARACTERISTICS
FINISH: Gloss, 65 units at 60° (White and White Base)
Semi-Gloss, 25 units at 60° (White and White Base)
Gloss, 80 units at 60° (Deep and Clear Base)
Semi-Gloss, 25 units at 60° (Deep and Clear Base)
COLOR: Wide range of colors possible (available in White Tint Base, Deep and Clear Tint Base)
VOLUME SOLIDS: 39% ± ±%, mixed, may vary by color
WEIGHT SOLIDS: 47% ± ±%, mixed, may vary by color
VOC (Calculated): 176 g/L; 1.50 lb/gal, mixed White Tint Base
MIX RATIO: 2 components, premeasured 4:1
RECOMMENDED SPREADING RATE PER COAT:
Wet mils: 6.5 - 8.0; Dry mils: 2.5 - 3.0;
Coverage: 209 - 250 sq ft/gal approximate
NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

CAUTIONS
Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings™ Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings™ Distributor.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, Krylon Products Group cannot make any warranties as to the end result. Please direct any questions or comments to 1-800-777-2966.