

## K'mastic 5000

### Two Pack Polyamide Cured Epoxy

#### Product Description

K'mastic 5000 is a high build surface tolerant epoxy solvent based primer. It has good anti-corrosive properties and provides very good adhesion to substrate as well as subsequent coatings.

#### Recommended Use

Recommended as primer and/or Intermediate coat for steel substrates in mild to aggressive industrial environments. Also suitable for touch up jobs.

#### Product Information

Binder	: Epoxy
No. of Components	: 2
Solids (% by Volume)	: 90 ± 2 %
Flash Point	: 27°C (when mixed)
Colour	: Limited Color Range
Finish	: Satin

#### Application Information

Substrate	: Steel
Recommended No. of Coats	: 1
Recommended Wet Film Thickness	: 85 to 220 µm / Coat
Recommended Dry Film Thickness	: 75 to 200 µm / Coat
Theoretical Spreading Rate	: 5 to 12 m <sup>2</sup> / L / Coat
Specific Gravity	: Approx. 1.50

#### Application Methods

Applied By : Brush / Roller / Spray / Airless Spray

\* Brush and Roller recommended for stripe coating and small areas only

\* Airless Spray Recommended Tip Size: 0.53 - 0.63 mm (21 - 25 thou)

\* Airless Spray Recommended Pressure: 140 - 165 kg/cm<sup>2</sup> (2000 - 2400 psi)

Thinner : Thinner 56 (5% maximum addition)

Clean Up : Cleaner 12

#### Packaging & Storage

Packaging : 5.0 Litres (4 Litres Part A : 1 Litres Part B)  
20.0 Litres (15.0 Litres Part A : 5.0 Litres Part B)

Shelf Life : 12 months - Unopened

Storage : Cool, dry and well ventilated area away from heat and direct sun light. Lid must be kept tightly closed.

Disclaimer : The above information is given to the best of our knowledge based on laboratory testing and practical experiences. The information in this data sheet may be subject to changes from time to time and without notice due to production refinements arising from continuing research and evaluation programmes, which may occasionally result in marginal changes in the coating properties.

Curing Time					
Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval		Pot Life
			Minimum	Maximum	
15 °C	7 hours	28 hours	28 hours	Indefinite	3 hours
25 °C	5 hours	18 hours	18 hours	Indefinite	2 hours
35 °C	2 hours	6 hours	6 hours	Indefinite	1 hours

\*The properties above may vary with surface temperature, site environment, film thickness, etc.

Typical Painting System		
System	Product	No. of Coats
Primer	K'mastic 5000	1
Intermediate	K'mastic 5000	1
Finish	Recommended KCC epoxy or polyurethane finish	1
Repair Coat	Touch up with K'mastic 5000	1

### Surface Preparation

All surface to be coated should be clean, dry and free from contamination as in accordance to ISO 8504. Oil and greasre must be removed by solvent cleaning as in accordace to SSPC -SP1. K'mastic 5000 is recommended to be applied over steel substrates with surface preparation to a cleanliness of Sa 2 or St 3 (ISO 8501:1 - 1:2007) The surface should also be clean, dry and free from all contamination. K'mastic 5000 must be applied within the recommended overcoating intervals.

### Preapplication Conditions

- 1) The surface temperature should be 3°C above the dew point and should not exceed 50°C.
- 2) The relative humidity should be between 60% and 85%.
- 3) Paint application shall not commence when there is a likelihood of an unfavourable change in weather condition within 2 hours after painting.
- 4) The Hardener (Part B) should be added to the Base (Part A) slowly while stirring with a mechanical agitator. Ensure all components are mixed together in a uniform and homogenous manner before application.

### Product Limitations

K'mastic 5000 is not designed for continuous water immersion. In common with all epoxies, K'mastic 5000 will chalk and discolour on external exposure and weathering. This phenomenon is not detrimental to the paint's anti-corrosive performance. K'mastic 5000 is recommended to be overcoated with a durable high performance polyurethane finish for better weathering resistance. Maximum film build in a single coat is best achieved by airless spray. For brush and roller applications, multiple coats will be required to achieve the required DFT.

### Safety Precaution

This product is flammable and must be kept away from any source of ignition. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately. Keep out of reach of children.

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