

THIS PRODUCT MAY NOT BE AVAILABLE IN SOME AREAS DUE TO VOC REGULATIONS
Contact your Kelly-Moore representative for more information

Product Description

A high performing, VOC compliant, two-component, self-priming high build polyamide epoxy coating specially formulated to protect steel and concrete in chemically aggressive environments. KM-280 can be applied at a dry film thickness of 6 mils in one coat. The cured film is tough and abrasion resistant.

Performance Features

- **Good Chemical, Abrasion, & Impact Resistance**
- **High Film Build**
- **Outstanding Adhesion**
- **For Concrete or Steel**
- **Semi-Gloss Finish**

Product Specifications

Resin Type	Epoxy Polyamide
Color Range	White, Deep Base, Neutral Base
Finish	Semi-Gloss
Drying Time	See chart - page 2
Practical Coverage	190-320 Sq. Ft. / Gallon
Recommended Dry Film Thickness	3-5 mils per coat
Solids By Volume	60 ±3%
Mixing Ratio	1:1 by volume 1 part Base <u>A</u> : 1 part Hardener <u>B</u>
Pot Life	8 hours @ 75°F.
Induction Time:	30 Minutes
Sizes	Ten & two gallon kits
V.O.C.	307 Grams per liter (white)
Thinner	KM-SA-65
Clean Up	KM-SA-65 or KM-S-74

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.

Steel (non-immersion):

Abrasive blast to a 'commercial' SSPC-SP6-63.

Steel (for immersion):

Abrasive blast to 'Near White' SSPC-SP10-63.

Recommended primers: KM-15, KM-110, KM-100, KM-183. KM-280 can be used as a primer over properly prepared surfaces.

Galvanized Steel:

Surface must be clean and free from all dirt, grease, and other foreign matter. If needed, surface can be high pressure water cleaned, or solvent degreased per SSPC-SP1-63. Prime with KM-100 MCU Aluminum Primer.

Concrete:

Remove all laitance, efflorescence, chemical contaminants, grease, oil, old paint, and other foreign matter. The prepared surface must be clean, dry, and structurally sound. Sand blasting or water blasting may be necessary to achieve the proper profile, Acid etch, or other chemical treatments should be evaluated. In all cases of surface preparation, the pH should be checked. A water dissipation test and a vapor barrier test should be run. Do not apply to slabs on grade unless a heavy unruptured vapor barrier has been installed under the slab. After concrete surface is clean and dry, prime with KM-155 Concrete Primer per label instructions. Apply 1 or 2 coats of KM-280 Epoxy topcoat per label instructions. Allow 24-48 hours cure before putting area back into service.

Mixing Instructions:

KM-280 is prepared by mixing 1 parts Base (Part A) to 1 part Hardener (Part B) with a slow speed, explosion proof, variable speed drill and Jiffy mixer. Allow an induction time of 30 minutes before using. KM-280 may be thinned up to 20% with KM-SA-65. Over thinning reduces the high film build capability.

Pot Life: The Pot life of KM-280 is 8 hours at 75°F, and 4-6 hours at 90°F.

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KM-280 (cont.)

Application Procedure

KM-280 can be applied by brush, roller, or spray.

Airless	Graco
Gun:	205-591
Pump:	30:1
Tip Range:	.017 - .021
Hose:	3/8" ID
Pressure:	2500

Conventional	DeVilbiss
Gun	MBC or JGA
Fluid Tip	E
Air Cap	64 or 704
Atomizing Pressure	20-60 psi
Pot Pressure	20-40 psi
Hose	1/2" ID

When spraying, use a 50% overlapping crosshatch pattern to minimize the occurrence of pinholes. Do not apply to surfaces below 50°F or above 120°F. Do not apply over dew or frost. The surface should be dry and at least 5°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	24 - 36 hours	10 days

Times may be longer for thickness above 4 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 effect 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.

Precautions

KM-280 is Flammable. Keep away from all sources of ignition during mixing, application and cure. 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 SHEETS FOR FULL SAFETY PRECAUTIONS.

KM-280 IS FOR PROFESSIONAL USE ONLY.

KM-280 IS FOR INDUSTRIAL USE ONLY.

KEEP AWAY FROM CHILDREN