

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

Product Description

KM-636 is a high performing, surface tolerant, two component, high solids, high build amine cured epoxy designed to cure at temperatures down to 25°F. KM-636 Epoxy is specially modified with a proprietary blend of selective resins, wetting agents and penetrants to provide excellent adhesion and protection of sound, rusty steel surfaces. Depending on the temperature, the fast setting KM-636 can be recoated the same day. Ideal as a two coat system over marginally prepared surfaces where blasting is impractical or prohibited. KM-636 Epoxy is also used as a high build primer under a wide variety of epoxy and polyurethane topcoats.

Performance Features

- Immersion Resistant to Many Chemicals
- Low Temperature cure to 25° F.
- Self Priming on Steel
- Excellent Chemical, Abrasion & Impact Resistance
- Fast Recoat

Product Specifications

Resin Type	Epoxy Amine
Color Range	Cream, Lt. Gray, Med. Gray, Dk. Gray, Tile Red, Black.
Finish	Semi-Gloss
Drying Time	See chart - page 2
Practical Coverage	170-300 Sq. Ft. / Gallon
Recommended Dry Film Thickness	4-7 mils per coat
Solids By Volume	75% ±2%
Mixing Ratio	4:1 by volume 4 parts Base <u>A</u> : 1 part Hardener <u>B</u>
Pot Life	2 hours @ 75°F.
Sizes	Five and One gallon units
V.O.C.	214 Grams per liter
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:

a. Sand Blast - Best:

Sand blast to a "Commercial" (SSPC-SP6-63) or "Near White" (SSPC-SP10-63) blast finish. For best results, prime same day with KM-636.

b. Power Tool Clean:

Follow instructions as outlined SSPC-SP3 specifications.

c. Hand Cleaning:

Follow instructions as outlined in SSPC-SP2 specifications.

Galvanized Steel:

a. New:

Brush blast per SSPC-SP7 Prime with KM-100 per label instructions

b. Old, Weathered, or Rusty

Remove all oil, grease, dirt, rust and other foreign matter. Surface should be clean, dry and free of contaminants. Follow with a Sweep blast to provide an anchor profile. Remove all loose, rust, etc. as outlined above under "steel."

Previously Painted Surfaces:

Remove all loose, peeling, or blistered paints, and any other surface contaminants. Make sure surface is sound and dry. A test sample of KM-636 Epoxy should be applied to the existing paint to check for compatibility.

Concrete:

All new concrete must be cured at least 28 days. 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, bug holes, spalled concrete, voids and expansion joints

Surface Preparation

All concrete should be prepared in accordance with 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 is normally used. Random pH readings using distilled water should be made to ensure all contaminants have been removed. A final pH reading of 7.0 - 8.5 is acceptable.

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Coating System Concrete

The properly sound, cleaned concrete should be primed first with KM-155, or KM-1703 Epoxy Concrete Primer per label instruction. Two coats of KM-636 Epoxy at approximately 4-7 mils dry per coat is recommended for light traffic areas.

Mixing Instructions:

Stir each component to a uniform consistency, using a slow speed, explosion proof, variable speed drill with a Jiffy Mixer. Make sure any pigment settled to the bottom is incorporated. Do not vary proportions. KM-636 is prepared by mixing 4 parts Base (part A) to 1 part Hardener (Part B) with a power mixer. Allow an induction time of 15 minutes. KM-636 may be thinned up to 15% with KM-SA-65 Thinner.

Pot Life: The Pot life of KM-636 is about 2 hours at 75°F.

Application Procedure

Airless	Graco	Binks
Gun	205-591	Model 500
Pump	Bull dog30:1	1Mercury 5C-30:1
Tip Range	.019 to .023	.019 to .023
Hose	3/8 inch ID	3/8 inch ID
Pressure	2400 to 2700 psi	2400 to 2700 psi

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 25°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 - 1 hour	3 - 4 hours	3 days
75° F	1 - 2 hours	4 - 6 hours	5 days
50° F.	4 - 6 hours	16 - 24 hours	7 days
35° F	8 - 12 hours	36 - 48 hours	10 days
25° F.	16 -24 hours	60 - 72 hours	14 days

Times may be longer for thickness above 5 dry mils. For maximum recoat times contact the manufacturer. 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. KM-636 Hardener will darken with age. 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 one (1) coat of KM-270 Polyester Epoxy for a finish coat. For maximum exterior gloss and color retention apply a topcoat of KM-370 or KM-375 polyurethane.

Precautions

KM-636 is Flammable. Keep away from all sources of ignition during mixing, application and cure. The Hardener (Part B) is also corrosive and can cause eye and skin irritation as well as allergic reactions. The use of goggles, fresh air masks or NIOSH approved respirators, protective skin cream and protective clothing is a recommended standard practice when spraying coatings. Proper ventilation is always required

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-636 IS FOR PROFESSIONAL USE ONLY

KM-636 IS FOR INDUSTRIAL USE ONLY

KEEP AWAY FROM CHILDREN