

**KARDEN ALUBOND**

PRODUCT CODE: KBK 020120  
EPOXY PRIMER FOR VARIOUS METALS

**1. DESCRIPTION OF PRODUCT AND THE PRODUCER**

GENERIC TYPE	Amine cured polymeric epoxy
DESCRIPTION, AREAS OF USE	A VOC compliant, user friendly, two pack, amine adduct cured, extremely high solid epoxy primer/sealer for steel surfaces which are marginally prepared. Could also be applied on old coatings. Penetrates into rust and discontinuities in existing coatings and develops a highly flexible-strong base for following coats. Has excellent adhesion abilities on steel, galvanizing, aluminum, copper and stainless steel surfaces. Not recommended for immersion service. Suitable topcoats; Acrylics, polyurethanes, epoxies, alkyds
PRODUCER INFORMATION	Kartallar Boya ve Kimya Sanayi Ticaret Limited Sirketi Koslucesme Mahallesi, Yeni Bagdat Caddesi, No:136, 41400 Gebze / KOCAELI / TURKIYE
PRODUCT HOTLINE	Monday-Saturday (08:30 – 18:00) Tel: 0262 641 49 67 Fax : 0262 641 49 68
EMERGENCY LINE	Uludag University Poison Research Center (7/24) – +90 224 442 82 93

**2. PRODUCT'S TECHNICAL & APPLICATION PARAMETERS**

COLOUR(S) / TEXTURE	Semi-transparent Green
APPEARANCE	High Gloss (ASTM D 523)
SPECIFIC GRAVITY	1,07±0,02 g/cm <sup>3</sup> (ASTM D 1475)
SOLID BY VOLUME	%99±1 (ASTM D 2897)
THINNER CODE	Not required. May be thinned with K-Solv1400
THINNING RATE	%0-8
VOC CONTENT	147 g/L (EPA Method 24)
THEORETICAL SPREADING RATE	19,5 sqm per liter when applied as single coat (50 microns DFT)
SURFACE DRY TIME	30 hours @20 °C
THROUGH DRY	18 hours @20 °C
COMPLETELY CURED	9 days @20 °C
HARDENER TYPE – COMP. MIXING RATIO	K-Cure 21000 , <b>1:1 on Volume</b>
METHOD OF APPLICATION	Airless Spray, HVLP Spray, lint free roller, brush
NOZZLE INFO	0,018" – 0,021"
PRESSURE INFO	200-220 bars
RECOMMENDED WET THICKNESS	50 microns
DRY FILM THICKNESS	≈50 microns
MINIMUM RECOATING INTERVAL	<b>18 hours</b> @20 °C for topcoating with acrylics, alkyds, epoxies and urethanes
MAXIMUM RECOATING INTERVAL	<b>14 days</b> @20 °C for topcoating with acrylics, alkyds, <b>30 days</b> @20 °C for epoxies and urethanes
MAXIMUM RECOATING INTERVAL(IMMERSION)	Not suitable for immersion service
POT LIFE	<b>80 minutes</b> @20 °C
SHELF LIFE	<b>3 years</b> for Component A and <b>3 years</b> for Component B from the date of manufacture, as long as stored at proper conditions and unopened

**3. SURFACE PREPARATION & ENVIRONMENTAL CONDITIONS DURING APPLICATION**

NEW APPLICATION	Oil and grease should be removed by solvent cleaning at least according to SSPC-SP2. If a suitable temporary protecting primer was applied, loose debris and any type of contamination should be cleaned thoroughly prior to the final application.
REPAIRS	Corroded areas should be cleaned to at least SSPC SP2. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to the overcoating.
SURFACE SALT LIMITS	35µg/sqm

DATE OF ISSUE : 24.09.2018

**KARTALLAR BOYA VE KIMYA SANAYI TICARET LIMITED SIRKETI**

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**KARDEN ALUBOND**

PRODUCT CODE: KBK 02.0120  
EPOXY PRIMER FOR VARIOUS METALS

**3. SURFACE PREPARATION & ENVIRONMENTAL CONDITIONS DURING APPLICATION (CONTINUED)****ENVIRONMENT CONDITIONS**

Ambient temperature of the application environment should be between 20-45°C. Temperature and relative humidity should be measured in the vicinity of the substrate. The maximum recommended surface temperature is 50°C. When applying this paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 16°C. Otherwise extra solvent may be needed to obtain a proper application viscosity. Relative humidity must not be over %90. This product should only be applied on completely dry surfaces.

**4. PACKING & STORAGE CONDITIONS****PACKING DETAILS**

10 Component A + 10L Component B in steel pails

**STORAGE CONDITIONS**

Storing areas should be dry and well ventilated where the temperature is always between 5-40°C. These areas should be separated from the manufacturing fields to eliminate the risks of fire.

**5. ENVIRONMENTAL RESPONSIBILITY, HEALTH & SAFETY****GENERAL RULES**

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.

**HEALTH**

Avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spillage on the skin should immediately be removed by thorough washing with lukewarm water and soap or a suitable industrial cleaner. Eyes should be flushed with fresh water and medical attention sought immediately. Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapors and paint mist by wearing an air mask.

**SAFETY**

This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

**6. DISCLAIMER****DISCLAIMER**

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.

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