

General Airgun Spray Application Guidelines for **KrystalKote™** Clear and Tint Coating

SURFACE PREPARATION

Refer to the **KrystalKote™ Data Sheet** for product preparation prior to application.

- 1.) The surface to be coated must be completely clean of all contaminants prior to application: including factory release agent, oil, grease, dust, powder, water, etc. New concrete must cure at least 28-days, and new mortar must be completely moisture-free, prior to application. Refer to manufacturer's instructions on cleaning procedures for product to be coated.
- 2.) It is mandatory to allow adequate time for water evaporation following factory prescribed machine-scrubbing, or wet-mopping, as **KrystalKote™** is NOT moisture-tolerant.
- 3.) Use a clean, electrostatic dust-mop to remove lint and other particulate material.

APPLICATION: TINT or CLEAR COATING

QUALIFIED, PROFESSIONAL APPLICATION RECOMMENDED

Equipment & materials requires:

- ▶ "Wet Film Thickness (WFT) gauge;
- ▶ Conventional (air), HVLP, or airless spray equipment;
- ▶ 1-inch to 2-inch wide masking tape;
- ▶ 12-inch wide, or wider, adhesive-edged, rolled, masking paper;
- ▶ Brown craft paper or newspaper;
- ▶ Acetone or Methyl Ethyl Ketone (M.E.K.) as thinning solvent, if needed;
- ▶ Acetone, Lacquer Thinner, M.E.K., or Toluene as cleaning solvent;
- ▶ Proper OSHA protective clothing and activated-charcoal filtered breathing mask apparatus.

Spray Equipment Selection Guide: Suitable equipment from other manufacturers may be used. Changes in pressure and tip sizes may be needed for proper spray characteristics.

Airless spray - Standard equipment such as SprayTech Model EP2105, or equal, rated at 0.40 GPM through-the-tip, and minimum 2500 p.s.i.; "fine" tip-filter or gun-filter; reversible tip of 0.013" to 0.017" orifice; 24-inch spray extension; and minimum of 50-foot (absolutely clean or new) airless hose.

Air spray - Industrial airgun equipment, such as Binks Model 2001 (Conventional) or Mach 1 (HVLP), or equal. Separate air & fluid pressure regulators, and moisture & oil trap in main air supply line, are recommended. A mechanical pot agitator can be used. With conventional spray, use adequate air pressure/volume to ensure proper atomization. Recommended fluid nozzle: .046" to .070" (.055" & .064" most commonly used).

- 1.) Using a drill-mounted impeller, thoroughly mix clear **KrystalKote™ Curing Agent** into clear or tinted **KrystalKote™ Base Compound** until uniform, as outlined on *Base* label and **KrystalKote™ Data Sheet**. Do not mix by shaking. Acetone or M.E.K. may be added as a thinning agent, if needed to facilitate flow of sprayed **KrystalKote™**. Up to 5% for clear, and up to 10% for tinted **KrystalKote™**.
- 2.) Mix no more **KrystalKote™** than can be easily applied within @ 2-hours. Normal pot life is approximately 2- to 3-hours at 77°F. An "accelerator" is available to shorten cure time, but will also shorten pot life. A hot weather "retarder" is also available to lengthen pot life, but will also lengthen cure time. Additives and instructions are available from **TradeWinds International, Inc.**
- 3.) Flush equipment with appropriate solvent before use. Properly prime equipment with **KrystalKote™**.

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(continued)

- 4.) Apply **KrystalKote™** to @ 5-mil WFT in even parallel passes, overlapping @ 50% each pass, and cross spray at right angles, to avoid pinholes and thin areas (aka "holidays").
- 5.) Check wet coating thickness with WFT Gauge: 6-mil WFT will dry to @ 5-mil DFT; 5-mil WFT will dry to @ 4-mil DFT; and 4-mil WFT will dry to @ 3.5-mil DFT.
- 6.) Use caution when applying **KrystalKote™ clear** to avoid excessive WFT, which may cause clouding of clarity, especially with SATIN finish. Two thin coats are better than one heavy coat. A second coat may be applied when first coat is "tack dry" (tacky, but not wet) to "dry-to-touch". See CURE TABLE.
- 7.) Clean all equipment with Acetone, Lacquer Thinner, M.E.K., Toluene, or similar solvent, immediately after use.
- 8.) Wait at least 24-hours before pulling tape from dried clear coat. Always pull tape 90° from coating edge, and parallel to surface to assure razor-sharp edges. (Or immediately remove masking tape from surface while clear coat is still wet, but do not allow wet masking tape to touch any surface. Roll wet tape around small box, or ball of newspaper.)
- 9.) With stock **KrystalKote™ Gloss, clear** compound for gymnasium floors, at 75°F, allow 24-hours before "light foot traffic"; and 72-hours before resuming normal use. Shorter cure times and corresponding application instructions are available from **TradeWinds International, Inc.**

KrystalKote™ is a pending registered trademarks of:

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