



A quick-drying, modified alkyd resin based primer with lead-free corrosion inhibitors. It has excellent anti corrosive property and provides economic advantages by decreasing the number of coatings. And it is widely used in marine and heavy duty coating industry.

Approved as a Fire Retardant Coating by Lloyd's Register of Shipping (LR), Korean Register of Shipping (KR), Det Norske Veritas (DNV, CE Marking) and Germanischer Lloyd (GL)

Recommended use	High build anti-corrosive primer for non-immersed steel structures of vessels and other projects which are subjected to expose to moderate and severe atmosphere such as coastal and marine environments
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Physical Properties

Finish and Color	Flat. L/Grey (1105), Red (2272) For application where light color topcoats are used or only one topcoat application is specified, use grey to facilitate better hiding from the topcoat
Specific gravity	Approx. 1.3
Solids by volume	Approx. 44 % (Determined by ISO 3233)
Spreading rate (Theoretical)	6.28 m ² /L in 70 μm dry film thickness on a smooth surface.
Flash point	MP120 : 31 °C / 88 °F (Closed cup)
VOC	Max. 463g/L (Determined by ISO 11890-1)

Application details

Surface preparation	Remove any oil, grease, dirt and any other contaminants from the surface before painting by proper method such as solvent cleaning and fresh water washing, etc. * Steel : Blast cleaning to Sa2.5 or Power tool cleaning to St3, St2, etc.			
Preceding coat	According to specification.			
Method of application	Spray (Airless or Air), Roller or Brush application. For airless spray application ; Nozzle orifice : 533μm ~ 584 μm (0.021" ~ 0.023") Output pressure : 11.7 ~ 19.7 MPa Fan : 40° ~ 60° (Airless spray data are indicative and subject to adjustment)			
Mixing	One-component			
Thinning	Thinner No. 002 Thinning Ratio : Max. 5% (by volume) * Please consult the KCC TSD for advice in severe conditions.			
Application conditions	The surface should be adequately clean and dry. Do not apply when relative humidity is above 85 %. The surface temperature should be at least 3 °C (5 °F) above dew point to prevent condensation. In confined areas, ventilate with clean air during application to assist solvent evaporation.			
Film thickness	70 μm dry. Depending on the purpose and the area of use, different film thickness may be applied.			
Drying time	Substrate temperature	5 °C/41 °F	20 °C/68 °F	30 °C/86 °F
	Set to touch	6h	2h	1h
	Dry through	12h	4h	3h

	* These are the results from laboratory tests done under standardized conditions. Thus, actual times may be different due to environment situations such as weather, wind and humidity, etc
Subsequent Coat	Koramel Enamel LT313 or according to specification.
Pot life	One-component
Recoating interval	At 20 °C/68 °F, Minimum : 8 h Maximum : Free Before overcoating, remove the oil, salt, chalking material and any other contaminants on aged coating film completely by proper cleaning method such as solvent cleaning and/or fresh water washing.
Heat resistance temperature	Continuous : 93 °C/200 °F (Non-immersion service) Non-continuous : 121 °C/250 °F (Non-immersion service)

Storage and package	
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Shelf life	MP120 : 36 months (at 23 °C/73.4°F)
Packing Unit	18 L, 4 L

Remarks	
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Note	Do not store at temperature below 5 °C/41 °F or above 40 °C/104 °F. Protect skin and eyes from direct contact with liquid paint, and avoid prolonged breathing of solvent vapors. Use with adequate ventilation. Adequate ventilation with clean air should be maintained during application and curing to assist solvent evaporation. Respiratory protection is recommended when applying this product in confined spaces or stagnant air.
1'st issue	2012-03-01
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Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.

