Product Description
An alkyd resin based finish coat for ships and steel structures. It has outstanding resistance against exposure to sunlight, seawater, mineral oil and withstands temperatures as normally existing on water cooled blocks, etc. Approved as a Fire Retardant Coating by Lloyd's Register of Shipping (LR), Nippon Kaiji Kyokai (NK), Korean Register of Shipping (KR), Det Norske Veritas (DNV, CE Marking) and Germanishier Lloyd (GL).

Recommended Use
As a finishing coat in engine rooms, including main engines and auxiliary machinery. As a general purpose finish on interior surfaces. Also usable on exterior steel surfaces in moderately corrosive environment, including ship’s superstructure.

Physical Properties

<table>
<thead>
<tr>
<th>Finish and Color</th>
<th>Semi-gloss</th>
<th>White (1000), Red Brown (2260), Green (4440)</th>
</tr>
</thead>
</table>
* For more available color, consult with KCC’s business department.

<table>
<thead>
<tr>
<th>Drying Time</th>
<th>Substrate temperature</th>
<th>5 °C/41 °F</th>
<th>20 °C/68 °F</th>
<th>30 °C/86 °F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Set to touch</td>
<td>8 h</td>
<td>2 h</td>
<td>1 h</td>
<td></td>
</tr>
<tr>
<td>Dry through</td>
<td>36 h</td>
<td>8 h</td>
<td>7 h</td>
<td></td>
</tr>
</tbody>
</table>
* The actual drying time is subject to the film thickness, ventilation, humidity etc., and drying time under other temperature conditions should be checked and informed by KCC.

Solids by Volume
Approx. 48 % (Determined by ISO 3233)

Theoretical Spreading Rate
12.0 m²/L in 40 μm dry film thickness on a smooth surface.

Specific Gravity
Approx. 1.2

Flash Point
38 °C/100 °F (Closed cup)

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.

Application Conditions
The surface should be completely cleaned and dried. Do not apply when relative humidity is above 85 %. The surface temperature should be at least 2.7 °C (5 °F) above dew point to prevent condensation. In confined areas, ventilate with clean air during application to assist solvent evaporation.

Preceding Coat
Koramel Primer H.B. MP120, Koramel Primer MP125, or according to specification.

Thinning
Thinner No. 002

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.
Koramel Enamel    LT313

**Application Method**

Spray (Airless or Air), Roller or Brush application.

For airless spray application:
- Nozzle orifice: 432 μm ~ 584 μm (0.017” ~ 0.023”)
- Output pressure: 14.5 MPa
- Fan: 40 ° ~ 60 °

(Airless spray data are indicative and subject to adjustment)

**Typical Film Thickness**

40 μm dry.

**Recoating Interval**

At 20 ℃/68 ℉, Minimum: 6h
Maximum: Free (For with itself and epoxy primer)

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.

Also, if the film

**Shelf Life**

12 months

**Heat Resistance**

Continuous: 93 ℃/200 ℉ (Non-immersion service)
Non-continuous: 121 ℃/250 ℉ (Non-immersion service)

<table>
<thead>
<tr>
<th>Chemical Resistance</th>
<th>Acids</th>
<th>Alkalis</th>
<th>Solvents</th>
<th>Salts</th>
<th>Water</th>
</tr>
</thead>
<tbody>
<tr>
<td>Splash &amp; Spillage</td>
<td>NR</td>
<td>NR</td>
<td>NR</td>
<td>Good</td>
<td>Excellent</td>
</tr>
<tr>
<td>Fumes</td>
<td>Poor</td>
<td>Poor</td>
<td>Poor</td>
<td>Good</td>
<td>Excellent</td>
</tr>
<tr>
<td>Immersion</td>
<td>NR</td>
<td>NR</td>
<td>NR</td>
<td>NR</td>
<td>NR</td>
</tr>
</tbody>
</table>

* NR: Not Recommended.

**Standard Packing Unit**

18 L, 4 L

**Remarks**

Protect skin and eyes from direct contact with liquid paint, and avoid prolonged breathing of solvent vapors. Use with adequate ventilation.
Respiratory protection is recommended during application in confined spaces or stagnant air.
Keep away from sparks and open flames.
May be specified in another film thickness than indicated depending on purpose, but this will influence drying time and over-coating interval.
Applying within the recommended film thickness range to avoid the lifting, wrinkling when Over-coating.

**Issued**

November 2016

**Revision**

November 2018

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