



PRODUCT DATA SHEET
KoraTex - 640
Waterborne Acrylic
Acrylic Maintenance Primer/Finish

GENERIC TYPE:

Waterborne Acrylic

DESCRIPTION: *KoraTex - 640* A versatile, 100% acrylic, industrial grade primer or finish coat. It has outstanding adhesion to a variety of surfaces and contains corrosion inhibitive pigments to minimize the formation of rust, providing long term protection against corrosive attack. When used as a finish coat, *KoraTex - 640* is non-yellowing with excellent durability, color retention and flexibility.

FEATURES:

- May be topcoated with a variety of coatings
- Excellent tie coat for high performance coatings
- Easily applied by brush, roller or spray
- Dries fast, recoat in 1 hour
- Seals in stains, adheres to hard smooth surfaces
- VOC compliant to current AIM regulations

RECOMMENDED USES:

Formulated for use as a primer/finish coat on bare or previously painted interior and exterior structural steel, steel storage tanks, galvanized metal, wood, aluminum, and masonry. As a Primer/Sealer and bonding agent for high performance coatings over a wide variety of substrates.

NOT RECOMMENDED FOR:

Do not use in immersion or untopcoated

SUBSTRATES:

Apply over properly prepared gypsum board, plaster, wood, masonry, ceramic, tile, metal, PVC, galvanized metal or other surfaces as recommended



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SPECIFICATION DATA

- **Solids Content By Volume:** 38% ± 2%
- **VOC Values As supplied:** 1.18 lbs/gal (141 g/l)
These are nominal values

• **Theoretical Coverage Rate per Gallon: ***

614 mil ft². (15.0 m²/l at 25 microns)

* Mixing and application losses will vary and must be taken into consideration when estimating job requirements.

• **Temperature Resistance (Non-Immersion)**

Continuous : 150 °F (66 °C)

Non-Continuous: 180 °F (82 °C)

• **Dry Film Thickness per Coat**

1 coat system: 1 - 2 mils (25 - 50 microns)

Dry film thickness in excess of 3 mils (75 microns) per coat is not recommended.

• **Color Standard in :** Translucent White Only

• **Gloss:** Satin

• **Shelf Life :** Twelve months when stored at 75 °F (25 °C)

Storage Conditions: Store indoors.

Temp.: 40 - 110 °F (4 -43 °C)

Humidity: 0 - 100%

PRIMERS:

Typically self-priming or used as a tie-coat. **KoraTex - 640** can also be applied over Inorganic Zinc primers as an intermediate coat. A mist coat may be required to minimize bubbling over the Inorganic Zinc primers.

COMPATIBLE COATINGS:

May be applied over and topcoated with alkyds, acrylic latexes, acrylics, epoxies, polyesters, polyurethanes or others as recommended. Consult **SanyChem** Technical Service Department for specific recommendation.

APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions, and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

Substrates & Surface Preparation

General:

All surfaces must be cured, clean, sound and free of all dirt, dust, efflorescence, wax, oil, grease, chalk and any other contamination that would interfere with new coating adhesion. Bare surfaces must be properly prepared prior to application of this product. Remove oil, grease or wax with **SolvenSany # 276**.

Wood Surfaces: Sand smooth any exposed wood surfaces. Patch nail holes and any imperfections with wood filler or putty and sand smooth. Remove sanding dust.

Ferrous Metal Surfaces: Abrasive blast new steel to SSPC-SP-6. Use proper abrasive to achieve an average of 1.5 to 2 mil profile. Blasted surfaces should be primed before flash rusting occurs. If blasting is not practical, remove loose rust and mill scale with hand or power abrading tools as per SSPC-SP-2 and SSPC-SP-3. Treat rust free, cold rolled steel with a metal cleaning and etching solution.

Masonry Surfaces: New concrete must cure for a minimum of 30 days at 72°F (22°C) prior to coating application. Level Poured concrete all surface projections and mortar spatters by stoning. Rake mortar joints clean and remove all Concrete block soluble salts.

New Galvanized & Aluminum Surfaces: Remove surface contamination or passivators by scrubbing with a cleaning & etching solution or blast per SSPC-SP-7 brush-off blast.

Previously Painted Metal Surfaces: Power or hand washing is recommended to remove contamination. If oil or grease is present, use of a cleaner/degreaser is required. All cleaning residue must be completely rinsed from the surface. Allow to dry. Remove all loose coatings, rust and corrosion by scraping, sanding or other abrading method as per SSPC-SP-2 and SSPC-SP-3, or abrasive blast according to SSPC-SP-6 commercial blast. Use sandpaper to dull slick, glossy and/or non-porous surfaces with sandpaper.

Thinning: Thinning not normally required. **KoraTex - 640** is designed to be used as supplied. If thinning is necessary, use only clean potable water and no more than 12 oz/gal.

Application Equipment

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results. The following equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Conventional Spray : Pressure pot equipped with dual regulators, 3/8" I.D. Minimum material hose, 0.43" I.D. Fluid tip and appropriate air cap.

Airless Spray : Flush airless lines with water. Equipment must be clean prior to start. Apply the product in even coats and maintain a wet edge. Use multiple passes to achieve film build. Allow the product to dry between coats. Pump Ratio: 30:1 (min)

<i>Tip Orifice</i>	<i>Atomizing Pressure</i>	<i>Mat'l Hose ID</i>	<i>Manifold Filter</i>
0.015" to 0.017"	2800 - 3000 PSI	1/4" - 3/8"	60 mesh

Brush or Roller: A good quality synthetic brush will make application easier. Select a roller cover suited for the texture of the surface to be coated. Apply product in full even coats. Maintain a wet edge. To insure adequate film build, two coats are recommended when applying by brush or roller (see the drying times chart for recoat period).

Contact



For information and Prices, Please Call a SANYCHEM Local Sales Representative.

Phones:



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APPLICATION CONDITIONS

	Material	Surfaces	Ambient	Humidity
Normal	60 – 90 °F (16 – 32 °C)	65 – 85 °F (18 – 29 °C)	65 – 90 °F (16 – 32 °C)	10 – 80 %
Minimum	45 °F (7 °C)	50 °F (10 °C)	50 °F (10 °C)	0 %
Maximum	105 °F (41 °C)	130 °F (54 °C)	110 °F (43 °C)	85 %

Do not apply when the surface temperature is less than 5 °F or 3 °C above the dew point.

DRYING TIMES

Surface Temp. & 50% RH	Touch / Handle	Topcoat with		Full Cured
		Waterbase	Solvent Base	
50 °F (10 °C)	3 hrs	12 hrs	60 hrs	28 days
60 °F (16 °C)	3 hrs	4 hrs	36 hrs	14 days
75 °F (24 °C)	1 hr	1 hr	24 hrs	7 days
90 °F (32 °C)	1 hr	1 hr	18 hrs	4 days

These times are based on a 1 mil per coat (25 microns) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times.

Cleanup & Safety

Cleanup: Spray equipment should be flushed with water followed by mineral spirits. Brushes and rollers should be cleaned immediately after use with soap and water. If **KoraTex - 640** dries before it is cleaned up, use a heavy-duty ammoniated household cleaner and rinse thoroughly with water. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety : Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use. Paint Products contain chemical ingredients which are considered hazardous. Prior to use, read container label warnings and the current Material Safety Data Sheet for important health and safety information. Insure these instructions are practiced during product application and cure. **Keep out of the reach of children.**



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