FEATURES:

- Alkyd-like hardness and durability
- Excellent Semi-gloss and color retention
- Low odor and water clean-up
- Excellent flow and leveling
- High hiding
- Non-yellowing
- Washable and scrubbable with mild detergents
- Rapid dry - minimum downtime in plant operations
- Bonds to glossy surfaces without sanding
- Easy application - brush, roll or spray
- All purpose finish for multiple surfaces
- Highly flexible - resists peeling and chipping
- Low VOC
- Dry fall properties (see Application for details)
- Performance alternate for Federal Specification TT-E-2784
- Good application over Inorganic Zinc

RECOMMENDED USES:

This all purpose, non-yellowing finish is ideal for use on walls, equipment, machinery, piping, structural steel, storage tanks, wood or metal trim, shutters, building exteriors, prefished siding, furniture and metal fences. As a topcoat for ZinCoat (Inorganic Zinc Primers), when used over steel substrate. Kora Tex-680 is ideal for protection of concrete or masonry in new or maintenance applications.

NOT RECOMMENDED FOR:

Immersion Service, Direct or indirect exposure to acids or alkalies without a suitable topcoat. Containment of aromatic solvents, strong mineral and organic acid or severely corrosive materials.

COMPATIBLE COATINGS:

May be applied over most tightly adhering coatings. ZinCoat series Primers, SanyMastics and other as recommended. For specific topcoat recommendations, please consult your SanyChem Technical Service.

NOTE: A mist coat or tie is required to minimize topcoat bubbling.

ORDER INFORMATION: Prices may be obtained from SanyChem Sales Representative or main Office.

APPROXIMATE SHIPPING WEIGHT:

<table>
<thead>
<tr>
<th>Freight Classification: Paint</th>
<th>1 gallon</th>
<th>5 gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>KoraTex-680</td>
<td>12.0 lbs</td>
<td>55.0 lbs</td>
</tr>
</tbody>
</table>

FLASH POINT (Pensky/Martens Closed Cup):

<table>
<thead>
<tr>
<th>Exposure</th>
<th>Splash &amp; Spillage</th>
<th>Fumes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Acids</td>
<td>Fair</td>
<td>Good</td>
</tr>
<tr>
<td>Alkalies</td>
<td>Good</td>
<td>Excellent</td>
</tr>
<tr>
<td>Solvents</td>
<td>N/R</td>
<td>Very Good</td>
</tr>
<tr>
<td>Water</td>
<td>Very Good</td>
<td>Excellent</td>
</tr>
<tr>
<td>Salt</td>
<td>Very Good</td>
<td>Excellent</td>
</tr>
</tbody>
</table>

KoraTex-680

> 93 °C

January 2001 replaces April 1998

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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: Remove any oil or grease from surface to be coated with clean rags soaked in SolvenSany® 252 Thinner or Meta/Cleaner # 100 in accordance with SSPC-SP-1.

Steel: Apply over clean, dry, recommended primers.

Concrete, Plaster and Masonry – Must cure at least 30 days before painting. pH must be 10.0 or lower. Roughen slick poured or precast concrete and remove sealers by chemical cleaning or abrasive method such as sandseeping. Rinse thoroughly with water and allow to dry. Remove loose aggregate. Can be applied direct to concrete where an uneven surface can be tolerated. Remove laitance by abrasive blasting or other means.

Previously Painted Surfaces: Wash to remove contaminants. Rinse thoroughly with water and allow to dry. Sanding is not required if the surface is properly and thoroughly cleaned (scuff sanding is required only on glossy, hard, slick or dense surfaces which are subject to high levels of moisture). Remove loose paint. Scrub heavy chalk exterior areas and overhead areas such as eaves with soap and water. All existing mildew must be removed by washing with a solution of 16 oz. (473 mL) liquid household bleach and two oz (59 mL) non ammoniated liquid detergent per gallon (3.785 L) of water. Rinse surfaces clean with water and allow to dry for 24 hours. Prime bare areas with primer specified under New Surfaces. May be used self primed over previously painted interior surfaces.

Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as properly fitted respirator (NIOSH approved) and proper containment and cleanup. For additional information, contact the USEPA/Lead Information Hotline at 1-800-424-LEAD.

Washing Instructions: Do not wash in less than seven days after application. Use a non-abrasive, mild detergent and water and a cellulose sponge. Do not attempt to clean the dried film with cleaners that contain ammonia and/or solvent such as window, tile or appliance cleaners.

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

SanyChem, Inc
680 N Pine Island Road # 450 Plantation, FL 33344-1311
Phone +1-954-315-0252 / FAX +1-954-315-0280
sanychem@cantv.net
sales@sanychem.com

APPLICATION TEMPERATURES

<table>
<thead>
<tr>
<th>Conditions</th>
<th>Material</th>
<th>Surfaces</th>
<th>Ambient</th>
<th>Humidity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Normal</td>
<td>16-32 °C</td>
<td>18 -29 °C</td>
<td>18–32 °C</td>
<td>10-80%</td>
</tr>
<tr>
<td>Minimum</td>
<td>10 °C</td>
<td>10 °C</td>
<td>10 °C</td>
<td>0 %</td>
</tr>
<tr>
<td>Maximum</td>
<td>40 °C</td>
<td>54 °C</td>
<td>43 °C</td>
<td>85 %</td>
</tr>
</tbody>
</table>

Do not apply when the surface temperature is less than 2 °C above the dew point.

Brush: Use a synthetic bristle brush. Two coats will be required in order to achieve desired film thickness and acceptable hiding.

Roller: Use a short woven nap synthetic roller and apply over smooth wall surfaces and smooth concrete. For rough surfaces, cinder block or very porous surfaces, use a 3/8” woven nap synthetic roller. Multiple coats may be required for uniform hiding and film thickness over rough surfaces.

Cleanup & Safety

Cleanup Use Clean potable water. In case of spillage, absorb and dispose of in accordance with local applicable regulations. Clean immediately with warm, soapy water.

WARNING! HARMFUL OR FATAL IF SWALLOWED. ASPIRATION HAZARD-CAN ENTER LUNGS AND CAUSE DAMAGE. HARMFUL IF INHALED. MAY CAUSE CENTRAL NERVOUS SYSTEM EFFECTS, INCLUDING DIZZINESS, HEADACHE OR NAUSEA. CAUSES EYE, SKIN AND RESPIRATORY TRACT IRRITATION. CAUSES EYE BURNS. CONTAINS CRYSTALLINE SILICA WHICH CAN CAUSE LUNG CANCER AND OTHER LUNG DAMAGE IF INHALED. OVEREXPOSURE MAY CAUSE BLOOD, LIVER, KIDNEY DAMAGE. USE ONLY WITH ADEQUATE VENTILATION. KEEP OUT OF THE REACH OF CHILDREN.

NOTICE: Products in this series contain solvents. Reports have associated repeated and prolonged occupational exposure over exposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal. Products in this series may contain chemicals subject to California Proposition 65. If sanding is done, wear a dust mask to avoid breathing of sanding dust. Do not breathe vapors or spray mist. If you experience eye watering, headaches, or dizziness, leave the area. If properly used, a respirator may offer additional protection. Obtain professional advice before using. Close container after each use. FIRST AID: In case of skin contact, wash off quickly with plenty of soap and water, remove contaminated clothing. For eye contact flush immediately with large amounts of water, for at least 15 minutes. Obtain emergency medical treatment. If swallowed, obtain medical treatment immediately. If inhalation causes physical discomfort, remove to fresh air. If discomfort persists or any breathing difficulty occurs, get medical help. KEEP FROM FREEZING. Note: These warnings encompass the product series. Prior to use, read and follow product-specific MSDS and label information.

FOR INDUSTRIAL USE ONLY. KEEP AWAY FROM CHILDREN. 1/2001

Temperature & 50% R.H. Between Coats Full Cure

<table>
<thead>
<tr>
<th>Temperature</th>
<th>10 °C</th>
<th>16 °C</th>
<th>24 °C</th>
<th>32 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>8 hours</td>
<td>4 hours</td>
<td>2 hour</td>
<td>1 hour</td>
<td>60 hours</td>
</tr>
</tbody>
</table>

These times are based on recommended dry film thickness. High humidity, high film thickness or cooler temperatures will lengthen dry to handle/topcoat and final cure due to slower water evaporation rate.