



PALGARD® EPOXY

K-VS3400 Series (Part A)

K-S3496 Satin Activator (Part B)

K-S3498 Gloss Activator (Part B)

K-S3415 Clear

Palgard Epoxy is an interior/exterior, two-component polyamide-cured epoxy that protects steel and concrete in industrial environments. Formulated for use on interior and exterior surfaces of steel, iron, aluminum, galvanized metal, concrete block and masonry.

- ✓ Excellent adhesion
- ✓ Chemical and abrasion resistant
- ✓ Interior/exterior use
- ✓ Suitable for use in
USDA-inspected facilities

INDUSTRIAL USE ONLY!

AS OF 01/01/2016 COMPLIES WITH:

- | | |
|---|---|
| ☒ OTC | ☐ CARB |
| ☒ EC | ☒ LADCO |
| ☐ SCAQMD | K-S3496, K-S3498 |

*Clear is not compliant in OTC, LADCO and Canada

krylonindustrial.com

1-800-247-3266

Revised June 2016

RECOMMENDED USES

- | | | |
|---------|--------------------|------------------|
| • Steel | • Aluminum | • Concrete Block |
| • Iron | • Galvanized Metal | • Masonry |

RECOMMENDED SYSTEMS

Steel, Iron, Aluminum, Galvanized Metal:

1 coat Krylon® Industrial
Iron Guard® Primer

2 coats Krylon Industrial
Palgard Epoxy

Masonry:

1 coat Iron Guard Primer

2 coats Palgard Epoxy

Concrete Block:

1 coat Acrylic Block Filler

2 coats Palgard Epoxy

SURFACE PREPARATION

WARNING! 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 brain damage or other 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 a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in U.S.) or contact your local health authority.

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion. **Do not use hydrocarbon solvents for cleaning.**

IRON AND STEEL:

Minimum surface preparation is Hand Tool Clean SSPC-SP2. Remove all oil and grease from surface per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3. Primer recommended for best performance.

ALUMINUM:

Remove all oil, grease, dirt, oxide and other foreign material per SSPC-SP1.

GALVANIZED METAL:

Surface should be exterior weathered for 6 months prior to painting. Remove all oil and grease per SSPC-SP1. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2. Prime clean area the same day with Iron Guard Primer.

PREVIOUSLY PAINTED SURFACES:

If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface.

MIXING INSTRUCTIONS

Mix contents of each component thoroughly with power agitation. Make certain no pigment remains on the bottom of the can. Then combine one part by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated prior to application. Re-stir before using. If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.

CLEAN-UP

Clean spills and spatters immediately with lacquer thinner. Follow manufacturer's safety recommendations when using any solvents.

TECHNICAL DATA

Vehicle	Polyamide Epoxy
Finish	Gloss (80+ units @ 60°F)
Flash Point	101°F, PMCC, mixed
Volume Solids	53 ± 2% (based on VS3491 Part A white/base 1)
Weight Solids	65 ± 2% (based on VS3491 Part A white/base 1)
Weight/Gallon	12.7 lb/gal (based on VS3491 Part A white/base 1)
VOC (less exempt solvents)	K-S3496 & K-S3498 mixed: 324 g/L, 2.7 lb/gal
	K-S3415 mixed: 434 g/L, 3.62 lb/gal
Mix Ratio	1:1 by volume of Part A to Part B (K-S3498 or K-S3496)
Rec. Film Thickness	4–6 mils wet
	2.1–3.2 mils dry
Spread Rate	400–530 ft ² /gal
Application	Apply by airless spray, brush or roller
Drying Time	@77°F, 50% RH
	Drying times are temperature and humidity dependent. If maximum recoat time is exceeded, abrade surface before recoating.
To Touch	3 hours
To Handle	16 hours
To Recoat	Min 16 hours
	Max 2 weeks
To Cure	7 days
Pot Life	8 hours
Sweat-In Time	30 mins
Reduction	Lacquer thinner
Cleanup	Lacquer thinner
Tinting	BAC®, Charisma™, GeoShades™ B3, Pratt & Lambert®
Sizes	1 Gallon

APPLICATION

Temperature	(air, surface and material)
	40°F min, at least 5°F above the dew point
Relative Humidity	85% max
Reducer/Cleanup	Lacquer thinner
Airless Spray	
	Pressure 2000–2200 psi
	Tip .017"–.019"
	Reduction Not Recommended

APPLICATION CONTINUED

Conventional Spray	
Fluid Cap	66
Air Nozzle	69PB
Atomization Pressure	55–65 psi
Fluid Pressure	10–20 psi
Reduction	Not Recommended
Brush	
Brush	Nylon/polyester or natural bristle
Reduction	Not recommended
Roller	
Cover	3/8" woven with solvent-resistant core
Reduction	Not recommended



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The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of Krylon® Industrial. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Krylon® Industrial dealer or representative to obtain the most recent Product Data Sheet.