

KilnCoat 2100

SPRAY APPLICATION GUIDE



APPLICATION EQUIPMENT:*

Use spray equipment similar to Graco TexSpray HTX2030 with equivalent texture spray gun HTX2030 Trigger Gun Applicator (Part #24R054).

Compress Air: 80-110 psi

SURFACE PREPARATION:

Steel surfaces are to be abrasive blasted to SSPC-SP 10 / NACE No. 2 Near-White Metal Blast Cleaning. Abrasive blasted surfaces must be profiled to no less than 3.0 mils / 75 microns.

APPLICATION:

Permissible temperatures during application should not exceed the following:

Material: 50 to 90°F (10 to 32°C)

Ambient: 50 to 100°F (10 to 38°C)

Substrate: 50 to 100°F (10 to 38°C)

Upon opening, KilnCoat 2100 should be thoroughly mixed using a drill motor and paint mixer attachment suitable for 5 gallon pails for a minimum period of 1 minute. KilnCoat 2100 should be subsequently re-mixed for a minimum of 30 seconds after pails have sat unused for over 1 hour.

The recommended spray equipment has the ability to apply KilnCoat 2100 from a distance of 18" to 60" (46 to 153 cm) depending on pump throttle and air assist adjustment. Set up equipment according to manufacturers recommendations. Pre-mixed KilnCoat 2100 may be inserted under the short siphon at the front of the spray gun.

When beginning to apply KilnCoat 2100 for the first time, set the Pump Throttle to the lowest setting. Turn the switch on the pump to Remote allowing the operator to control the flow of material from the spray gun. Always hold the trigger of the gun open before switching the pump ON. When pausing from spray activity, turn the pump switch OFF before releasing the gun trigger. This method will prevent excessive pressure build-up within the spray gun. When operator has become comfortable using the equipment in the prescribed manor, he may increase material flow in small increments by adjusting the pump

throttle to higher setting. The air adjustment knob at the base of the gun controls the atomization of the KilnCoat 2100. The more airflow the finer the spray (less texture). We recommend starting with the air flow near full stream. In Summary: Pump Throttle should be at the lowest setting /Air Feed at the gun should be set close to high. Adjust according to operator skill.

CLEANING:

Flush the entire system with clean tap water until no residue appears. Be sure to remove and clean Spray Disc on gun and flush both Drain Valve and Ball Valve on the pump. When system is flushed clean, cycle through Mineral Spirits to dry and lubricate the equipment. Never use any solvent more aggressive than Mineral Spirits on spray equipment.

SPARE PARTS/MAINTENANCE:

Fine Finish Tip Kit (Part # 287227)

Replacement Spray Disc C / 8mm (Part # 248311) Additional Spray Disc for above kit (Estimate 1 ea. *Spray Disc* per 1000 gallons KilnCoat 2100.

NOTE: *Spray Disc* is reversible.

Pump Repair Kit: (Part# 235186)

Throat Seal Oil: 1 US Quart (Part # 206995)

During use, when operator begins to feel pressure drop in Graco 2030 pump, shut down rig and replace components contained within Pump Repair Kit (Part # 235186) immediately. Otherwise, risk additional damage to spray equipment.

STORAGE:

DO NOT store KilnCoat 2100 at or below freezing temperatures.

READ SDS SHEET BEFORE USE • MANUFACTURED FOR

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KEEP OUT OF THE REACH OF CHILDREN • MADE IN U.S.A.

* It is not recommended to install KilnCoat 2100 manually in large areas. When necessary, for joints and repairs, KilnCoat 2100 may be applied in multiple coats using a medium to long nap roller. Allow 12-24 hours cure time between coats.