KCC Corporation
Head Office: 1301-4, Seocho-Dong, Seocho-Ku, Seoul, Korea

KOPATCH PC270

AMINE CURED EPOXY COATING FOR REPAIRING

KOPATCH PC270 is two components, amine cured epoxy based coating with excellent adhesion, anticorrosion resistance, high build, solvent free coating for use on steel substrate. Widely used as a repair for protection of internal and external pipelines.

1. PHYSICAL PROPERTIES

Property	Result
Color	Grey
Thickness	1 Coat System : Min. 600㎛
Solids Content	98±2% (by Volume)
Theoretical Coverage Rate	1.7m^2 @ 25°C (600㎛)

2. SURFACE & SUBSTRATE PREPARATION

• Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.

• Roughen or grind the surrounding area to reach out to the steel substrate.

• Feathered out the parent coating one centimeter around the area that requires to be repaired.

3. APPLICATION EQUIPMENT

1) Cartridge

2) Spatula

4. CURE SCHEDULE

Surface Temp (50%RH) .	Dry of Recoat	Maximum Recoat Time	Final Cure for Immersion Service
16°C	20 hours	2 days	96 hours
24°C	3 hours	1 days	36 hours
32°C	2 hours	16 hours	24 hours

These times are based on a DFT 600㎛. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times. Condensation on the surface or humidity above 25% during application and curing will result in a surface haze or blush. Any haze or blush must be removed by water washing before recoating. During high humidity conditions, it is recommended that the application be done while temperatures are increasing. If the maximum recoat time is exceeded, the surface must be washed with solvent, then abraded by sweep blasting prior to the application of additional coats.

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5. APPLICATION DETAILS

Property	Details
Application Conditions	<table><tr><td>Condition</td><td>Material</td><td>Surface</td><td>Ambient</td><td>Humidity</td></tr><tr><td>Normal</td><td>16~29°C</td><td>16~29°C</td><td>16~32°C</td><td>30~80%</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>32°C</td><td>52°C</td><td>43°C</td><td>90%</td></tr></table> This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperature below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.
Mixing & Thinning	① Thoroughly mix combined parts into a uniform color ② Thinning - Not recommended ③ Pot life : Approx. 10 min. @ 24°C Pot life ends when material begins to thicken and starts to heat up. Pot life times will be less at higher temperatures
Storage	Store indoors
Storage temp. & Humidity	4~40°C (0~100% Relative Humidity)
Packaging	50ml Cartridge
Shelf life	18 months @ 24°C

6. Notice

- The information is believed to be accurate without any obligation to KCC Corporation.
- Read Material Safety Data Sheet for complete hazard and safety information.
- All data are based on laboratory testing and practical experience.
- Contact your KCC sales representative for more information.

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