



Koramel Primer MP125

Product Description A lead free alkyd based quick drying primer containing zinc phosphate.

Recommended Use General purpose primer on well cleaned steel surface in mildly to moderately corrosive atmosphere, interior and exterior, including coastal and marine environments.
Not suitable for permanent immersion service.

Physical Properties

Finish and Color Flat. Green (4433), Red (2272)

Drying Time	Substrate temperature	5 °C/41 °F	20 °C/68 °F	30 °C/86 °F
	Set to touch	6 h	2 h	1 h
Dry through	12 h	4 h	3 h	

* The actual drying time is subject to the film thickness, ventilation, humidity etc., and drying time under other temperature conditions should be checked and informed by KCC.

Solids by Volume Approx. 48 % (Determined by ISO 3233)

Theoretical Spreading Rate 9.6 m²/L in 50 μm dry film thickness on a smooth surface.

Specific Gravity Approx. 1.3

Flash Point 35 °C/96 °F (Closed cup)

Application Details

Surface Preparation Remove any oil, grease, dirt and any other contaminants from the surface before painting by proper method such as solvent cleaning and fresh water washing, etc.
* Steel : Blast cleaning to Sa 2.5 or Power tool cleaning to St3, St2, etc.

Application Conditions The surface should be completely cleaned and dried. Do not apply when relative humidity is above 85 %. The surface temperature should be at least 2.7 °C (5 °F) above dew point to prevent condensation. In confined, areas, ventilate with clean air during application and drying to assist solvent evaporation.

Thinning For spray application : Thinner No. 002 or No. 012
For brush and roller application : Thinner No. 012

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Application Method Spray (Airless or Air), Roller or Brush application.
For airless spray application ;
Nozzle orifice : 432 μm ~ 584 μm (0.017" ~ 0.023")
Output pressure : 14.5 MPa
Fan : 60 °
(Airless spray data are indicative and subject to adjustment)

Typical Film Thickness 40 μm dry.
Depending on the purpose and the area of use, different film thickness may be applied.

Recoating Interval At 20 °C/68 °F, Minimum : 8 h
Maximum : Free

Before overcoating, remove the oil, salt, chalking material and any other contaminants on aged coating film completely by proper cleaning method such as solvent cleaning and/or fresh water washing.

Subsequent Coat Koramel Undercoating LU216, Koramel Enamel LT313, or according to specification.
For application where light color topcoats are used or only one topcoat application is specified, use gray to facilitate better hiding from the topcoat.

Shelf Life 12 months

Heat Resistance Continuous : 93 °C/200 °F (Non-immersion service)
Non-continuous : 121 °C/250 °F (Non-immersion service)

Chemical Resistance

	Acids	Alkalis	Solvents	Salts	Water
Splash & Spillage	NR	NR	NR	Good	Excellent
Fumes	Poor	Poor	Poor	Fair	Excellent
Immersion	NR	NR	NR	NR	NR

* NR : Not Recommended

Standard Packing Unit 18 L, 20 L

Remarks Protect skin and eyes, and avoid prolonged breathing of solvent vapors.
Use with adequate ventilation.
Respiratory protection is recommended when applying this material in confined spaces or stagnant air.

Issued April 2009