



NEW
KG 3400 Series Ceramic Fill
Protective Coatings

KG's 3400 CF coating is a cost effective **One-Part** coating, which is balanced to provide excellent scratch resistance, impact resistance, abrasion resistance, and good corrosion resistance, while still providing heat dissipation. The 3400 Series comes in Flat colors only.

Industries such as motor sports, glass manufacturing, agriculture, firearms, decorative metal manufactures and oil/petrol companies are just some of the industries where the 3400 can be used.

Pre-Treatment: All substrates should be pretreated prior to coating, by blasting with 100 to 120--grit aluminum oxide to correct the surface profile. Degrease and then K-Phos. Air pressure should range from 40 to 60 pounds depending on substrate material followed by cleaning/degreasing. Care must be taken that components are handled with clean latex type gloves.

Care needs to be taken that the material is shaken or spun to reconstitute any residual sediment which has settled to the bottom of the can.

Thinning: 3400 is manufactured for spraying without thinning. However, if thinning is required (due to temperature or humidity) thinning to 10% by volume with a 50/50 mix of MEK and Alcohol is suitable.

Application and Spray Techniques: KG CF3400 has been formulated to be applied with conventional type or HVLP Spray equipment.

Normal atomizing pressure ranges between 25 and 30 PSI.

When handling parts, use a pair of clean white, powder free latex type gloves to insure you do not leave any fingerprints, which will affect the bonding of the material to the metal. Using a good quality air gun or airbrush, spray in light passes, 8 to 10 inches away from the part you are coating. Spray from four to five different directions to assure complete coverage. Place coated parts in curing oven. Bake at 325 to 350F for two hours (metal temperature).

Cured Film Properties:

| | |
|---------------------------------------|--|
| Recommended cured film thickness: | .0003 to .0007. Coating thickness may be increased by spraying additional coats. |
| Constant Operating Temperature Range: | +500 |
| Hardness: | >9H |
| Salt Spray: | In Testing |

Product Specifications:

| | |
|--------------------------------|--|
| Shelf Life: | 12 months in sealed containers and periodically shaken. |
| Solid Content: | 15% (by weight) |
| Appearance: | Smooth silk feel flat finish |
| Color: | Several colors are available. |
| Spray Guns: | Conventional or HVLP manual or automatic |
| Optimum Cure temp.: | 325 to 350 Fahrenheit for 2 hours (Metal Temperature). Baking longer at higher temperatures will make the coating harder but may cause color change. |
| Clean Up | MEK, Acetone |