



KORESTER PC4288 is a unsaturated polyester resin based coating and contains glass flakes which makes the film very resistant to penetration in aggressive environments. It shows excellent long term protection and resistance to water, impact and abrasion. Approved by NORSOK M-501(Rev.6) System No.7A.

<b>Recommended use</b>	Recommended as a protective coating for areas of requiring exceptional resistance to abrasion and corrosion such as offshore structure of splash zone, ship hulls and rudders.
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### Physical Properties

<b>Finish and Color</b>	Flat. Grey
<b>Specific gravity</b>	Approx. 1.1 ~ 1.3 for Mixture of Base and Curing agent.
<b>Solids by volume</b>	Approx. 97 % (Determined by ISO 3233)
<b>Spreading rate (Theoretical)</b>	1.29 m <sup>2</sup> /L in 750 μm dry film thickness on a smooth surface.
<b>Flash point</b>	Base [PC4288PTA] : 29 °C / 84 °F (Closed cup) Curing Agent [PC4288PTB] : 72 °C / 162 °F (Closed cup)

### Application details

<b>Surface preparation</b>	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. * Blast cleaning to minimum Sa2.5 for immersion and non-immersion.										
<b>Method of application</b>	Airless spray application ; Pump ratio : 66 : 1 Nozzle orifice : 483 mm ~ 686 μm (0.019" ~ 0.027") Output pressure : 26.4 MPa ~ 43.8 MPa Fan : 50 ~ 65 ° (Airless spray data are indicative and subject to adjustment)										
<b>Mixing</b>	BASE (PC4288PTA) : CURING AGENT (PC4288PTB) = 100 : 1.25 ~ 1.50 (by volume) * Choose peroxide and, if necessary, accelerator or inhibitor according to the table below. Accelerator or inhibitor (if used) must be thoroughly mixed with PC4288PTA before adding the required amount of peroxide(PC4288PTB).										
	<table border="1"> <thead> <tr> <th>Temperature</th> <th>Addition</th> </tr> </thead> <tbody> <tr> <td>10~15°C</td> <td>PC4288PTB 1.50 vol% + Accelerator 2 vol%</td> </tr> <tr> <td>15~20°C</td> <td>PC4288PTB 1.50 vol%</td> </tr> <tr> <td>20~30°C</td> <td>PC4288PTB 1.25 vol%</td> </tr> <tr> <td>30~40°C</td> <td>PC4288PTB 1.25 vol% +Inhibitor 0.75 vol%</td> </tr> </tbody> </table>	Temperature	Addition	10~15°C	PC4288PTB 1.50 vol% + Accelerator 2 vol%	15~20°C	PC4288PTB 1.50 vol%	20~30°C	PC4288PTB 1.25 vol%	30~40°C	PC4288PTB 1.25 vol% +Inhibitor 0.75 vol%
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	<p>※ Note : Check the temp. of pump during the application friction in piston any cause increase in temperature. If this happens, keep pump going to get out heated PC4288 as quickly as possible. Warning : curing agent and accelerator should not be mixed directly together.</p>										

<b>Thinning</b>	None. TH0288(if needed max. 3% )				
<b>Application conditions</b>	<p>The surface should be completely cleaned and dried.</p> <ul style="list-style-type: none"> <li>* Use only where application and curing can proceed at temperature above 10 °C / 50 °F and at relative humidity below 85 %.</li> <li>* The surface temperature should be at least 3 °C (5.4 °F) above dew point to prevent condensation.</li> <li>* Storage should be lower than 23 °C (73 °F) to ensure suitable application viscosity.</li> <li>* Paint application should be carried out the ambient and surface temperature conditions of over 10 °C / 50 °F. After application, the curing temperature must be at least above 10 °C / 50 °F to avoid film defects due to slow drying.</li> <li>* Keep the temperature specified for application and curing.</li> </ul>				
<b>Film thickness</b>	<p>750 µm dry.</p> <p>May be specified in another film thickness than indicated depending on purpose and area of use.</p> <p>All polyester resin is subject to shrinkage during the curing process. This results in a practical spreading rate lower than the theoretically dry film thickness.</p>				
<b>Drying time</b>	Substrate temperature	10°C / 50°F	20°C / 68°F	30°C / 86°F	40°C / 104°F
	Set to touch	2 h	2 h	1.5 h	1.5 h
	Dry through	10 h	10 h	6.5 h	5 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.				
<b>Pot life</b>	1 hr at 20 °C / 68 °F				
<b>Recoating interval</b>	<p>At 25 °C / 77 °F, Minimum : 8 hrs</p> <p>Maximum : 20 days (with itself)</p> <p>Prior to 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.</p>				

<b>Storage and package</b>	
<b>Shelf life</b>	6 months
<b>Storage</b>	Do not store at temperature above 23 °C / 73 °F.
<b>Packing Unit</b>	PC4288PTA : 16 L PC4288PTB : 0.2 L

<b>Remarks</b>	
<b>Note</b>	<p>Protect skin and eyes from direct contact with liquid paint, and avoid prolonged breathing of solvent vapors.</p> <p>Use with adequate ventilation.</p> <p>Respiratory protection is recommended when applying this product in confined spaces or stagnant air.</p>
<b>1'st issue</b>	2015-09-01
<b>Revision</b>	2016-04-01

Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.



