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GUIDELINES FOR APPLYING MODEL KDC-E-162 DAMPING COMPOUND

1. **Surface Preparation:** Substrate to be sprayed or troweled with KDC-E-162 Damping Compound should be free of all grease, oil, dirt, scale, excessive moisture, etc. If sandblasting is required, clean the surface afterwards to assure removal of oil film or dirt.

2. **Mixing:** Some separation of the compound can occur after six months. Materials should be mixed prior to use, if separation occurs.

It is not necessary to further thin the compound for application, but if desired, a small amount of water can be added, but it is cautioned to stir until thoroughly blended at a very slow rate of speed.

3. **Application:** Compound can be sprayed using an airless high-pressure pump. For large volume applications:

Pump Ratios 30:1 or larger
Tip Sizes, minimum: 0.041

A typical recommended system is a Graco 30:1 Xtreme airless pump and an X30 or larger nozzle, on a XTR –S airless spray gun (Model X30DH3-Pnematic or 16U288 Gas rig).

4. **Coverage and Thickness:** A coverage rate of 11.4 sq. ft./gal. is attained with a 9/64" wet thickness. At 1/8" wet thickness, the coverage is eight (8) gallons per 100 sq. ft. Coating should be applied at least 1 to 1-1/2 times the metal thickness to which it is applied to attain the greatest effectiveness of the damping action. If thicknesses of the damping compound are required that are greater than 1/8" thick, it is suggested that Model KDC-E-162 be applied in built-up coats with each coat being dry to the touch before the next is applied.

5. **Drying Time:** A 9/64" thick coating is dry to the touch within twelve (12) hours and completely air dries to a hard, firm surface in 24 to 40 hours. This drying time is under normal atmospheric conditions of temperature and humidity. If the temperature is cooler and humidity higher, a longer curing time will be necessary.

Drying time can be accelerated by the application of heat. The maximum recommended drying temperature is 150° F.

6. **Temperature and Storage Limitations:** Since this is a water-based emulsion, it is recommended that storage be made in areas above 40° F. Do not allow the compound to freeze. The recommended shelf life for KDC-E-162 is six months. The product could separate after six months but can be re-mixed.

7. **Clean Up:** Model KDC-E-162 Damping Compound can be cleaned from tools and surfaces with the use of water, immediately after application.

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