

CURE CYCLE:

The following standards may be used in assessing what activities can be carried out after an application of **Product #642**.

Temperature	75°F
Overcoating	1 to 2 hours
Movement/Light Stress	8 hours
Traffic Bearing	16 to 24 hours
Immersion/Full Chemical Exposure	5 days

Force cures may be used to enhance chemical resistance or to allow the coating to be placed in service before 5 days. Allow the coating a post cure to 12 to 24 hours before force curing.

RECOMMENDED FORCE CURE SCHEDULE

Minimum 2 hours @ 150°F

Maximum 4 hours @ 200°F

NOTE: this product will cure well at temperatures as low as 40-45 °F. However, additional curing time must be provided.

CHEMICAL RESISTANCE PROPERTIES:

ACIDS

Hydrochloric	10% to 35%
Sulfuric	10% to 98%
Nitric	45%

ALKALIES

Ammonia	10%
Sodium Hydroxide	10% to 50%

SALTS

Sodium Chloride	Excellent
Calcium Chloride	Excellent

SOLVENTS

Alcohols, acetone, toluol, methyl cellulose, methanol.

SURFACE PREPARATION:

Remove all grease, dirt and other contaminants from surface prior to sandblasting. Grind sharp edges to a radius of 1/8". Remove all weld splatters. Sandblast to a white metal finish according to SSPC-SP-5-63 or NACE standard TM-01-70 with a minimum anchor profile of 3 mils.

APPLICATION:

Product#642 can be applied by trowel or grout pump. **Product #642** is designed as a one coat system (minimum 45 mils, maximum 80 mils). Relative humidity during the coating process should be 90% or less. Substrate temperature should be a minimum of 60°F for application to commence. If a second coat is needed before the first coat cures, no surface preparation is needed. Simply apply the second coat maintaining the required standards. However, if the first coat has cured (when it is tack free) the first coat must be brush blasted prior to the second coat.

CAUTION:

Society of the Plastics Industry (SPI) Classification and Warning for "A" Components: **FOR INDUSTRIAL USE ONLY! WARNING!** May cause skin sensitization or other allergic responses. Avoid inhalation of vapor. Use good ventilation, particularly if the material is heated or sprayed. prevent all contact with skin or eyes. Wear protective clothing, goggles, gloves and/or barrier creams. If contact with skin occurs, wash immediately with soap and water. In case of contact with eyes, flush with water and contact a physician.

Manufacturing Chemists Association (MCA) Warning for "B" Components: **CAUTION! DANGER!** Causes severe burns. Contains alkaline amines; strong sensitizer. Do not get into eyes, on skin or clothing. Avoid breathing vapor. Keep container closed. Use with adequate ventilation. Wash thoroughly after handling. **FIRST AID!** In cases of contact, immediately flush eyes or skin with plenty of water for at least 15 minutes. Remove contaminated clothing and shoes. Call a physician. Wear protective clothing, goggles, gloves and/or barrier creams.

**FOR INDUSTRIAL USE ONLY!
KEEP AWAY FROM CHILDREN!**

For more information please contact:

Epoxy Systems, Inc.

Dunnellon, FL 34431

352-489-1666 (voice)

352-465-3497 (fax)

info@epoxy.com (Internet)

www.epoxy.com (WWW)