

DURA-TOP™ EPOXY FLOOR COATING

K0540 Series, Part A

K05409005, Part B

Product Data Sheet

KRYLON

INDUSTRIAL
COATINGS™

DESCRIPTION

Dura-Top™ Epoxy Floor Coating is a self-leveling 100% solids, low odor, two component floor system that provides a high gloss, seamless, surface that is hard wearing and durable. Dura-Top™ Epoxy Floor Coating has good chemical resistance under spill/splash conditions. The coating can also be applied to provide a non-slip texture and may be topcoated if required.

ADVANTAGES

- Chemical resistant
- Impact resistant
- Abrasion resistant
- Economical
- Acceptable for use in federally inspected meat and poultry plants

RECOMMENDED USES

- Dura-Top™ Epoxy Floor Coating is especially suited for warehouses, workshops and light assembly areas.
- This product can be applied at thickness from 10.0 to 30.0 mls dft.
- When a urethane or additional epoxy topcoat is required

Caution: This is a two component system, **do not** use without a hardener.

SPECIFICATIONS

RECOMMENDED SYSTEMS

Concrete:

1 ct. Epoxy Primer/Sealer (K05101000) @ 8.0 mls dft
1 ct. Dura-Top™ Epoxy Floor Coating (K0540 Series)
@ 10.0 - 30.0 mls dft

Steel:

1 ct. Industrial Epoxy Primer (23500) @ 2.0 - 2.5 mls dft
1 ct. Dura-Top™ Epoxy Floor Coating (K0540 Series)
@ 10.0 - 30.0 mls dft

SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Poured Concrete (New): Surface must be clean, dry, sound, and offer sufficient profile to achieve adequate adhesion. Minimum substrate cure is 28 days at 75°F. Remove all form release agents, curing compounds, salts, efflorescence, laitance, and other foreign matter by sandblasting, shotblasting, mechanical scarification, or suitable chemical means, such as muriatic acid etch, refer to ASTM D4280. Rinse thoroughly to achieve a final pH between 6.0 and 10.0. Allow to dry thoroughly prior to coating.

SURFACE PREPARATION cont.

Poured Concrete (Old): Surface preparation is done in much the same manner as new concrete. However, if the concrete is contaminated with oils, grease, chemicals, etc., they must be removed by cleaning with a strong detergent or cleaner/degreaser such as Sprayon® Neutra Green®. Refer to ASTM D4258. Form release agents, hardeners, etc. must be removed by sandblasting, shotblasting, mechanical scarification, or suitable chemical means. If surface deterioration presents an unacceptably rough surface, patch and resurface damaged concrete.

Iron and Steel: Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mls). Prime any bare steel the same day as it is cleaned.

Previously Painted Surfaces: If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.

Note: Fill all cracks, voids and bugholes with Crack Filler (K05100004).

Always Follow the ASTM Methods Listed Below:

ASTM D4258 Standard Practice for Cleaning Concrete.
ASTM D4259 Standard Practice for Abrading Concrete.
ASTM D4260 Standard Practice for Etching Concrete.
ASTM D4263 Plastic Sheet Method for Checking Moisture in Concrete.

APPLICATION

APPLICATION CONDITIONS

Temperature: 55°F minimum, 95°F maximum (air, surface, and material). At least 5°F above dew point
Relative humidity: 85% maximum

APPLICATION EQUIPMENT

Reducer/Clean-up: Epoxy Reducer (K01661000) (clean-up only)

Methods: Roll, Trowel, Squeegee

Roller: 3/8" woven with phenolic core. Reduction: Not recommended

Trowel: Acceptable. Reduction: Not recommended

Squeegee: Acceptable. Reduction: Not recommended

Spike Roller: Required to help reduce pinholing

Note: If specific application equipment is listed above, equivalent equipment may be substituted.

APPLICATION cont.

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

To mix 1 gallon units: Use electric or air mixer (approximately 250 rpm) with metal mixing blade (Jiffy Model HS or equal).

Pre-mix both components for 1-2 minutes, then pour hardener contents into short-filled resin can. Mix for 2-3 minutes, moving blade around can while mixing. Avoid whipping in air while mixing. To mix 4 gallon units use same procedure as mixing 1 gallon units except a larger blade (Jiffy Model ES or equal) is required.

With material freshly mixed, pour out material on floor, spread to desired thickness with a 3/8" nap soft woven roller or equivalent. Check film thickness frequently. After 20-30 minutes set-up time, material should be rolled with a spike roller to remove any entrapped air. Do not spike roll after 40 minutes.

If a slip-resistant texture is desired, broadcast a clean, dry 30-50 mesh silica sand into the Epoxy Primer/Sealer (K05100100) coat immediately after application. Broadcast sand until the primer is saturated and only dry sand is showing. After the primer has set (6 hours minimum), sweep excess sand off the surface. Then topcoat with 15-20 mils of Dura-Top™ Epoxy Floor Coating (K0540 Series). Lower topcoat thickness will produce more pronounced slip-resistant profiles, heavier topcoats will produce smoother profiles. Spike rolling is not necessary when Dura-Top™ Epoxy Floor Coating (K0540 Series) is applied as a slip-resistant coating.

PERFORMANCE TIPS

- Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.
- No reduction of material is recommended as it can affect film build, appearance, and adhesion.
- Do not apply the material beyond recommended pot life.
- Do not mix previously catalyzed material with new.
- When coating previously painted surfaces, always apply a test patch and examine for lifting and proper intercoat adhesion. If lifting occurs, remove the old coating or apply an appropriate barrier coat.

CHARACTERISTICS

FINISH: Full Gloss

COLORS: Tile Red, Sandstone, Haze Gray, Deck Gray

VOLUME SOLIDS: 100%, mixed

VOC (Calculated): 0 g/L; 0.0 lb/gal, mixed

MIX RATIO: 2 components, premeasured 3.2 gal : .8 gal by volume

RECOMMENDED SPREADING RATE:

Wet mils: 10.0 - 30.0

Dry mils: 10.0 - 30.0

Coverage: 160 - 50 sq ft/gal approximate

DRYING SCHEDULE @ 50% RH @ 10.0 mils wet:

	@ 55°F	@ 77°F	@ 95°F
To touch:	36 hours	10 hours	7 hours
Foot traffic:		16 hours	
Heavy traffic:		96 hours	
To cure:		7 days	

Note: Drying time is temperature, humidity, and film thickness dependent. Abrade surface if recoating after 72 hours.

POT LIFE: 30 minutes @ 77°F, 50% RH

SWEAT-IN TIME: None required

SHELF LIFE: 12 months, unopened, at 60-80°F

FLASH POINT (Catalyzed): 200°F, PMCC

CLEAN-UP: Epoxy Reducer (K01661000) (clean-up only)

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings™ Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings™ Distributor.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, Krylon Products Group cannot make any warranties as to the end result. Please direct any questions or comments to 1-800-777-2966.