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# EPOXICOTE CORE
# 2-PART HIGH SOLIDS EPOXY

## DESCRIPTION AND USES

Watco® EpoxiCote Core is a two-component, high solids epoxy coating that provides a durable, abrasion and chemical resistant protective surface suitable for most all industrial environments. As Watco Floors' most versatile industrial product, it can be applied directly to concrete, sound rusted steel, galvanized metal, and clean steel. This product was developed with the end user in mind. It has a convenient 1:1 mix ratio, a pot life of a minimum of two hours, and has two activator options, Standard and Rapid. EpoxiCote Core is available with Standard and Anti-Slip activator of 340 VOC and Rapid activator of 250 VOC.

This coating complies with USDA FSIS regulatory sanitation performance standards for food establishment facilities. This coating is impervious to moisture and easily cleaned and sanitized.

Note: The Rapid Activator produces a semi-gloss finish. Also, using the Rapid Activator may result with a slight color shift when compared with products using the Standard Activator.

EpoxiCote Core can be used indoors or out. Epoxy coatings will yellow with age. This is most noticeable with interior applications of white or light colors which are not subjected to bleaching from sunlight. Exterior exposure over time will cause fading and chalking with all epoxy type coatings. These changes are cosmetic in nature only and film integrity and performance will not be adversely affected.

MPI #98 Certified. Refer to the MPI website for the most current listing of MPI certified products.

## PRODUCT FEATURES AND BENEFITS

- Extremely Versatile, Easy to Use, Durable, Solvent-Based Epoxy
- Direct-To-Metal and Self-Priming on a Variety of Substrates including concrete floors and walls
- Ultra-Smooth Finish with High Build Capability on Edges and Welds
- Superior Resistance to Solvents, Chemical, Abrasion and Impact
- Rapid Activator can be recoated in as little as 4 hours to minimize downtime

## PRODUCTS

**1-Gallon Kit SKUS**

| Standard Activator | Rapid Activator | Anti-Slip | Color |
|---|---|---|---|
| 403443 | 403463 | 403472 | Black |
| 403445 | 403464 | 403473 | Navy Gray |
| 403446 | 403465 | 403474 | Safety Blue |
| 403447 | 403466 | 403475 | Safety Green |
| 403458 | 403467 | 403476 | Safety Orange |
| 403459 | 403468 | 403477 | Safety Red |
| 403460 | 403469 | 403478 | Safety Yellow |
| 403461 | 403470 | 403479 | Silver Gray |
| 403462 | 403471 | 403480 | White |

## PRODUCT APPLICATION

### SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt, and chemical contaminants by washing the surface with Rust-Oleum® Professional Cleaner Degreaser. Mold and mildew must be cleaned with an appropriate cleaner. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

CONCRETE OR MASONRY: New concrete or masonry must cure 30 days before coating. Any concrete surface must be protected from moisture transmission from uncoated areas. Remove all loose, unsound concrete.

CONCRETE FLOORS: Remove laitance and create a surface profile by either acid etching with Watco Cemtetch Self-Etching Cleaner, or by grinding. Rinse thoroughly and allow to dry. The concrete must be fully dry prior to coating application. After etching, the concrete should have a texture, which resembles fine grit sandpaper. Repeat the process if necessary. Surface sealers and curing agents must be removed by grinding. Vacuum to remove fine dust and debris. The floor should be dry and dust free prior to application. Watco PowerFloat Primer is recommended for best performance over bare concrete. Previously coated floors need to be in good condition with proper adhesion to the concrete substrate.

PREVIOUSLY COATED: Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding or sweep blasting to create a surface profile. The EpoxiCote Core is compatible with most coatings, but a test patch is suggested.

**WARNING!** If you scrape, sand, or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-Approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove loose rust, scale, and deteriorated previous coatings to obtain a sound rusted surface. For optimum corrosion resistance, abrasive blast to commercial grade SSPCSP-6, with a blast profile of 1-2 mils (25-50 µ).

GALVANIZED METAL: Remove oil, dirt, grease, and other chemical deposits with Rust-Oleum Professional Cleaner Degreaser or other suitable cleaner. Remove loose rust, white rust or deteriorated old coatings by hand or power tool cleaning or brush off blasting. Rinse thoroughly with fresh water and allow to fully dry.

ALUMINUM: Power tool cleaning (SSPC-SP-11) to produce bare metal surface and achieve a minimum of 1.0 mil surface profile. Rinse thoroughly with fresh water and allow to fully dry.



Form: EJ-432
Rev.: 071626

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## PRODUCT APPLICATION (cont.)

### MIXING

Both the base and activator components are highly pigmented. Mix each component thoroughly to ensure any settled pigment is re-dispersed before combining the components together. Combine at a 1:1 ratio by volume in a container large enough to hold the total volume. Mix thoroughly for 2-3 minutes. Power mixing is preferred. Do not mix more material than you plan to use within the listed pot life. For Anti-Slip kits, combine and mix parts A and B as above, then add Aluminum Oxide 3 lb. bag and mix thoroughly.

### APPLICATION

Airless spray is the preferred method of application. However, brush, roller, or air-atomized spray may also be used. Anti-Slip kits must be rolled. Refer to table for thinning recommendations. For proper performance, a dry film thickness of 5-8 mils per coat is required. Excessive brushing or rolling may reduce film thickness. Apply a second coat if necessary to achieve the recommended film thickness.

Use the **Standard Activator or Rapid Activator** at air temperatures between **50-120°F (10-49°C)** and when the surface temperature is at least 5°F (3°C) above the dew point and less than 120ºF (49ºC). Low curing temperatures and/or condensation on the film while curing can affect appearance in the form of an amine blush. This can generally be removed with soap and water; however, in a case of extreme blushing, the performance of the coating may be slightly affected.

### EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable.)
**BRUSH**: Use a good quality natural or synthetic bristle brush.
**ROLLER:** Use a good quality roller cover (3/8- 1/2"nap).

### AIR–ATOMIZED SPRAY

| Method | Fluid Tip | Fluid Delivery | Atomized Pressure |
|---|---|---|---|
| Pressure | 0.055-0.070 | 10-16 oz./min. | 25-60 psi |
| Siphon | 0.055-0.070 | -- | 25-60 psi |
| HVLP | 0.043-0.070 | 8-10 oz./min. | 10 psi (at tip) |

### AIRLESS SPRAY

| Fluid Pressure | Fluid Tip | Filter Mesh |
|---|---|---|
| 1,800-3,000 psi | 0.013-0.017 | 100 |

**CAUTION:** Protect surrounding surfaces from over spray. Over spray can be wet or dry depending on height of work, weather, environmental conditions, and application equipment. Wet over spray can adhere to unwanted surfaces. Dry over spray may be removed by wiping or washing. Always clean dry over spray from hot surfaces before fusing occurs as surface temperatures can be higher than the air temperature.

### THINNING

Thinning is normally not required, except for air-atomized spray. For air-atomized spray application, thin only up to 10% by volume with Professional Solutions Xylene Solvent Blend after the components have been mixed.

**NOTE:** Addition of more than 10% of Professional Solutions Xylene Solvent Blend will cause VOC to exceed 340 g/l. In this case, Professional Solutions Acetone Thinner can be used if needed.

## PRODUCT APPLICATION (cont.)

### CLEAN-UP

Use Professional Solutions Xylene Solvent Blend or Water Immersion Reducer.

### SHELF LIFE

3 years[5]

[5] Unopened containers. Some settling may occur requiring mechanical mixing to redisperse pigment.

**CAUTION:** Exposure of the EpoxiCote Core during the curing stage of the coating to the by-products of propane combustion may cause discoloration to occur. During application and curing, propane fueled fork-lifts and other vehicles, or propane fueled heaters should not be used in the area until the coating is fully cured. At least 72 hours.

## PERFORMANCE CHARACTERISTICS

### SYSTEM TESTED
EpoxiCote Core with Standard Activator

### PENCIL HARDNESS
METHOD: ASTM D3363
RESULT: B (7 days), 4H (30 days)

### CONICAL FLEXIBILITY
METHOD: ASTM D522
RESULT: >32%

### CYCLIC PROHESION
**Rating 1-10, 10=best**
METHOD: ASTM D5894, 2300 hours
RESULT: 10 ASTM D714 for blistering
RESULT: 10 ASTM D1654 for corrosion

### IMPACT RESISTANCE (direct)
METHOD: ASTM D2794
RESULT:160 in. lbs.

### ALKALI RESISTANCE
METHOD: ASTM D1308
RESULT: No effect

### ADHESION BY TAPE TEST
METHOD: ASTM D3359B
SUBSTRATE and RESULT: Cold rolled steel (dry)-5B

### TABER ABRASION
METHOD: ASTM D4060, CS-17 wheels, 500 gram load, 1000 cycles
RESULT: 125 mg loss

### GLOSS
**METHOD:** ASTM D4587
**RESULT:** 80%

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## PHYSICAL PROPERTIES

| | | Standard Activator/Anti-Slip | | Rapid Activator. | |
|---|---|---|---|---|---|
| **Resin Type** | | Aliphatic Amine Converted Epoxy | | Polyamide/modified Amine Converted Epoxy | |
| **Inhibitive Pigment** | | Calcium Borosilicate | | Calcium Borosilicate | |
| **Weight**[6] | **Per Gallon** | 11.4-12.6 lbs. | | 12.1-13.2 lbs. | |
| | **Per Liter** | 1.4-1.5 kg | | 1.4-1.5 kg | |
| **Solids**[6] | **By Weight** | 86-89% | | 81.3-83.5% | |
| | **By Volume** | 78-81% | | 68.3-69.8% | |
| **Volatile Organic Compounds**[6] | | <340 g/l (2.84 lbs./gal.) | | <250 g/l (2.08 lbs./gal.) | |
| **Mixing Ratio** | | 1:1 Base:Act.(by vol.) | | 1:1 Base:Act. (by vol.) | |
| **Recommended Dry Film Thickness (DFT) Per Coat** | | 5-8 mils (125-200µ) | | 5-8 mils (125-200µ) | |
| **Wet Film to Achieve DFT (unthinned material)** | | 6.5-10.5 mils (162.5-262.5µ) | | 7.5-12.0 mils (187.5-300µ) | |
| **Theoretical Coverage at 1 mil DFT (25µ)** | | 1,250-1,300 sq.ft./gal. (30.8-32.0 $m^2$/l) | | 1,095-1,120 sq.ft./gal. (26.9-27.6 $m^2$/l) | |
| **Practical Coverage at Recommended DFT (assumes 15% material loss)** | | 125-225 sq.ft./gal. (3.1-5.5 $m^2$/l) | | 115-190 sq.ft./gal. (2.8-4.6 $m^2$/l) | |
| **Induction Period** | | None required | | 15 minutes | |
| **Pot Life**[7] | **2 gallons** | 2-4 hours at 70°F (21°C), | 2-4 hours at 70°F (15°C) | 2-4 hours at 70°F (21°C) | 1-2 hours at 90°F (32°C) |
| | **10 gallons** | 2 hours at 70°F (21°C) | 2 hours at 70°F (21°C) | 2 hours at 70°F (21°C) | <1 hour at 90°F (32°C) |
| **Dry Times at 50% Relative Humidity** | **Tack-free** | 6-8 hours at 70°F (21°C) | 4 hours at 70°F (21°C) | 4 hours at 70°F (21°C) | 8 hours at 50°F (10°C) |
| | **Handle** | 6-12 hours at 70°F (21°C) | 5 hours at 70°F (21°C) | 5 hours at 70°F (21°C) | 10 hours at 50°F (10°C) |
| | **Recoat** | 16 hours to 1 year[8] at 70°F (21°C) | 4 hours to 30 days[8] at 70°F (21°C) | 4 hours to 1 year[8] at 70°F (21°C) | 8 hours to 1 year[8] at 50°F (10°C) |
| **Dry Heat Resistance** | | 300°F (149°C), Color may shift above 150°F (66°C) | | | |
| **Shelf Life** | | Unopened containers; 3 years | | | |
| **Safety Information** | | See SDS | | | |

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