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## TECHNICAL DATA SHEET

### EPOXY 325™

A revolutionary, water based epoxy coating designed to repel chemicals and abrasions available in a clear or colored semi-gloss finish. Epoxy 325 is a water based, two component epoxy designed to prime and coat concrete floors combining the highest quality of cyclo-aliphatic epoxy components. The Epoxy 325 provides incredible abrasion resistance and chemical resistance. Recommended for indoor areas with high risks of exposure to chemical spills, fuel, heavy equipment and extreme temperatures. The Epoxy 325 is best used as a primer in conjunction with Urethane 645 as a top coat though it can also be used as a standalone product.

#### APPLICATIONS

Exceptional when used for:

- Applications: Garages, shop floors, warehouses
- Substrates: Concrete

Not for use on:

- For interior use only

#### BENEFITS

- Excellent hardness
- Excellent durability
- May be used as a topcoat or stand-alone product
- Stops dusting
- Protects from chemical spills
- Superior abrasion resistance
- UV Stable
- Will form an excellent bond to concrete
- Scratch resistant
- Excellent flexibility
- Available clear or colored

#### PREPARATION

Avoid contact with skin, eyes and clothing. Wash hands after use and do not take internally. Please refer to the product Safety Data Sheet (SDS) before using. The preparation process should be followed to ensure adequate penetration and optimum performance:

**Step 1:** The concrete substrate must be structurally sound, thoroughly dry and clean.

**Step 2:** Remove all paints, previous sealers and/or adhesives before application.

**Step 3:** The substrate must be clean of oil, grease, dirt, wax, curing compounds, efflorescence and other contaminants that might interfere with the penetration of the sealer.



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**Step 4:** For a one or two coat thin build system (3-10 mils dry) we recommend either mechanical scarification or acid etching until a suitable profile is achieved. For a complete system build higher than 10 mils dry, we recommend a fine brush blast (shot blast). If acid is used to clean the concrete, neutralize the surface completely and rinse it with water prior to application. Then wait for the concrete to dry out for at least 24-48 hours.

**Step 5:** The surface-zone moisture content of the concrete should not exceed 4%wt. A test should be made to determine that the concrete has an appropriate vapor barrier. This can be done by placing a 4'X4' plastic sheet on the substrate and taping down the edges. If after 24 hours, the substrate is still dry below the plastic sheet, then the substrate does not show signs of eventual hydrostatic pressure problems that may later cause disbanding.

**Step 6:** Cover all surrounding areas not intended to be coated.

**Step 7:** New concrete must be cured for at least 28 days before sealing.

### MIXING

This product comes pre-packaged by weight. Kits should be mixed in their entirety. Epoxy 325 A and Epoxy 325 B should be thoroughly mixed before combining. Scrape the bottom and sides of each container. Epoxy 325 A and Epoxy 325 B can then be combined (Epoxy 325 is sold as a pre-packaged kit and Epoxy 325 Part A should be mixed in its entirety with Epoxy 325 Part B). After the two parts are combined, mix well with slow speed mixing equipment such as a jiffy mixer until the material is thoroughly mixed and streak free. This product is an emulsion product and should be mixed well before using.

### APPLICATION

Test the sealer in an inconspicuous area to ensure the desired coverage and appearance is achieved. The mixed material can be applied by brush or roller. Workable time is about 1 hour. Maintain temperatures within the recommended ranges during the application and curing process. Apply material with relative humidity within the parameters. When the end of the pot life has been reached, you will find that the material becomes hard to apply and will actually tend to roll back up onto the roller. Do not try to continue application when the coating has reached this step. Applications made at different times with differing environmental conditions, may show slight variations in gloss. Coverage is approximately 200 sq. ft. per gallon. Make sure you test the surface for dryness prior to use and allow at least 8 hours before walking. A full cure will take up to 7 days to complete.

### RECOATING/TOPCOATING

If you opt to recoat or topcoat this product, you must first be sure that all of the solvents and water have evaporated from the coating during the curing process. However, it is best to test the coating before recoating or topcoating. This can be done by pressing on the coating with your thumb to verify that no fingerprint impression is left. If no impression is created, then the recoat or topcoat can be started. Always remember that colder temperatures will require more cure time for the product before recoating or topcoating can commence. Before recoating or topcoating, check the coating to insure no epoxy blushes were developed (a whitish, greasy film or deglossing). If a blush is present, it must be removed prior to topcoating or recoating. A standard type detergent cleaner can be used to remove any blush. Many epoxy overlays and coatings as well as urethanes are compatible for use as a topcoat for this product as well as multiple coats of this product.



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### APPLICATION NOTES:

- Restrict the use of the floor to light traffic and non-harsh chemicals until the coating is fully cured. It is best to let the floor remain dry for the full cure cycle. Dependent on actual complete system application, surface may be slippery, especially when wet or contaminated; keep surface clean and dry.
- Some cleaners may affect the color of the floor installed. Test each cleaner in a small area, utilizing your cleaning technique. If no ill effects are noted, you can continue to clean with the product and process tested.
- The clear is not water clear (it is an amber clear) and is not suitable for topcoating over previously color coated floors. The clear is suitable as a primer or concrete sealer only.
- Color or gloss may be affected by humidity, low temperatures, chemical exposure or sodium vapor lighting.
- Product will yellow in the presence of UV light.
- For best results use a 1/4" or 3/8" nap roller.
- Slab on grade requires moisture barrier.
- Substrate temperature must be 5°F above dew point.
- All new concrete must be cured for at least 28 days.
- Product color will vary from batch to batch. Use only product from the same batch for an entire job.
- Improper mixing or too thick of an application may result in product failure.
- Light or bright colors (white, etc.) may require multiple coats or a topcoat to achieve a satisfactory hide, depending on the substrate.
- For added chemical resistance, color stability or UV stability, topcoat with Urethane 645.

### TECHNICAL SPECS

- Feature: Durable Coating
- Chemistry: Cycloaliphatic Epoxy
- Color: Clear (amber), tile red, beige, medium gray, light gray, off white, white
- Finish: Semi-gloss
- Category: Coating
- Carrier: Water
- Availability: 2 component kit
- Packaging: 1 Gallon Kit, 2 Gallon Kit, 5 Gallon Kit
- Coverage: 200 sq. ft. per gallon
- Interior/Exterior: Interior
- Application Method: Roller/brush
- Application Temperature: 45 F - 90 F
- Number of Coats: 1
- New Concrete: Yes, at least 28 days after being poured
- Storage/Shelf Life: 1 Year
- Clean up: PM Solvent
- VOC Content: 175 g/L
- Film Thickness: 5-7 mils, (2-3 mils dry)
- Impact Resistance: 50 in/lb
- Abrasion Resistance: 54 mg



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- Adhesion: 425 psi
- Viscosity: 700 cps
- Primer: None

### CURE TIMES: (70F)

Pot Life – 1-gallon volume: 1 – 1.5 hours

Tack Free (dry to touch): 5-8 hours

Recoat or Topcoat: 7-10 hours

Light Foot Traffic: 16-24 hours

Full Cure (Heavy Traffic): 2-7 days

### CHEMICAL RESISTANCE

10% Sodium Hydroxide: Long Term Splash Spill

10% Sulfuric: Short Term Splash Spill

10% Hydrochloric Acid: Short Term Splash Spill

20% Nitric Acid: Not recommended

50% Sodium Hydroxide: Short Term Splash Spill

Acetic Acid 5%: Short Term Splash Spill

Ethylene Glycol: Long Term Immersion

Gasoline: Short Term Splash Spill

Mek: Not Recommended

Xylene: Short Term Splash Spill

### WARRANTY/LIMITATIONS OF LIABILITY

We warrant that our products are manufactured to strict quality assurance specifications and that the information supplied by us is accurate to the best of our knowledge. Such information supplied about our products is not a representation or a warranty. It is supplied on the condition that you shall make your own tests to determine the suitability of our product for your particular purpose. Any use or application other than recommended herein is the sole responsibility of the user. Listed physical properties are typical and should not be construed as specifications. No warranty is made, expressed or implied, regarding such other information, the data on which it is based, or the results you will obtain from its use. No warranty is made, expressed or implied, that our product shall be merchantable or that our product shall be fit for any particular purpose. No warranty is made that the use of such information or our product will not infringe upon any patent. We shall have no liability for incidental or consequential damages, direct or indirect. Our liability is limited to the net selling price of our product or the replacement of our product, at our option. Acceptance of delivery of our product means that you have accepted the terms of this warranty whether or not purchase orders or other documents state terms that vary from this warranty. No representative is authorized to make any representation or warranty or assume any other liability on our behalf with any sale of our products. Our products contain chemicals that may cause serious physical injury. Before using, read the Safety Data Sheet and follow all precautions to prevent bodily harm.