

AQUEPOXY 250

HIGH-PERFORMANCE WATERBORNE EPOXY COATINGS

DESCRIPTION:

AQUEPOXY 250 HD is a two-component, waterborne epoxy coating system designed for heavy commercial and industrial applications. Applications include both vertical and horizontal concrete surfaces, steel, galvanized metal, ceramic glazes, aged previously applied alkyd and epoxy enamels, asphalt, aluminum and plywood.

Two grades are available: **HD** (Immersion Grade) and **250-S30** (Sealer).

HD Immersion grade (Clear or Pigmented) may be used for surfaces subject to heavy traffic, prolonged or continuous submersion, and harsh chemical exposures. It is supplied in 3-gallon units at a 1:2 mixing ratio.

250-S30 Sealer grade (Clear) is supplied in 5-gallon units (1:4 mixing ratio), and is useful for a wide range of commercial and industrial applications.

AQUEPOXY 250 offers high gloss, hardness and chemical resistance, making it a truly practical alternative to solvent-borne epoxies in heavy commercial and industrial applications. Both the clear and white base formulations are USDA accepted for use on incidental food contact surfaces such as floors and machinery in Federally inspected meat and poultry packing plants.

FEATURES:

- Low odor and toxicity
- Low volatile organic content (VOC < 250)
- Cures despite high humidity, dampness
- Water clean-up
- No flash rusting on untreated steel
- No grain raising on wood surfaces
- No bleed through on asphalt surfaces
- Hardness, flexibility and solvent resistance
- Fast cure
- Non-flammable, Non-corrosive
- Non-carcinogenic

- D.O.T. Non-hazardous
- USDA accepted

CHARACTERISTICS:

PROPERTY	250-HD	250S-30
Mix Ratio	1:2 by volume	1:4 by volume
Pot Life	25-40 mins. at room temp.	1 hr. at room temperature
Solids Content	≈80% (Color) ≈66% (Clear)	30% by weight
Colors	Off-white, clear, custom colors	Clear
Packaging	Pre-measured 3-gal. unit	Pre-measured 5-gal. unit
Gloss	92 (60° specular gloss)	
VOC Content	Approx. 0.75 lb/gal. (87 g/l); Easily complies with 250 g/l limits.	

CHEMICAL RESISTANCE: (12 Weeks submersion at 73°F)

EXPOSURE	REACTION
Sea Water	No Effect
10% NaOH	No Effect
Xylene	No Effect
10% H ₂ SO ₄	Slight Blistering

Above data for Immersion grade **AQUEPOXY 250 HD**.

APPLICATION:

1. SURFACE PREPARATION:

Apply **AQUEPOXY 250** to clean, damp or dry substrates, free of grease, oil, dirt, or any other material which may hinder penetration. Remove any such contaminants by an

appropriate procedure such as abrasive or chemical cleaning. Chemical washing, if selected, should only be performed using cleaning agents which leave no residues or excess acid or alkali following final rinsing. For many applications, Edison **SYSTEM 21** cleaner/degreaser may be considered. Previous coatings should be tested for compatibility prior to large scale application.

2. COMPATIBILITY TESTING:

Clean a small, inconspicuous section of sound, existing coating and apply a small test patch. Allow to cure for at least 24 hours, and then cut a series of cross-cuts using a razor. Place a strip of cellophane tape across the cut intersection and rub down firmly for maximum adhesion. Quickly peel the tape back, at a sharp angle, and observe both the back of the tape and the coating. If any coating beyond that which was directly cut by the blade adheres to the tape or peels away from the substrate, adhesion is inadequate and more aggressive preparation is required, such as sanding, solvent-wiping or abrasive removal.

3. MIXING:

Pour the contents of Part A - Resin and Part B - Hardener into a clean mixing container and mix for at least three minutes using a slow speed drill mixer (250 rpm) and a flat paddle. Carefully scrape sides and bottom of container while mixing, and avoid whipping air into the mixture. In pigmented formulas, it may be necessary to agitate Part A prior to mixing, making certain that all pigments are dislodged from the container walls and bottom. Whenever possible, mix complete units. If necessary, partial units may be used, but it is essential that components be measured carefully and consistently. After mixing, allow the mixture to stand for several minutes and then re-stir.

4. APPLICATION:

Product may be applied to dry or damp surfaces, but not over saturated surfaces or standing water. On some

surfaces, product may spread and flow more evenly if slightly thinned using **Thinner #251** or a small quantity of water (no more than 6 ounces per gallon). Alternatively, porous surfaces may be dampened slightly with water to reduce suction.

Apply evenly and moderately at 100 - 200 sq. ft. per gallon, using brush, roller, or low-pressure airless spray. Do not attempt to re-work areas which have partially set. Any material which has not been applied within 1 hour of initial mixing should be set aside, allowed to harden, and then disposed of in accordance with local regulations.

Some applications will require only one coat. A second coat may be applied at any time after the first coat has cured to a "tack-free" state, preferably within 96 hours of first coat application. If re-coat is delayed beyond 96 hours, light sanding or solvent wiping may be required.

5. CURING:

CAUTION!: KEEP FROM FREEZING. Do not apply at temperatures below 45°F or when temperatures will drop below 45°F within 24 hours. Do not apply under extreme high humidity, such that condensation may form on uncured product. Product, substrate and air temperatures must all be considered when working at conditions close to these limits. At 75°F, product is ready for light traffic in 8-12 hours, moderate traffic in 18 -24 hours. Full cure is nominally 5-7 days. Do not submerge for at least 5 - 7 days.

HANDLING & SAFETY:

May cause eye injury, skin irritation, sensitization and allergic responses. Consult Material Safety Data Sheets supplied with this product for appropriate handling procedures and protective equipment.

Clean up oversprays and equipment immediately using hot water and mild detergent or **Thinner #251**.

FOR COMMERCIAL AND INDUSTRIAL USE.



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Rev. 6/2003

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