

# HIGH BUILD DECOUPAGE EPOXY

100% SOLIDS HIGH BUILD EPOXY - UP TO 1 INCH



High Build Epoxy is a 100% solids, two component, thick pour epoxy system. High Build Epoxy is designed to fill forms from 1/2" up to 1" deep and remain super clear. High Build Epoxy is an excellent choice over concrete and wood when a clear, thick pour epoxy is needed.

Specifications / Compliances • Meets OTC, CARB, LADCO & SCAQMD VOC restrictions.



## KEY FEATURES & TYPICAL BENEFITS

- Excellent for a variety of high build concrete and wood applications.
- Extended cure time allows air to escape to avoid bubbles trapped in the cured epoxy.
- Use this product for a variety of craft and specialty projects where a thick, clear epoxy is needed.
- VOC compliant for most areas in the United States and Canada.

## Typical Properties & Technical Information

PROPERTY	VALUE
Solids/Active Content, Percentage by weight	100%
Pot Life	N/A
Dry Time - Tack Free	2 - 4 days*
Dry Time - Foot Traffic	3 - 6 days*
Re-Coat Time Window	36 - 48 hours*
Application Temperature	50° F - 80° F
VOC (Volatile Organic Compound) Content	0 grams/Liter
Appearance - Dry	Clear and High Gloss

Information above is based on lab temperatures of 70° - 72°F at 50% RH. Using this product outside these conditions may affect the accuracy of the information above. Always test prior to use!

ALWAYS REFER TO SDS & READ FULL TECH DATA SHEET AND WARRANTY INFORMATION PRIOR TO USE.

## RECOMMENDED APPLICATIONS

- Tables
- Countertops
- Crafts
- Other applications where a high build, clear epoxy is needed.



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**SURFKOAT**<sup>™</sup>  
Surface Koatings, Inc.  
*Manufacturers of Industrial and Decorative Concrete Materials*

## **APPLICATION INSTRUCTIONS**

**HIGH BUILD EPOXY IS DESIGNED TO BE USED BETWEEN 1/2" INCH THICK AND CAN BE POURED UP TO 1 INCH THICK AND STILL MAINTAIN CLAIRITY. PLEASE NOTE THAT THIS PRODUCT TAKES A MINIMUM OF 2 DAYS TO CURE AND THE AREA SHOULD BE KEPT DUST FREE UNTIL CURED TO AVOID CONTAMINANTS. TEST PRIOR TO USE!**

**MOISTURE TESTING:** Concrete floors, especially those not poured over a proper vapor barrier (plastic), are subject to possible moisture vapor transmission which may result in bubbling and/or failure of high performance coatings. Basic moisture testing can be performed by placing a 4' x 4' sheet of plastic on the concrete surface and securely taping it down on all edges. If after 24 hours the concrete is still dry below the plastic, the surface should be ready to coat. If moisture is present, the coating applicator should perform calcium chloride and relative humidity probe testing to determine if excessive levels of vapor emissions are present before applying any coatings.

**SURFACE PREPARATION:** The concrete surface must be deemed mechanically and structurally sound, thoroughly clean of debris and completely dry. Concrete must be fully cured a minimum of 28 days. It is recommended to prepare the concrete surface by mechanical means such as shot blasting or diamond grinding with 30 grit or coarser diamonds to achieve a CSP-2 to CSP-3 profile. If using in a thin mil system such as acid stain, dye & seal, 2 or less clear coats, etc., an 80 grit diamond may be acceptable to minimize visual scratches in the finish. Vacuum concrete surface several times until dust thoroughly removed. If applying over an existing, fully bonded coating that is outside its recommended recoat window, the surface should be sanded thoroughly with a 60-120 grit sanding screen until the surface is completely dulled with scratches. Vacuum dust thoroughly, rinse with clean water and remove excess water with a wet/dry vacuum or floor scrubber. Allow surface to dry completely prior to application of coating. Where applicable and with adequate ventilation, wipe the surface with acetone and a microfiber dust mop. **CAUTION:** Acetone is extremely flammable! If using acetone follow all safety precautions, make sure no pilot lights, open flames, sources of static electricity, sparks or extreme heat sources are present. Use recommended personal protection for acetone. If applying to wood or other surfaces, the surface must be clean, dry and free of any debris. The surface must also be porous enough to accept a coating.

*Please note that higher substrate, air and material temperatures as well as excessive humidity may speed the cure rate of this product. Cooler temperatures and lower humidity may extend the cure rate of this product.*

**PRIMING:** If necessary, prime concrete surfaces with 1040 Bond Koat to improve adhesion and reduce air bubbles. Refer to the 1040 Bond Koat technical data sheet for application information. For wood surfaces, brush or roll on a light coat of epoxy to seal off the surface to reduce air bubbles.

**COVERAGE:** Figure the cubic inches by measuring LENGTH x WIDTH x DEPTH. Every cubic inch needs 0.554113 fluid oz. of epoxy. (Example: 12" x 12" x 1" = 144 cubic inches | 144 x 0.554113 = 80 oz.) ALWAYS have a extra material on hand to account for settling that may occur.

**FOR PERSONAL PROTECTION USE GLOVES, GOGGLES, RESPIRATOR AND OTHER NECESSARY PPE. REFER TO SDS PRIOR TO USE!**

**PRODUCT MIXING:** If mixing less than a full kit, mix Part A & Part B separately with a stir stick prior to blending the smaller kit to ensure uniform distribution of all ingredients. Pour a full pre-packaged kit of 2 parts of Part A to 1 part of Part B together and mix well with slow speed paint paddle for **5 minutes** or until the material is thoroughly mixed and homogenous. Make sure to thoroughly scrape the sides and bottom to ensure distribution of all ingredients. It is not recommend to mix with a drill mixer to avoid whipping air into the coating. Improper mixing may result in product failure and/or air bubbles. **DO NOT THIN!**

**PRODUCT APPLICATION:** Ensure that the form, mold, etc. that the epoxy will be poured into is sealed thoroughly to avoid leaks, loss of material and air bubbles. Slowly pour the mixed material into the form. Allow the material to fill all voids well. Spread with a flat flexible squeegee, notched squeegee or other tools if necessary. Using a small stir stick to slowly run through the material and pushing it into voids where air may be trapped will help to emanate late air bubbles and settling of the material. Using a heat gun or propane torch to pop air bubbles will improve clarity and help eliminate surface bubbles.

*\*Please note that this product cures faster in higher volumes. Lower volume pours may take longer than expected to fully cure. Always test prior to use.*

**RE-COAT / TOP COAT:** For surfaces with no foot traffic, allow the epoxy to cure to a point when a finger print cannot be left on the surface then apply another coat immediately. For surfaces with foot traffic, allow the epoxy to cure thoroughly. Screen the surface with a 40 - 60 grit sanding screen for another coat of epoxy. For urethane and other thin mil coatings, screen with a 80 - 100 grit sanding screen. Sweep, vacuum and solvent wipe the surface thoroughly to ensure all screening dust is removed.

**PLEASE NOTE:** Applying this product in high temperatures and high volumes may cause it to cure faster causing air bubbles, ambering, wavy finish, etc.. It is recommended to be used at 70°F with 50% RH. Coverage rates may vary for all coatings and substrates depending on porosity, density, texture etc. Coating may darken surface. Coating may cause surface to be slippery when wet.

**COF WARNING:** OSHA and the American Disabilities Act (ADA) have now set enforceable standards for slip-resistance on pedestrian surfaces. The current coefficient of friction required by ADA is .6 on level surfaces and .8 on ramps. Surface Koatings, Inc. recommends the use of slip-resistant aggregate in all coatings or flooring systems that may be exposed to wet, oily or greasy conditions. It is the contractor and end users' responsibility to provide a flooring system that meets current safety standards. Surface Koatings, Inc. nor its sales agents will be responsible for injury incurred in a slip and fall accident. For interior floors subjected only to foot traffic, Cherry Surf-Wax may be used as an acceptable slip-resistant coating as it meets requirements for ASTM D2047.

## **PRECAUTIONS AND LIMITATIONS**

- This product will freeze during storage. Store at temperatures above 40°F.
- All HVAC ventilation ducts should be somehow blocked prior to application so solvent fumes are not distributed.
- If using indoor, use proper ventilation while applying and for hours after application to ensure fumes are removed.
- It is not recommended to apply product over carpet, tile, or other types of floor adhesives.
- This product performs best when applied as one or two medium-light coats, not one heavy coat.
- Please be aware that this product when cured may be slippery when wet. An anti-slip additive, such as Surf-Grip, can be added to reduce slip hazards.
- All new concrete must be cured for at least 28 days prior to application.
- It is not recommended to thin product. Improper thinning may cause coating to delaminate in a short time frame and other performance issues.
- This product may darken the surface of many new and existing concrete slabs. Test prior to use.
- Physical properties listed on this technical data sheet are typical values not specifications.
- This product, specifically Part B, is corrosive. Wear proper safety equipment while handling material.
- This product is not UV stable and should not be used outdoors or in areas exposed to excessive sunlight.
- Keep area dust free until the epoxy is fully cured.
- If using with solvent, DO NOT use heat gun or torch to reduce air.

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**CLEAN-UP:** Use MEK. Dispose of containers in accordance with local, state and federal regulations.

**PRODUCT REMOVAL:** Dried, cured coating may be removed with a commercial epoxy stripper or by using a diamond grinding method, sandblasting method or similar mechanical action.

**SHELF LIFE:** Up to one year from manufacture date in its original, unopened container stored at room temperature.

**PACKAGING:** Available in 3 quart, 1.5 and 3 gallon kits.

Always read all technical information, label and SDS prior to use. This information can be found online or by calling customer service at the number below.

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Surface Koatings, Inc. warrants our products to be of good quality, free of defects and will conform with our published specifications in force on the date of acceptance of the order. As the exclusive remedy for breach of this warranty, we will replace defective materials. Ninety days after Surface Koatings, Inc. has shipped the products, all our warranty and other duties with respect to the quality of the materials delivered shall conclusively be presumed to have been satisfied, all liability therefore terminates, and no action for breach of any said duties may thereafter be commenced. No warranty is expressed or implied as to the length of life of this product, or merchantability or fitness. Liability, if any, is limited to the purchase price of the material. Under no circumstances will Surface Koatings, Inc. be liable for a consequential damage to anyone in excess of the purchase price of the products.